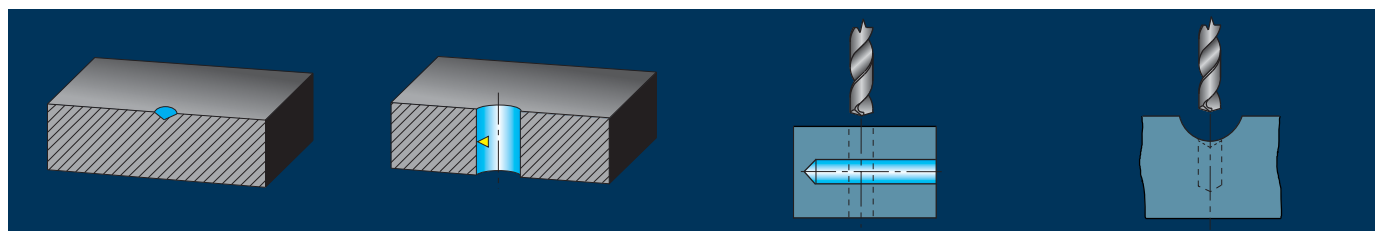


				ART.	LUNGHEZZA ELICA LENGTH FLUTES	ØD	Z	MATERIALE MATERIAL	Materiali - Materials Pag. H 73							Pag.							
																P	M	K	N	S	H	G	
MICROPUNTE - MICRO-DRILLS																							
		TIALN		SDM0301	3xD	0,4-2,9	2	MG	●	●	●	●	○	○	○	C 8							
	NEW			SDMN0301	3xD	0,4-2,9	2	MG	●	○	●	●			○	C 10							
		TIALN		SDM0501	5xD	0,7-2,9	2	MG	●	●	●	●	○	○	○	C 12							
	NEW			SDMN0501	5xD	0,7-2,9	2	MG	●	○	●	●			○	C 14							
		TIALN		SDM0310	3xD	0,5-2,9	2	MG	●	●	●	●	○	○	○	C 16							
	NEW			SDMN0310	3xD	0,5-2,9	2	MG	●	○	●	●			○	C 18							
		TIALN		SDM0510	5xD	0,5-2,9	2	MG	●	●	●	●	○	○	○	C 20							
	NEW			SDMN0510	5xD	0,5-2,9	2	MG	●	○	●	●			○	C 22							
PUNTE INTEGRALI IN HM - SOLID CARBIDE DRILLS																							
		TIALN		SDR0341	3xD	3-12	2	MG	●		○	○			○	C 26							
	NEW	TIALN		SDR0302	3xD	3-20	2	MG	●	○	●				○	C 28							
	NEW	TIALN		SDF0302	3xD	3-20	2	MG	●	●	●		○		○	C 30							
	NEW	TIALN		SDF0371	3xD	2-12	2	MG	●	●	●					C 32							
	NEW	TIALN		SDR0502	5xD	3-20	2	MG	●	○	○				○	C 34							
	NEW	TIALN		SDF0502	5xD	3-20	2	MG	●	○	○		○		○	C 36							
		TIALN		SDF0551	5xD	3-16	2	MG	○	●	○		○		○	C 38							
		TIALN SILVER		SDF0511	5xD	3-20	2	MG	○	○		●	●		○	C 40							
		TIALN		SDF0505	5xD	3-16	2	MG	○		●				○	C 42							
	NEW	TIALN		SDF0802	8xD	3-16	2	MG	●	●	●				○	C 44							
		TIALN		SDF1201	12xD	3-16	2	MG	●	●	●				○	C 46							
		TIALN		SDF1601	16xD	3-12	2	MG	●	●	●				○	C 48							
		TIALN		SDF2001	20xD	2-12	2	MG	●	●	●				○	C 50							
		TIALN		SDF3001	30xD	2-12	2	MG	●	●	●				○	C 52							



			ART.	ANGOLO ELICA ANGLE FLUTES	ØD	Z	MATERIALE MATERIAL	Materiali - Materials Pag. H 73							Pag.
								P	M	K	N	S	H	G	
PUNTE A GRADINO - STEP DRILLS															
NEW	TIALN		SDN0102	30°	3,4-11	2	MG	●		●					C 56
	TIALN		SDR0102	30°	2,5-14	2	MG	●		●					C 58
PUNTE A CENTRARE - CENTER DRILLS															
	TIALN		SCR0184	30°	3-20	2	MG	●	○	●	○				C 62
	TIALN		SCR0185	30°	6-20	2	MG	●	○	●	○				C 64
	TIALN		SCR0186	30°	6-20	2	MG	●	○	●	○				C 66
PUNTE FORALESA - REAMER-DRILLS															
NEW	TIALN		SPFAR3	30°	2,97-20,02	2	MG	●		●					C 70
NEW	TIALN		SPFAR5	30°	2,97-20,02	2	MG	●		●					C 72
ALESATORI - REAMERS															
			SAN0508	6°	4-18	4/6	MG	●	●	●	●				C 76
			SAN0509	6°	3,8-18,2	4/6	MG	●	●	●	●				C 78
			SAN0708	6°	1-18,2	4/6	MG	●	●	●	●				C 80
			SAN0709	6°	1-18,2	4/6	MG	●	●	●	●				C 82
			SAN0808	6°	1,5-12,2	4/6	MG	●	●	●	●				C 84
			SAN0809	6°	2-12,2	4/6	MG	●	●	●	●				C 86

SIMBOLOGIA - SYMBOL - SYMBOLE - SYMBOLES

RIVESTIMENTI - COATED - BESCHICHTUNG - RECOUVREMENT

RIVESTIM. COATED TIALN	TIALN: Elevata durezza e resistenza al calore, basso coefficiente di attrito, si può usare con refrigerante oppure a secco con aria. TIALN: High degree of hardness and heat resistance, low friction coefficient; it can be used with coolant or with air and no coolant	RIVESTIM. COATED TIALN SILVER	TIALN SILVER: Elevata resistenza all'usura, migliore finitura, basso coefficiente di attrito, elevata tenacità ed aderenza al substrato TIALN SILVER: High resistance to wear, better finishing, low friction coefficient, high degree of toughness and substratum adhesion
---	--	--	--

AFFILATURA TESTA - HEAD SHARPENING - KOPFSCHLIFF - AFFUTAGE TETE

 - Autocentrante - Tipo S - Self centering - S Type - Selbstzentrierend - Type S - A centrage automatique - Type S	 - Autocentrante - refrigerata - Tipo S - Self centering - with coolant - S Type - Selbstzentrierend - gekühlt - Type S - A centrage automatique-refrigere - Type S	 - Autocentrante - Tipo 4F - Self centering - 4F Type - Selbstzentrierend - Type 4F - A centrage automatique - Type 4F
 - Autocentrante - refrigerata - Tipo 4F - Self centering - with coolant - 4F Type - Selbstzentrierend - gekühlt - Type 4F - A centrage automatique-refrigere - Type 4F	 - Doppio pattino - Tipo 4F - Double ski drills - 4F Type - Doppel-Ski-Bohrer - Type 4F - Double de ski perceuses - Type 4F	 - Doppio pattino - refrigerata - Tipo 4F - Double ski drills - with coolant - 4F Type - Doppel-Ski-Bohrer - gekühlt - Type 4F - Double de ski perceuses - refrigere - Type 4F
 - Punta a centrare - Center drills - Zentrierbohrer - Pointes a centrer	 - Punta Foralesa - Reamer-Drills - Reibahlen-Bohrer - Forets de perçage et alésage	

ANGOLO ELICA - FLUTES DEGREES - SPIRALWINKEL - ANGLE HELICE

 30°	 38°	 6°
--	--	---

ANGOLO DI TESTA - HEAD ANGLE - KOPFKEGELWINKEL - ANGLE DE TETE

 90°	 118°	 120°
 135°	 140°	 142°
 145°		

NORME - STANDARDS - NORMEN - NORMES

DIN 338 DIN 338	DIN 1897 DIN 1897	DIN 6535 DIN 6535
DIN 6537 DIN 6537	DIN 6539 DIN 6539	

LUNGHEZZA PUNTA - DRILL LENGHT - BOHRERLÄNGE - LONGUEUR POINTE

3xD - 3 volte il diametro - Three times the diameter - Dreimal den durchmesser - 3 fois le diametre	5xD - 5 volte il diametro - Five times the diameter - Fünfmal den durchmesser - 5 fois le diametre	8xD - 8 volte il diametro - Eight times the diameter - Achtmal den durchmesser - 8 fois le diametre	12xD - 12 volte il diametro - Twelve times the diameter - Zwölfmal den durchmesser - 12 fois le diametre
16xD - 16 volte il diametro - Sixteen times the diameter - Sechzehnmal den durchmesser - 16 fois le diametre	20xD - 20 volte il diametro - Twenty times the diameter - Zwanzigmal den durchmesser - 20 fois le diametre	30xD - 30 volte il diametro - Thirty times the diameter - Dreißigmal den durchmesser - 30 fois le diametre	

SIMBOLI GENERALI - GENERAL SYMBOLS - ALLGEMEINE SYMBOLE - SYMBOLES GÉNÉRAUX

 - Punta autocentrante - Self-centering drill - Selbstzentrierender bohrer - Pointe a centrage automatique	MG - Micrograno 0,7 µm (K 20) - Micrograin 0,7 µm (K 20) - Feinstkorn 0,7 µm (K 20) - Microgreno 0,7 µm (K 20)
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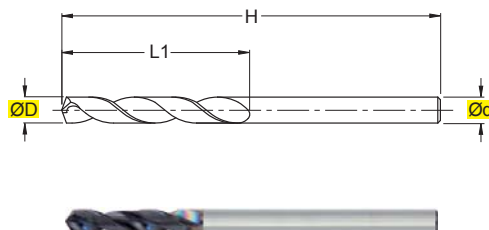


MICROPUNTE

MICRO-DRILLS / MIKROBOHRER / MICRO-FORETS / MICROBROCAS

SDM0301

$\varnothing D = 0,4 - 2,9$

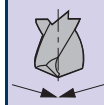
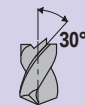


TOLLERANZE
 TOLERANCE RANGE

D	d
h7	h7

RIVESTIM.
 COATED
TIALN

3xD

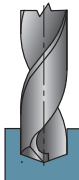


DIN
 6539



MG

(mm)				
ART.	$\varnothing D$	$\varnothing d$	H	L1
SDM0301004	0,4	0,4	26	6
SDM0301005	0,5	0,5	26	6
SDM0301006	0,6	0,6	26	6
SDM0301007	0,7	0,7	26	6
SDM0301008	0,8	0,8	26	6
SDM0301009	0,9	0,9	26	6
SDM0301010	1,0	1,0	26	6
SDM0301011	1,1	1,1	28	7
SDM0301012	1,2	1,2	30	8
SDM0301013	1,3	1,3	30	8
SDM0301014	1,4	1,4	32	9
SDM0301015	1,5	1,5	32	9
SDM0301016	1,6	1,6	34	10
SDM0301017	1,7	1,7	34	10
SDM0301018	1,8	1,8	36	11
SDM0301019	1,9	1,9	36	11
SDM0301020	2,0	2,0	38	12
SDM0301021	2,1	2,1	38	12
SDM0301022	2,2	2,2	40	13
SDM0301023	2,3	2,3	40	13
SDM0301024	2,4	2,4	43	14
SDM0301025	2,5	2,5	43	14
SDM0301026	2,6	2,6	43	14
SDM0301027	2,7	2,7	46	16
SDM0301028	2,8	2,8	46	16
SDM0301029	2,9	2,9	46	16

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73					
		P					M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
		●															0,4÷0,8	50	0,07	-	-	
		●																0,8÷1,2	50	0,07	-	-
		●																1,2÷1,6	50	0,10	-	-
		●																1,6÷2,0	50	0,10	-	-
		●																2,0÷2,4	50	0,12	-	-
		●																2,4÷2,9	50	0,14	-	-
				●														0,4÷0,8	40	0,07	-	-
				●														0,8÷1,2	40	0,07	-	-
				●														1,2÷1,6	40	0,10	-	-
				●														1,6÷2,0	40	0,10	-	-
				●														2,0÷2,4	40	0,12	-	-
				●														2,4÷2,9	40	0,14	-	-
					●													0,4÷0,8	30	0,04	-	-
					●													0,8÷1,2	30	0,04	-	-
					●													1,2÷1,6	30	0,06	-	-
					●													1,6÷2,0	30	0,06	-	-
					●													2,0÷2,4	30	0,07	-	-
					●													2,4÷2,9	30	0,08	-	-
						●												0,4÷0,8	65	0,07	-	-
						●												0,8÷1,2	65	0,07	-	-
						●												1,2÷1,6	65	0,10	-	-
						●												1,6÷2,0	65	0,10	-	-
						●												2,0÷2,4	65	0,12	-	-
						●												2,4÷2,9	65	0,14	-	-
							●											0,4÷0,8	115	0,07	-	-
							●											0,8÷1,2	115	0,07	-	-
							●											1,2÷1,6	115	0,10	-	-
							●											1,6÷2,0	115	0,10	-	-
							●											2,0÷2,4	115	0,12	-	-
							●											2,4÷2,9	115	0,14	-	-
													○					0,4÷0,8	15	0,03	-	-
													○					0,8÷1,2	15	0,03	-	-
													○					1,2÷1,6	15	0,04	-	-
													○					1,6÷2,0	15	0,04	-	-
													○					2,0÷2,4	15	0,05	-	-
													○					2,4÷2,9	15	0,06	-	-
														○				0,4÷0,8	15	0,025	-	-
														○				0,8÷1,2	15	0,025	-	-
														○				1,2÷1,6	15	0,025	-	-
														○				1,6÷2,0	15	0,025	-	-
														○				2,0÷2,4	15	0,035	-	-
														○				2,4÷2,9	15	0,035	-	-
															○			0,4÷0,8	15	0,015	-	-
															○			0,8÷1,2	15	0,015	-	-
															○			1,2÷1,6	15	0,015	-	-
															○			1,6÷2,0	15	0,015	-	-
															○			2,0÷2,4	15	0,025	-	-
															○			2,4÷2,9	15	0,025	-	-

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

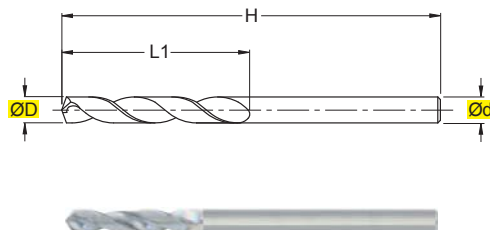
$$n = \frac{Vc \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

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

SDMN0301

ØD = 0,4 - 2,9

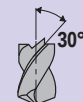
NEW



TOLLERANZE
TOLERANCE RANGE

D	d
h7	h7

3xD

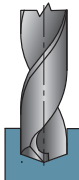


DIN
6539



MG

(mm)				
ART.	ØD	Ød	H	L1
SDMN0301004	0,4	0,4	26	6
SDMN0301005	0,5	0,5	26	6
SDMN0301006	0,6	0,6	26	6
SDMN0301007	0,7	0,7	26	6
SDMN0301008	0,8	0,8	26	6
SDMN0301009	0,9	0,9	26	6
SDMN0301010	1,0	1,0	26	6
SDMN0301011	1,1	1,1	28	7
SDMN0301012	1,2	1,2	30	8
SDMN0301013	1,3	1,3	30	8
SDMN0301014	1,4	1,4	32	9
SDMN0301015	1,5	1,5	32	9
SDMN0301016	1,6	1,6	34	10
SDMN0301017	1,7	1,7	34	10
SDMN0301018	1,8	1,8	36	11
SDMN0301019	1,9	1,9	36	11
SDMN0301020	2,0	2,0	38	12
SDMN0301021	2,1	2,1	38	12
SDMN0301022	2,2	2,2	40	13
SDMN0301023	2,3	2,3	40	13
SDMN0301024	2,4	2,4	43	14
SDMN0301025	2,5	2,5	43	14
SDMN0301026	2,6	2,6	43	14
SDMN0301027	2,7	2,7	46	16
SDMN0301028	2,8	2,8	46	16
SDMN0301029	2,9	2,9	46	16

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																		
		P				M	K			N		S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n
	●															0,4÷0,8	40	0,04	-	-
	●															0,8÷1,2	40	0,04	-	-
	●															1,2÷1,6	40	0,06	-	-
	●															1,6÷2,0	40	0,06	-	-
	●															2,0÷2,4	40	0,08	-	-
	●															2,4÷2,9	40	0,08	-	-
			●													0,4÷0,8	30	0,04	-	-
			●													0,8÷1,2	30	0,04	-	-
			●													1,2÷1,6	30	0,06	-	-
			●													1,6÷2,0	30	0,06	-	-
			●													2,0÷2,4	30	0,08	-	-
			●													2,4÷2,9	30	0,08	-	-
					○											0,4÷0,8	20	0,03	-	-
					○											0,8÷1,2	20	0,03	-	-
					○											1,2÷1,6	20	0,04	-	-
					○											1,6÷2,0	20	0,04	-	-
					○											2,0÷2,4	20	0,05	-	-
					○											2,4÷2,9	20	0,05	-	-
							●									0,4÷0,8	50	0,03	-	-
							●									0,8÷1,2	50	0,03	-	-
							●									1,2÷1,6	50	0,04	-	-
							●									1,6÷2,0	50	0,04	-	-
							●									2,0÷2,4	50	0,05	-	-
							●									2,4÷2,9	50	0,05	-	-
									●							0,4÷0,8	80	0,04	-	-
									●							0,8÷1,2	80	0,04	-	-
									●							1,2÷1,6	80	0,06	-	-
								●							1,6÷2,0	80	0,06	-	-	
								●							2,0÷2,4	80	0,08	-	-	
								●							2,4÷2,9	80	0,08	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

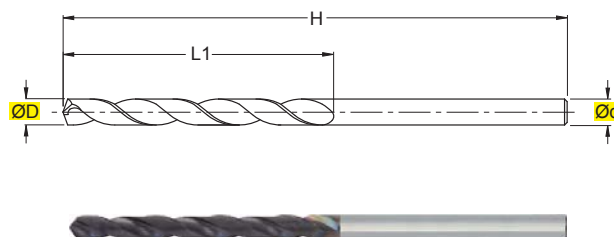
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SDM0501

$\varnothing D = 0,7 - 2,9$

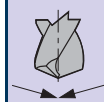
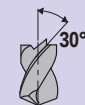


TOLLERANZE
TOLERANCE RANGE

D	d
h7	h7

RIVESTIM.
COATED
TIALN

5xD



DIN
338



MG

(mm)				
ART.	ØD	Ød	H	L1
SDM0501007	0,7	0,7	28	9
SDM0501008	0,8	0,8	30	10
SDM0501009	0,9	0,9	32	11
SDM0501010	1,0	1,0	34	12
SDM0501011	1,1	1,1	36	14
SDM0501012	1,2	1,2	38	16
SDM0501013	1,3	1,3	38	16
SDM0501014	1,4	1,4	40	18
SDM0501015	1,5	1,5	40	18
SDM0501016	1,6	1,6	43	20
SDM0501017	1,7	1,7	43	20
SDM0501018	1,8	1,8	46	22
SDM0501019	1,9	1,9	46	22
SDM0501020	2,0	2,0	49	24
SDM0501021	2,1	2,1	49	24
SDM0501022	2,2	2,2	53	27
SDM0501023	2,3	2,3	53	27
SDM0501024	2,4	2,4	57	30
SDM0501025	2,5	2,5	57	30
SDM0501026	2,6	2,6	57	30
SDM0501027	2,7	2,7	61	33
SDM0501028	2,8	2,8	61	33
SDM0501029	2,9	2,9	61	33

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73				
		P					M	K			N			S	H	G					
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●															0,4÷0,8	50	0,07	-	-	
	●															0,8÷1,2	50	0,07	-	-	
	●															1,2÷1,6	50	0,10	-	-	
	●															1,6÷2,0	50	0,10	-	-	
	●															2,0÷2,4	50	0,12	-	-	
	●															2,4÷2,9	50	0,14	-	-	
			●													0,4÷0,8	40	0,07	-	-	
			●													0,8÷1,2	40	0,07	-	-	
			●													1,2÷1,6	40	0,10	-	-	
			●													1,6÷2,0	40	0,10	-	-	
			●													2,0÷2,4	40	0,12	-	-	
			●													2,4÷2,9	40	0,14	-	-	
					●											0,4÷0,8	30	0,04	-	-	
					●											0,8÷1,2	30	0,04	-	-	
					●											1,2÷1,6	30	0,06	-	-	
					●											1,6÷2,0	30	0,06	-	-	
					●											2,0÷2,4	30	0,07	-	-	
					●											2,4÷2,9	30	0,08	-	-	
							●									0,4÷0,8	65	0,07	-	-	
							●									0,8÷1,2	65	0,07	-	-	
							●									1,2÷1,6	65	0,10	-	-	
							●									1,6÷2,0	65	0,10	-	-	
							●									2,0÷2,4	65	0,12	-	-	
							●									2,4÷2,9	65	0,14	-	-	
									●							0,4÷0,8	115	0,07	-	-	
									●							0,8÷1,2	115	0,07	-	-	
									●							1,2÷1,6	115	0,10	-	-	
									●							1,6÷2,0	115	0,10	-	-	
									●							2,0÷2,4	115	0,12	-	-	
									●							2,4÷2,9	115	0,14	-	-	
													○			0,4÷0,8	15	0,03	-	-	
													○			0,8÷1,2	15	0,03	-	-	
													○			1,2÷1,6	15	0,04	-	-	
													○			1,6÷2,0	15	0,04	-	-	
													○			2,0÷2,4	15	0,05	-	-	
													○			2,4÷2,9	15	0,06	-	-	
														○		0,4÷0,8	15	0,025	-	-	
														○		0,8÷1,2	15	0,025	-	-	
														○		1,2÷1,6	15	0,025	-	-	
														○		1,6÷2,0	15	0,025	-	-	
														○		2,0÷2,4	15	0,035	-	-	
														○		2,4÷2,9	15	0,035	-	-	
															○	0,4÷0,8	15	0,015	-	-	
															○	0,8÷1,2	15	0,015	-	-	
															○	1,2÷1,6	15	0,015	-	-	
															○	1,6÷2,0	15	0,015	-	-	
															○	2,0÷2,4	15	0,025	-	-	
															○	2,4÷2,9	15	0,025	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

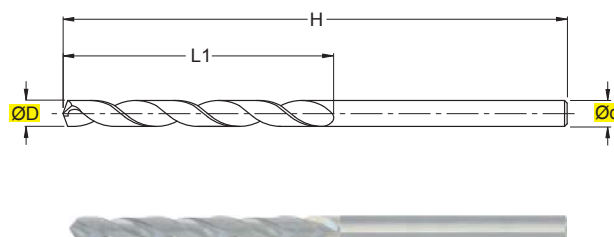
$$n = \frac{Vc \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

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

SDMN0501

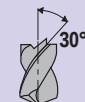
ØD = 0,7 - 2,9

NEW



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h7

5xD



DIN
338



MG

ART.	ØD	Ød	H	L1
SDMN0501007	0,7	0,7	28	9
SDMN0501008	0,8	0,8	30	10
SDMN0501009	0,9	0,9	32	11
SDMN0501010	1,0	1,0	34	12
SDMN0501011	1,1	1,1	36	14
SDMN0501012	1,2	1,2	38	16
SDMN0501013	1,3	1,3	38	16
SDMN0501014	1,4	1,4	40	18
SDMN0501015	1,5	1,5	40	18
SDMN0501016	1,6	1,6	43	20
SDMN0501017	1,7	1,7	43	20
SDMN0501018	1,8	1,8	46	22
SDMN0501019	1,9	1,9	46	22
SDMN0501020	2,0	2,0	49	24
SDMN0501021	2,1	2,1	49	24
SDMN0501022	2,2	2,2	53	27
SDMN0501023	2,3	2,3	53	27
SDMN0501024	2,4	2,4	57	30
SDMN0501025	2,5	2,5	57	30
SDMN0501026	2,6	2,6	57	30
SDMN0501027	2,7	2,7	61	33
SDMN0501028	2,8	2,8	61	33
SDMN0501029	2,9	2,9	61	33

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N		S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●															0,4÷0,8	40	0,04	–	–	
	●															0,8÷1,2	40	0,04	–	–	
	●															1,2÷1,6	40	0,06	–	–	
	●															1,6÷2,0	40	0,06	–	–	
	●															2,0÷2,4	40	0,08	–	–	
	●															2,4÷2,9	40	0,08	–	–	
			●													0,4÷0,8	30	0,04	–	–	
			●													0,8÷1,2	30	0,04	–	–	
			●													1,2÷1,6	30	0,06	–	–	
			●													1,6÷2,0	30	0,06	–	–	
			●													2,0÷2,4	30	0,08	–	–	
			●													2,4÷2,9	30	0,08	–	–	
					○											0,4÷0,8	20	0,03	–	–	
					○											0,8÷1,2	20	0,03	–	–	
					○											1,2÷1,6	20	0,04	–	–	
					○											1,6÷2,0	20	0,04	–	–	
					○											2,0÷2,4	20	0,05	–	–	
					○											2,4÷2,9	20	0,05	–	–	
							●									0,4÷0,8	50	0,03	–	–	
							●									0,8÷1,2	50	0,03	–	–	
							●									1,2÷1,6	50	0,04	–	–	
							●									1,6÷2,0	50	0,04	–	–	
							●									2,0÷2,4	50	0,05	–	–	
							●									2,4÷2,9	50	0,05	–	–	
									●						0,4÷0,8	80	0,04	–	–		
									●						0,8÷1,2	80	0,04	–	–		
									●						1,2÷1,6	80	0,06	–	–		
									●						1,6÷2,0	80	0,06	–	–		
									●						2,0÷2,4	80	0,08	–	–		
									●						2,4÷2,9	80	0,08	–	–		

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

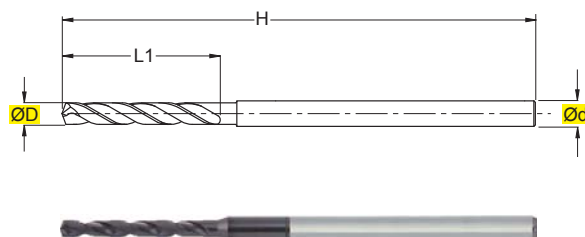
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SDM0310

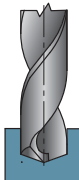
$\varnothing D = 0,5 - 2,9$



TOLLERANZE	D	d
TOLLERANCE RANGE	h7	h7

RIVESTIM. COATED TIALN	3xD
	DIN 6537
	MG

(mm)										
ART.	ØD	Ød	H	L1						
SDM0310005	0,5	3	38	6						
SDM0310006	0,6	3	38	6						
SDM0310007	0,7	3	38	6						
SDM0310008	0,8	3	38	6						
SDM0310009	0,9	3	38	6						
SDM0310010	1,0	3	38	6						
SDM0310011	1,1	3	38	12						
SDM0310012	1,2	3	38	12						
SDM0310013	1,3	3	38	12						
SDM0310014	1,4	3	38	12						
SDM0310015	1,5	3	50	12						
SDM0310016	1,6	3	50	12						
SDM0310017	1,7	3	50	12						
SDM0310018	1,8	3	50	12						
SDM0310019	1,9	3	50	12						
SDM0310020	2,0	3	50	12						
SDM0310021	2,1	3	60	18						
SDM0310022	2,2	3	60	18						
SDM0310023	2,3	3	60	18						
SDM0310024	2,4	3	60	18						
SDM0310025	2,5	3	60	18						
SDM0310026	2,6	3	60	18						
SDM0310027	2,7	3	60	18						
SDM0310028	2,8	3	60	18						
SDM0310029	2,9	3	60	18						

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																				
		P				M	K			N			S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●																0,5÷1,0	50	0,07	-	-	
	●																1,0÷1,5	50	0,10	-	-	
	●																1,5÷2,0	50	0,10	-	-	
	●																2,0÷2,5	50	0,12	-	-	
	●																2,5÷2,9	50	0,14	-	-	
			●															0,5÷1,0	40	0,07	-	-
			●															1,0÷1,5	40	0,10	-	-
			●															1,5÷2,0	40	0,10	-	-
			●															2,0÷2,5	40	0,12	-	-
			●															2,5÷2,9	40	0,14	-	-
						●												0,5÷1,0	30	0,04	-	-
						●												1,0÷1,5	30	0,06	-	-
						●												1,5÷2,0	30	0,06	-	-
						●												2,0÷2,5	30	0,07	-	-
						●												2,5÷2,9	30	0,08	-	-
							●											0,5÷1,0	65	0,07	-	-
							●											1,0÷1,5	65	0,10	-	-
							●											1,5÷2,0	65	0,10	-	-
							●											2,0÷2,5	65	0,12	-	-
							●											2,5÷2,9	65	0,14	-	-
										●								0,5÷1,0	115	0,07	-	-
										●								1,0÷1,5	115	0,10	-	-
										●								1,5÷2,0	115	0,10	-	-
										●								2,0÷2,5	115	0,12	-	-
										●								2,5÷2,9	115	0,14	-	-
													○					0,5÷1,0	15	0,03	-	-
													○					1,0÷1,5	15	0,04	-	-
													○					1,5÷2,0	15	0,04	-	-
													○					2,0÷2,5	15	0,05	-	-
													○					2,5÷2,9	15	0,06	-	-
														○				0,5÷1,0	15	0,025	-	-
														○				1,0÷1,5	15	0,025	-	-
														○				1,5÷2,0	15	0,025	-	-
														○				2,0÷2,5	15	0,035	-	-
														○				2,5÷2,9	15	0,035	-	-
															○			0,5÷1,0	15	0,015	-	-
															○			1,0÷1,5	15	0,015	-	-
															○			1,5÷2,0	15	0,015	-	-
															○			2,0÷2,5	15	0,025	-	-
															○			2,5÷2,9	15	0,025	-	-

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

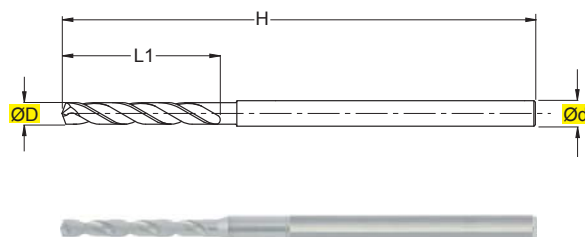
$$n = \frac{Vc \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

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

SDMN0310

ØD = 0,5 - 2,9

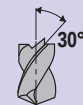
NEW



TOLLERANZE
 TOLERANCE RANGE

D	d
h7	h7

3xD

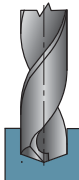


DIN
 6537



MG

ART.	ØD	Ød	H	L1
SDMN0310005	0,5	3	38	6
SDMN0310006	0,6	3	38	6
SDMN0310007	0,7	3	38	6
SDMN0310008	0,8	3	38	6
SDMN0310009	0,9	3	38	6
SDMN0310010	1,0	3	38	6
SDMN0310011	1,1	3	38	12
SDMN0310012	1,2	3	38	12
SDMN0310013	1,3	3	38	12
SDMN0310014	1,4	3	38	12
SDMN0310015	1,5	3	50	12
SDMN0310016	1,6	3	50	12
SDMN0310017	1,7	3	50	12
SDMN0310018	1,8	3	50	12
SDMN0310019	1,9	3	50	12
SDMN0310020	2,0	3	50	12
SDMN0310021	2,1	3	60	18
SDMN0310022	2,2	3	60	18
SDMN0310023	2,3	3	60	18
SDMN0310024	2,4	3	60	18
SDMN0310025	2,5	3	60	18
SDMN0310026	2,6	3	60	18
SDMN0310027	2,7	3	60	18
SDMN0310028	2,8	3	60	18
SDMN0310029	2,9	3	60	18

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N		S	H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf		
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP ALLOY	TITANIO E SUE LEGHE TITANIUM						ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE
	●															0,5÷1,0	40	0,04	-	-	
	●																1,0÷1,5	40	0,04	-	-
	●																1,5÷2,0	40	0,06	-	-
	●																2,0÷2,5	40	0,06	-	-
	●																2,5÷2,9	40	0,08	-	-
			●														0,5÷1,0	30	0,04	-	-
			●														1,0÷1,5	30	0,04	-	-
			●														1,5÷2,0	30	0,06	-	-
			●														2,0÷2,5	30	0,06	-	-
			●														2,5÷2,9	30	0,08	-	-
						○											0,5÷1,0	20	0,03	-	-
						○											1,0÷1,5	20	0,03	-	-
						○											1,5÷2,0	20	0,04	-	-
						○											2,0÷2,5	20	0,04	-	-
						○											2,5÷2,9	20	0,05	-	-
							●										0,5÷1,0	50	0,03	-	-
							●										1,0÷1,5	50	0,03	-	-
							●										1,5÷2,0	50	0,04	-	-
							●										2,0÷2,5	50	0,04	-	-
							●										2,5÷2,9	50	0,05	-	-
									●							0,5÷1,0	80	0,04	-	-	
									●							1,0÷1,5	80	0,04	-	-	
									●							1,5÷2,0	80	0,06	-	-	
									●							2,0÷2,5	80	0,06	-	-	
									●							2,5÷2,9	80	0,08	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

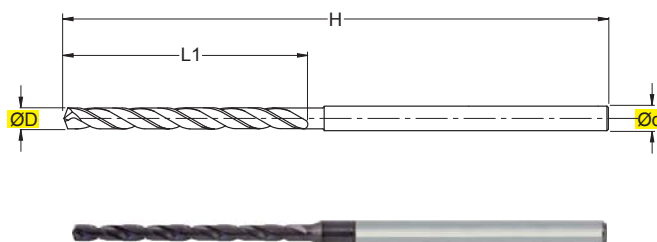
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SDM0510

$\varnothing D = 0,5 - 2,9$



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h7

RIVESTIM. COATED TIALN	5xD
	DIN 6537
	MG

(mm)				
ART.	ØD	Ød	H	L1
SDM0510005	0,5	3	50	10
SDM0510006	0,6	3	50	10
SDM0510007	0,7	3	50	10
SDM0510008	0,8	3	50	10
SDM0510009	0,9	3	50	10
SDM0510010	1,0	3	50	10
SDM0510011	1,1	3	50	20
SDM0510012	1,2	3	60	20
SDM0510013	1,3	3	60	20
SDM0510014	1,4	3	60	20
SDM0510015	1,5	3	60	20
SDM0510016	1,6	3	60	20
SDM0510017	1,7	3	60	20
SDM0510018	1,8	3	60	20
SDM0510019	1,9	3	60	20
SDM0510020	2,0	3	60	20
SDM0510021	2,1	3	66	28
SDM0510022	2,2	3	66	28
SDM0510023	2,3	3	66	28
SDM0510024	2,4	3	66	28
SDM0510025	2,5	3	66	28
SDM0510026	2,6	3	66	28
SDM0510027	2,7	3	66	28
SDM0510028	2,8	3	66	28
SDM0510029	2,9	3	66	28

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73				
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●															0,5÷1,0	50	0,07	-	-	
	●															1,0÷1,5	50	0,10	-	-	
	●															1,5÷2,0	50	0,10	-	-	
	●															2,0÷2,5	50	0,12	-	-	
	●															2,5÷2,9	50	0,14	-	-	
			●													0,5÷1,0	40	0,07	-	-	
			●													1,0÷1,5	40	0,10	-	-	
			●													1,5÷2,0	40	0,10	-	-	
			●													2,0÷2,5	40	0,12	-	-	
			●													2,5÷2,9	40	0,14	-	-	
					●											0,5÷1,0	30	0,04	-	-	
					●											1,0÷1,5	30	0,06	-	-	
					●											1,5÷2,0	30	0,06	-	-	
					●											2,0÷2,5	30	0,07	-	-	
					●											2,5÷2,9	30	0,08	-	-	
							●									0,5÷1,0	65	0,07	-	-	
							●									1,0÷1,5	65	0,10	-	-	
						●									1,5÷2,0	65	0,10	-	-		
						●									2,0÷2,5	65	0,12	-	-		
						●									2,5÷2,9	65	0,14	-	-		
								●							0,5÷1,0	115	0,07	-	-		
								●							1,0÷1,5	115	0,10	-	-		
								●							1,5÷2,0	115	0,10	-	-		
								●							2,0÷2,5	115	0,12	-	-		
								●							2,5÷2,9	115	0,14	-	-		
												○			0,5÷1,0	15	0,03	-	-		
												○			1,0÷1,5	15	0,04	-	-		
												○			1,5÷2,0	15	0,04	-	-		
												○			2,0÷2,5	15	0,05	-	-		
												○			2,5÷2,9	15	0,06	-	-		
													○		0,5÷1,0	15	0,025	-	-		
													○		1,0÷1,5	15	0,025	-	-		
													○		1,5÷2,0	15	0,025	-	-		
													○		2,0÷2,5	15	0,035	-	-		
													○		2,5÷2,9	15	0,035	-	-		
														○	0,5÷1,0	15	0,015	-	-		
														○	1,0÷1,5	15	0,015	-	-		
														○	1,5÷2,0	15	0,015	-	-		
														○	2,0÷2,5	15	0,025	-	-		
														○	2,5÷2,9	15	0,025	-	-		

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

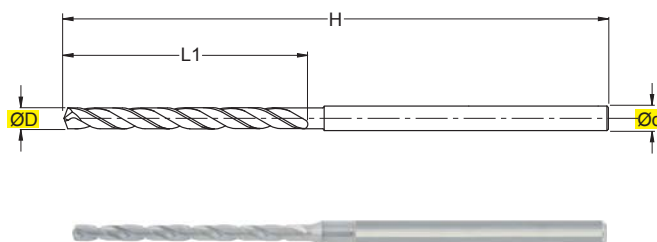
$$n = \frac{Vc \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

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

SDMN0510

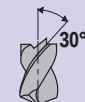
ØD = 0,5 - 2,9

NEW



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h7

5xD



DIN
6537



MG

ART.	ØD	Ød	H	L1
SDMN0510005	0,5	3	50	10
SDMN0510006	0,6	3	50	10
SDMN0510007	0,7	3	50	10
SDMN0510008	0,8	3	50	10
SDMN0510009	0,9	3	50	10
SDMN0510010	1,0	3	50	10
SDMN0510011	1,1	3	50	20
SDMN0510012	1,2	3	60	20
SDMN0510013	1,3	3	60	20
SDMN0510014	1,4	3	60	20
SDMN0510015	1,5	3	60	20
SDMN0510016	1,6	3	60	20
SDMN0510017	1,7	3	60	20
SDMN0510018	1,8	3	60	20
SDMN0510019	1,9	3	60	20
SDMN0510020	2,0	3	60	20
SDMN0510021	2,1	3	66	28
SDMN0510022	2,2	3	66	28
SDMN0510023	2,3	3	66	28
SDMN0510024	2,4	3	66	28
SDMN0510025	2,5	3	66	28
SDMN0510026	2,6	3	66	28
SDMN0510027	2,7	3	66	28
SDMN0510028	2,8	3	66	28
SDMN0510029	2,9	3	66	28

Applicazione - Application		MATERIALI - MATERIALS													Pag. H 73						
		P				M	K			N		S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
		●														0,5÷1,0	40	0,04	-	-	
		●															1,0÷1,5	40	0,04	-	-
		●															1,5÷2,0	40	0,06	-	-
		●															2,0÷2,5	40	0,06	-	-
		●															2,5÷2,9	40	0,08	-	-
			●														0,5÷1,0	30	0,04	-	-
			●														1,0÷1,5	30	0,04	-	-
			●														1,5÷2,0	30	0,06	-	-
			●														2,0÷2,5	30	0,06	-	-
			●														2,5÷2,9	30	0,08	-	-
					○												0,5÷1,0	20	0,03	-	-
					○												1,0÷1,5	20	0,03	-	-
					○												1,5÷2,0	20	0,04	-	-
					○												2,0÷2,5	20	0,04	-	-
					○												2,5÷2,9	20	0,05	-	-
							●										0,5÷1,0	50	0,03	-	-
							●										1,0÷1,5	50	0,03	-	-
							●										1,5÷2,0	50	0,04	-	-
							●										2,0÷2,5	50	0,04	-	-
							●										2,5÷2,9	50	0,05	-	-
										●							0,5÷1,0	80	0,04	-	-
										●							1,0÷1,5	80	0,04	-	-
										●							1,5÷2,0	80	0,06	-	-
										●							2,0÷2,5	80	0,06	-	-
									●							2,5÷2,9	80	0,08	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

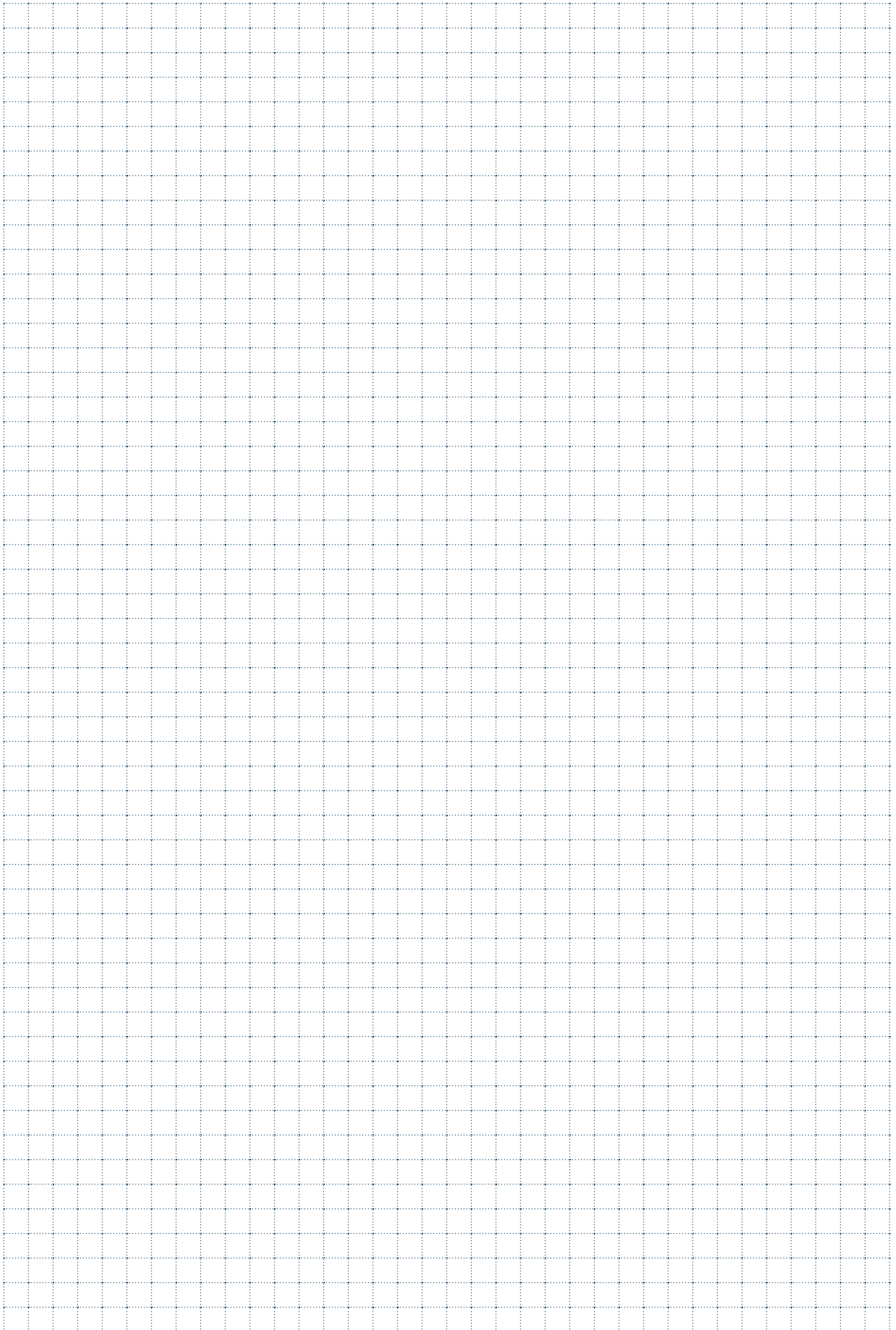
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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



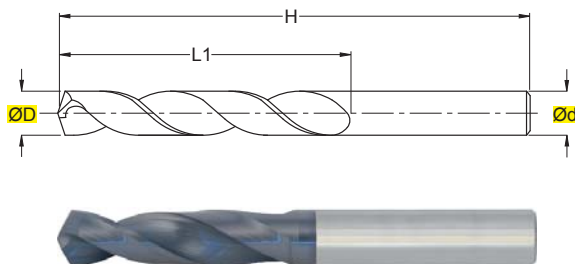


PUNTE INTEGRALI IN HM

SOLID CARBIDE DRILLS / HM VOLLBOHRER /
FORETS EN CARBURE MONOBLOC / PUNTAS INTEGRALES EN METAL DURO

SDR0341

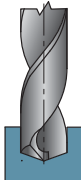
ØD = 3 - 12



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h7

RIVESTIM. COATED TIALN	3xD
	DIN 1897
	MG

(mm)					(mm)								
ART.	ØD	Ød	H	L1	ART.	ØD	Ød	H	L1				
SDR0341030	3,0	3,0	46	16	SDR0341075	7,5	7,5	74	34				
SDR0341031	3,1	3,1	49	18	SDR0341076	7,6	7,6	79	37				
SDR0341032	3,2	3,2	49	18	SDR0341077	7,7	7,7	79	37				
SDR0341033	3,3	3,3	49	18	SDR0341078	7,8	7,8	79	37				
SDR0341034	3,4	3,4	52	20	SDR0341079	7,9	7,9	79	37				
SDR0341035	3,5	3,5	52	20	SDR0341080	8,0	8,0	79	37				
SDR0341036	3,6	3,6	52	20	SDR0341081	8,1	8,1	79	37				
SDR0341037	3,7	3,7	52	20	SDR0341082	8,2	8,2	79	37				
SDR0341038	3,8	3,8	55	22	SDR0341083	8,3	8,3	79	37				
SDR0341039	3,9	3,9	55	22	SDR0341084	8,4	8,4	79	37				
SDR0341040	4,0	4,0	55	22	SDR0341085	8,5	8,5	79	37				
SDR0341041	4,1	4,1	55	22	SDR0341086	8,6	8,6	84	40				
SDR0341042	4,2	4,2	55	22	SDR0341087	8,7	8,7	84	40				
SDR0341043	4,3	4,3	58	24	SDR0341088	8,8	8,8	84	40				
SDR0341044	4,4	4,4	58	24	SDR0341089	8,9	8,9	84	40				
SDR0341045	4,5	4,5	58	24	SDR0341090	9,0	9,0	84	40				
SDR0341046	4,6	4,6	58	24	SDR0341091	9,1	9,1	84	40				
SDR0341047	4,7	4,7	58	24	SDR0341092	9,2	9,2	84	40				
SDR0341048	4,8	4,8	62	26	SDR0341093	9,3	9,3	84	40				
SDR0341049	4,9	4,9	62	26	SDR0341094	9,4	9,4	84	40				
SDR0341050	5,0	5,0	62	26	SDR0341095	9,5	9,5	84	40				
SDR0341051	5,1	5,1	62	26	SDR0341096	9,6	9,6	89	43				
SDR0341052	5,2	5,2	62	26	SDR0341097	9,7	9,7	89	43				
SDR0341053	5,3	5,3	62	26	SDR0341098	9,8	9,8	89	43				
SDR0341054	5,4	5,4	66	28	SDR0341099	9,9	9,9	89	43				
SDR0341055	5,5	5,5	66	28	SDR0341100	10,0	10,0	89	43				
SDR0341056	5,6	5,6	66	28	SDR0341102	10,2	10,2	89	43				
SDR0341057	5,7	5,7	66	28	SDR0341105	10,5	10,5	89	43				
SDR0341058	5,8	5,8	66	28	SDR0341110	11,0	11,0	95	47				
SDR0341059	5,9	5,9	66	28	SDR0341115	11,5	11,5	95	47				
SDR0341060	6,0	6,0	66	28	SDR0341120	12,0	12,0	102	51				
SDR0341061	6,1	6,1	70	31									
SDR0341062	6,2	6,2	70	31									
SDR0341063	6,3	6,3	70	31									
SDR0341064	6,4	6,4	70	31									
SDR0341065	6,5	6,5	70	31									
SDR0341066	6,6	6,6	70	31									
SDR0341067	6,7	6,7	70	31									
SDR0341068	6,8	6,8	74	34									
SDR0341069	6,9	6,9	74	34									
SDR0341070	7,0	7,0	74	34									
SDR0341071	7,1	7,1	74	34									
SDR0341072	7,2	7,2	74	34									
SDR0341073	7,3	7,3	74	34									
SDR0341074	7,4	7,4	74	34									

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																				
		P				M	K			N			S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm)	(m/min)	(mm)	(giri/min) (min ⁻¹)	(mm/min)	
		ØD	Vc	fn	n	Vf																
	●																3÷4	80	0,040	7279	291	
	●																4÷5	80	0,050	5662	283	
	●																5÷6	80	0,075	4632	347	
	●																6÷7	80	0,090	3920	353	
	●																7÷8	80	0,110	3397	374	
	●																8÷9	80	0,125	2997	375	
	●																9÷10	80	0,135	2682	362	
	●																10÷12	80	0,150	2316	347	
		●																3÷4	60	0,040	5460	218
		●																4÷5	60	0,050	4246	212
		●																5÷6	60	0,075	3474	261
		●																6÷7	60	0,090	2940	265
		●																7÷8	60	0,110	2548	280
		●																8÷9	60	0,125	2248	281
		●																9÷10	60	0,135	2011	272
		●																10÷12	60	0,150	1737	261
								○										3÷4	84	0,045	7643	344
								○										4÷5	84	0,070	5945	416
								○										5÷6	84	0,090	4864	438
								○										6÷7	84	0,110	4116	453
								○										7÷8	84	0,130	3567	464
								○										8÷9	84	0,145	3147	456
								○										9÷10	84	0,155	2816	436
								○										10÷12	84	0,170	2432	413
								○										3÷4	70	0,045	6369	287
								○										4÷5	70	0,070	4954	347
								○										5÷6	70	0,090	4053	365
								○										6÷7	70	0,110	3430	377
								○										7÷8	70	0,130	2972	386
								○										8÷9	70	0,145	2623	380
								○										9÷10	70	0,155	2347	364
								○										10÷12	70	0,170	2027	345
								○										3÷4	130	0,014	11829	166
								○										4÷5	130	0,018	9200	166
								○										5÷6	130	0,025	7528	188
								○										6÷7	130	0,045	6369	287
								○										7÷8	130	0,055	5520	304
								○										8÷9	130	0,065	4871	317
								○										9÷10	130	0,075	4358	327
								○										10÷12	130	0,090	3764	339
								○										3÷4	100	0,006	9099	55
								○										4÷5	100	0,012	7077	85
								○										5÷6	100	0,016	5790	93
								○										6÷7	100	0,025	4900	122
								○										7÷8	100	0,040	4246	170
								○										8÷9	100	0,055	3747	206
								○										9÷10	100	0,065	3352	218
								○										10÷12	100	0,085	2895	246

●

APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○

APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

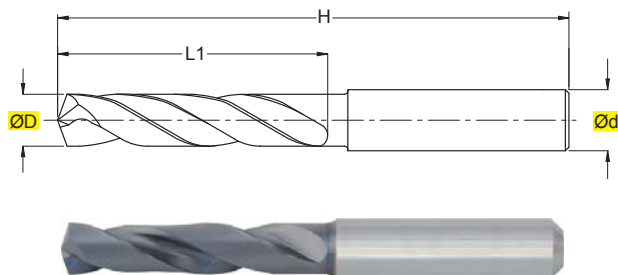
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDR0302

ØD = 3 - 20

NEW

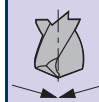
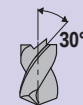


TOLLERANZE
TOLERANCE RANGE

D	d
m7	h6

RIVESTIM.
COATED
TIALN

3xD



DIN
6535



MG

ART.	ØD	Ød	H	L1
SDR0302030	3,0	6	62	20
SDR0302031	3,1	6	62	20
SDR0302032	3,2	6	62	20
SDR0302033	3,3	6	62	20
SDR0302034	3,4	6	62	20
SDR0302035	3,5	6	62	20
SDR0302036	3,6	6	62	20
SDR0302037	3,7	6	62	20
SDR0302038	3,8	6	66	24
SDR0302039	3,9	6	66	24
SDR0302040	4,0	6	66	24
SDR0302041	4,1	6	66	24
SDR0302042	4,2	6	66	24
SDR0302043	4,3	6	66	24
SDR0302044	4,4	6	66	24
SDR0302045	4,5	6	66	24
SDR0302046	4,6	6	66	24
SDR0302047	4,7	6	66	24
SDR0302048	4,8	6	66	28
SDR0302049	4,9	6	66	28
SDR0302050	5,0	6	66	28
SDR0302051	5,1	6	66	28
SDR0302052	5,2	6	66	28
SDR0302053	5,3	6	66	28
SDR0302054	5,4	6	66	28
SDR0302055	5,5	6	66	28
SDR0302056	5,6	6	66	28
SDR0302057	5,7	6	66	28
SDR0302058	5,8	6	66	28
SDR0302059	5,9	6	66	28
* SDR0302060	6,0	6	66	28
SDR0302061	6,1	8	79	34
SDR0302062	6,2	8	79	34
SDR0302063	6,3	8	79	34
SDR0302064	6,4	8	79	34
SDR0302065	6,5	8	79	34
SDR0302066	6,6	8	79	34
SDR0302067	6,7	8	79	34
SDR0302068	6,8	8	79	34
SDR0302069	6,9	8	79	34
SDR0302070	7,0	8	79	34
SDR0302071	7,1	8	79	41
SDR0302072	7,2	8	79	41
SDR0302073	7,3	8	79	41
SDR0302074	7,4	8	79	41

ART.	ØD	Ød	H	L1
SDR0302075	7,5	8	79	41
SDR0302076	7,6	8	79	41
SDR0302077	7,7	8	79	41
SDR0302078	7,8	8	79	41
SDR0302079	7,9	8	79	41
* SDR0302080	8,0	8	79	41
SDR0302081	8,1	10	89	47
SDR0302082	8,2	10	89	47
SDR0302083	8,3	10	89	47
SDR0302084	8,4	10	89	47
SDR0302085	8,5	10	89	47
SDR0302086	8,6	10	89	47
SDR0302087	8,7	10	89	47
SDR0302088	8,8	10	89	47
SDR0302089	8,9	10	89	47
SDR0302090	9,0	10	89	47
SDR0302091	9,1	10	89	47
SDR0302092	9,2	10	89	47
SDR0302093	9,3	10	89	47
SDR0302094	9,4	10	89	47
SDR0302095	9,5	10	89	47
SDR0302096	9,6	10	89	47
SDR0302097	9,7	10	89	47
SDR0302098	9,8	10	89	47
SDR0302099	9,9	10	89	47
* SDR0302100	10,0	10	89	47
SDR0302102	10,2	12	102	55
SDR0302105	10,5	12	102	55
SDR0302108	10,8	12	102	55
SDR0302110	11,0	12	102	55
SDR0302112	11,2	12	102	55
SDR0302115	11,5	12	102	55
SDR0302118	11,8	12	102	55
* SDR0302120	12,0	12	102	55
SDR0302122	12,2	14	107	60
SDR0302125	12,5	14	107	60
SDR0302128	12,8	14	107	60
SDR0302130	13,0	14	107	60
SDR0302135	13,5	14	107	60
SDR0302138	13,8	14	107	60
* SDR0302140	14,0	14	107	60
SDR0302142	14,2	16	115	65
SDR0302145	14,5	16	115	65
SDR0302148	14,8	16	115	65
SDR0302150	15,0	16	115	65

ART.	ØD	Ød	H	L1
SDR0302152	15,2	16	115	65
SDR0302155	15,5	16	115	65
SDR0302158	15,8	16	115	65
* SDR0302160	16,0	16	115	65
SDR0302165	16,5	18	123	73
SDR0302168	16,8	18	123	73
SDR0302170	17,0	18	123	73
SDR0302175	17,5	18	123	73
* SDR0302180	18,0	18	123	73
SDR0302185	18,5	20	131	79
SDR0302188	18,8	20	131	79
SDR0302190	19,0	20	131	79
SDR0302195	19,5	20	131	79
* SDR0302200	20,0	20	131	79

* = COSTRUITI IN TOLLERANZA h7
 * = MADE WITH h7 TOLERANCE
 * = GEBAUT MIT TOLERANZ h7
 * = RÉALISÉS EN TOLÉRANCE h7

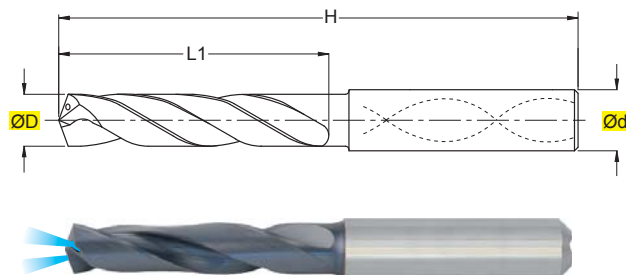
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0302

ØD = 3 - 20

NEW

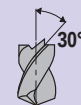


TOLLERANZE
TOLERANCE RANGE

D	d
m7	h6

RIVESTIM.
COATED
TIALN

3xD



DIN
6535



MG

ART.	ØD	Ød	H	L1
SDF0302030	3,0	6,0	62,0	20,0
SDF0302031	3,1	6,0	62,0	20,0
SDF0302032	3,2	6,0	62,0	20,0
SDF0302033	3,3	6,0	62,0	20,0
SDF0302034	3,4	6,0	62,0	20,0
SDF0302035	3,5	6,0	62,0	20,0
SDF0302036	3,6	6,0	62,0	20,0
SDF0302037	3,7	6,0	62,0	20,0
SDF0302038	3,8	6,0	66,0	24,0
SDF0302039	3,9	6,0	66,0	24,0
SDF0302040	4,0	6,0	66,0	24,0
SDF0302041	4,1	6,0	66,0	24,0
SDF0302042	4,2	6,0	66,0	24,0
SDF0302043	4,3	6,0	66,0	24,0
SDF0302044	4,4	6,0	66,0	24,0
SDF0302045	4,5	6,0	66,0	24,0
SDF0302046	4,6	6,0	66,0	24,0
SDF0302047	4,7	6,0	66,0	24,0
SDF0302048	4,8	6,0	66,0	28,0
SDF0302049	4,9	6,0	66,0	28,0
SDF0302050	5,0	6,0	66,0	28,0
SDF0302051	5,1	6,0	66,0	28,0
SDF0302052	5,2	6,0	66,0	28,0
SDF0302053	5,3	6,0	66,0	28,0
SDF0302054	5,4	6,0	66,0	28,0
SDF0302055	5,5	6,0	66,0	28,0
SDF0302056	5,6	6,0	66,0	28,0
SDF0302057	5,7	6,0	66,0	28,0
SDF0302058	5,8	6,0	66,0	28,0
SDF0302059	5,9	6,0	66,0	28,0
* SDF0302060	6,0	6,0	66,0	28,0
SDF0302061	6,1	8,0	79,0	34,0
SDF0302062	6,2	8,0	79,0	34,0
SDF0302063	6,3	8,0	79,0	34,0
SDF0302064	6,4	8,0	79,0	34,0
SDF0302065	6,5	8,0	79,0	34,0
SDF0302066	6,6	8,0	79,0	34,0
SDF0302067	6,7	8,0	79,0	34,0
SDF0302068	6,8	8,0	79,0	34,0
SDF0302069	6,9	8,0	79,0	34,0
SDF0302070	7,0	8,0	79,0	34,0
SDF0302071	7,1	8,0	79,0	41,0
SDF0302072	7,2	8,0	79,0	41,0
SDF0302073	7,3	8,0	79,0	41,0
SDF0302074	7,4	8,0	79,0	41,0

ART.	ØD	Ød	H	L1
SDF0302075	7,5	8,0	79,0	41,0
SDF0302076	7,6	8,0	79,0	41,0
SDF0302077	7,7	8,0	79,0	41,0
SDF0302078	7,8	8,0	79,0	41,0
SDF0302079	7,9	8,0	79,0	41,0
* SDF0302080	8,0	8,0	79,0	41,0
SDF0302081	8,1	10,0	89,0	47,0
SDF0302082	8,2	10,0	89,0	47,0
SDF0302083	8,3	10,0	89,0	47,0
SDF0302084	8,4	10,0	89,0	47,0
SDF0302085	8,5	10,0	89,0	47,0
SDF0302086	8,6	10,0	89,0	47,0
SDF0302087	8,7	10,0	89,0	47,0
SDF0302088	8,8	10,0	89,0	47,0
SDF0302089	8,9	10,0	89,0	47,0
SDF0302090	9,0	10,0	89,0	47,0
SDF0302091	9,1	10,0	89,0	47,0
SDF0302092	9,2	10,0	89,0	47,0
SDF0302093	9,3	10,0	89,0	47,0
SDF0302094	9,4	10,0	89,0	47,0
SDF0302095	9,5	10,0	89,0	47,0
SDF0302096	9,6	10,0	89,0	47,0
SDF0302097	9,7	10,0	89,0	47,0
SDF0302098	9,8	10,0	89,0	47,0
SDF0302099	9,9	10,0	89,0	47,0
* SDF0302100	10,0	10,0	89,0	47,0
SDF0302102	10,2	12,0	102,0	55,0
SDF0302105	10,5	12,0	102,0	55,0
SDF0302108	10,8	12,0	102,0	55,0
SDF0302110	11,0	12,0	102,0	55,0
SDF0302112	11,2	12,0	102,0	55,0
SDF0302115	11,5	12,0	102,0	55,0
SDF0302118	11,8	12,0	102,0	55,0
* SDF0302120	12,0	12,0	102,0	55,0
SDF0302122	12,2	14,0	107,0	60,0
SDF0302125	12,5	14,0	107,0	60,0
SDF0302128	12,8	14,0	107,0	60,0
SDF0302130	13,0	14,0	107,0	60,0
SDF0302135	13,5	14,0	107,0	60,0
SDF0302138	13,8	14,0	107,0	60,0
* SDF0302140	14,0	14,0	107,0	60,0
SDF0302142	14,2	16,0	115,0	65,0
SDF0302145	14,5	16,0	115,0	65,0
SDF0302148	14,8	16,0	115,0	65,0
SDF0302150	15,0	16,0	115,0	65,0

ART.	ØD	Ød	H	L1
SDF0302152	15,2	16,0	115,0	65,0
SDF0302155	15,5	16,0	115,0	65,0
SDF0302158	15,8	16,0	115,0	65,0
* SDF0302160	16,0	16,0	115,0	65,0
SDF0302165	16,5	18,0	123,0	73,0
SDF0302170	17,0	18,0	123,0	73,0
SDF0302175	17,5	18,0	123,0	73,0
* SDF0302180	18,0	18,0	123,0	73,0
SDF0302185	18,5	20,0	131,0	79,0
SDF0302190	19,0	20,0	131,0	79,0
SDF0302195	19,5	20,0	131,0	79,0
* SDF0302200	20,0	20,0	131,0	79,0

* = COSTRUITI IN TOLLERANZA h7
 * = MADE WITH h7 TOLERANCE
 * = GEBAUT MIT TOLERANZ h7
 * = RÉALISÉS EN TOLÉRANCE h7

- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

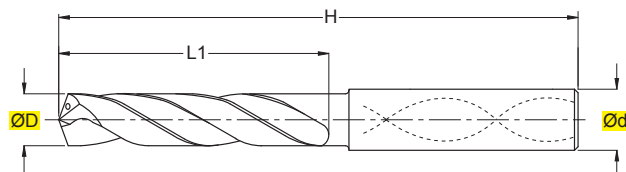
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

SDF0371

ØD = 2 - 12

NEW

DISPONIBILE DA SETTEMBRE 2014
AVAILABLE FROM SEPTEMBER 2014
AB SEPTEMBER 2014 LIEFERBAR
DISPONIBLE À PARTIR DE SEPTEMBRE 2014

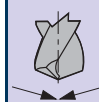
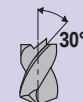


PER PREPARAZIONE FORI ≥ 16xD
FOR THE PREPARATION OF BORES ≥ 16xD
ZUR VORBEREITUNG VON BOHRUNGEN ≥ 16xD
POUR LA PRÉPARATION DE TROUS ≥ 16xD

TOLLERANZE	D	d
TOLERANCE RANGE	+0,030 +0,005	h6

RIVESTIM.
COATED
TIALN

3xD

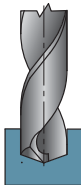


DIN
6535



MG

ART.	ØD	Ød	H	L1
SDF0371020	2,0	4	50,0	12,0
SDF0371022	2,2	4	50,0	12,0
SDF0371023	2,3	4	50,0	12,0
SDF0371024	2,4	4	50,0	12,0
SDF0371025	2,5	4	50,0	12,0
SDF0371027	2,7	4	50,0	12,0
SDF0371028	2,8	4	50,0	12,0
SDF0371030	3,0	6	62,0	20,0
SDF0371032	3,2	6	62,0	20,0
SDF0371033	3,3	6	62,0	20,0
SDF0371035	3,5	6	62,0	20,0
SDF0371038	3,8	6	66,0	24,0
SDF0371040	4,0	6	66,0	24,0
SDF0371042	4,2	6	66,0	24,0
SDF0371045	4,5	6	66,0	24,0
SDF0371048	4,8	6	66,0	28,0
SDF0371050	5,0	6	66,0	28,0
SDF0371055	5,5	6	66,0	28,0
SDF0371058	5,8	6	66,0	28,0
SDF0371060	6,0	6	66,0	28,0
SDF0371065	6,5	8	79,0	34,0
SDF0371068	6,8	8	79,0	34,0
SDF0371070	7,0	8	79,0	34,0
SDF0371075	7,5	8	79,0	41,0
SDF0371078	7,8	8	79,0	41,0
SDF0371080	8,0	8	79,0	41,0
SDF0371085	8,5	10	89,0	47,0
SDF0371088	8,8	10	89,0	47,0
SDF0371090	9,0	10	89,0	47,0
SDF0371098	9,8	10	89,0	47,0
SDF0371100	10,0	10	89,0	47,0
SDF0371102	10,2	12	102,0	55,0
SDF0371108	10,8	12	102,0	55,0
SDF0371118	11,8	12	102,0	55,0
SDF0371120	12,0	12	102,0	55,0

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73															(mm) ØD (m/min) Vc (mm) fn (mm) n (mm) Vf				
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															2÷3	120	0,130	15287	1987	
	●																3÷4	120	0,150	10919	1638
	●																4÷5	120	0,170	8493	1444
	●																5÷6	120	0,200	6948	1390
	●																6÷7	120	0,230	5879	1352
	●																7÷8	120	0,260	5096	1325
	●																8÷9	120	0,300	4496	1349
	●																9÷10	120	0,330	4023	1328
	●																10÷11	120	0,350	3640	1274
	●																11÷12	120	0,380	3323	1263
	●																2÷3	110	0,130	14013	1822
	●																3÷4	110	0,150	10009	1501
	●																4÷5	110	0,170	7785	1323
	●																5÷6	110	0,200	6369	1274
	●																6÷7	110	0,230	5390	1240
	●																7÷8	110	0,260	4671	1214
	●																8÷9	110	0,300	4121	1236
	●																9÷10	110	0,330	3688	1217
	●																10÷11	110	0,350	3336	1168
	●																11÷12	110	0,380	3046	1158
					●												2÷3	45	0,100	5732	573
					●												3÷4	45	0,110	4095	450
					●												4÷5	45	0,130	3185	414
					●												5÷6	45	0,150	2606	391
					●												6÷7	45	0,170	2205	375
					●												7÷8	45	0,200	1911	382
					●												8÷9	45	0,220	1686	371
					●												9÷10	45	0,250	1509	377
					●												10÷11	45	0,270	1365	369
					●												11÷12	45	0,280	1246	349
						●											2÷3	120	0,130	15287	1987
						●											3÷4	120	0,150	10919	1638
						●											4÷5	120	0,170	8493	1444
						●											5÷6	120	0,200	6948	1390
						●											6÷7	120	0,230	5879	1352
						●											7÷8	120	0,260	5096	1325
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						●											9÷10	120	0,330	4023	1328
						●											10÷11	120	0,350	3640	1274
						●											11÷12	120	0,380	3323	1263
							●										2÷3	110	0,100	14013	1401
							●										3÷4	110	0,110	10009	1101
							●										4÷5	110	0,130	7785	1012
							●										5÷6	110	0,150	6369	955
							●										6÷7	110	0,170	5390	916
							●										7÷8	110	0,200	4671	934
							●										8÷9	110	0,220	4121	907
							●										9÷10	110	0,250	3688	922
							●										10÷11	110	0,270	3336	901
							●										11÷12	110	0,280	3046	853

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

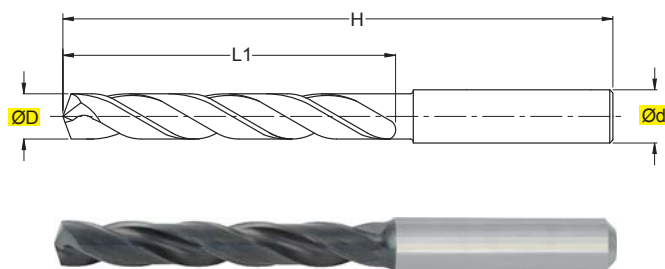
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDR0502

ØD = 3 - 20

NEW

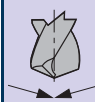
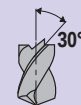


TOLLERANZE
TOLERANCE RANGE

D	d
m7	h6

RIVESTIM.
COATED
TIALN

5xD



DIN
6535



MG

ART.	ØD	Ød	H	L1
SDR0502030	3,0	6,0	66,0	28,0
SDR0502031	3,1	6,0	66,0	28,0
SDR0502032	3,2	6,0	66,0	28,0
SDR0502033	3,3	6,0	66,0	28,0
SDR0502034	3,4	6,0	66,0	28,0
SDR0502035	3,5	6,0	66,0	28,0
SDR0502036	3,6	6,0	66,0	28,0
SDR0502037	3,7	6,0	66,0	28,0
SDR0502038	3,8	6,0	74,0	36,0
SDR0502039	3,9	6,0	74,0	36,0
SDR0502040	4,0	6,0	74,0	36,0
SDR0502041	4,1	6,0	74,0	36,0
SDR0502042	4,2	6,0	74,0	36,0
SDR0502043	4,3	6,0	74,0	36,0
SDR0502044	4,4	6,0	74,0	36,0
SDR0502045	4,5	6,0	74,0	36,0
SDR0502046	4,6	6,0	74,0	36,0
SDR0502047	4,7	6,0	74,0	36,0
SDR0502048	4,8	6,0	82,0	44,0
SDR0502049	4,9	6,0	82,0	44,0
SDR0502050	5,0	6,0	82,0	44,0
SDR0502051	5,1	6,0	82,0	44,0
SDR0502052	5,2	6,0	82,0	44,0
SDR0502053	5,3	6,0	82,0	44,0
SDR0502054	5,4	6,0	82,0	44,0
SDR0502055	5,5	6,0	82,0	44,0
SDR0502056	5,6	6,0	82,0	44,0
SDR0502057	5,7	6,0	82,0	44,0
SDR0502058	5,8	6,0	82,0	44,0
SDR0502059	5,9	6,0	82,0	44,0
* SDR0502060	6,0	6,0	82,0	44,0
SDR0502061	6,1	8,0	91,0	53,0
SDR0502062	6,2	8,0	91,0	53,0
SDR0502063	6,3	8,0	91,0	53,0
SDR0502064	6,4	8,0	91,0	53,0
SDR0502065	6,5	8,0	91,0	53,0
SDR0502066	6,6	8,0	91,0	53,0
SDR0502067	6,7	8,0	91,0	53,0
SDR0502068	6,8	8,0	91,0	53,0
SDR0502069	6,9	8,0	91,0	53,0
SDR0502070	7,0	8,0	91,0	53,0
SDR0502071	7,1	8,0	91,0	53,0
SDR0502072	7,2	8,0	91,0	53,0
SDR0502073	7,3	8,0	91,0	53,0
SDR0502074	7,4	8,0	91,0	53,0

ART.	ØD	Ød	H	L1
SDR0502075	7,5	8,0	91,0	53,0
SDR0502076	7,6	8,0	91,0	53,0
SDR0502077	7,7	8,0	91,0	53,0
SDR0502078	7,8	8,0	91,0	53,0
SDR0502079	7,9	8,0	91,0	53,0
* SDR0502080	8,0	8,0	91,0	53,0
SDR0502081	8,1	10,0	103,0	61,0
SDR0502082	8,2	10,0	103,0	61,0
SDR0502083	8,3	10,0	103,0	61,0
SDR0502084	8,4	10,0	103,0	61,0
SDR0502085	8,5	10,0	103,0	61,0
SDR0502086	8,6	10,0	103,0	61,0
SDR0502087	8,7	10,0	103,0	61,0
SDR0502088	8,8	10,0	103,0	61,0
SDR0502089	8,9	10,0	103,0	61,0
SDR0502090	9,0	10,0	103,0	61,0
SDR0502091	9,1	10,0	103,0	61,0
SDR0502092	9,2	10,0	103,0	61,0
SDR0502093	9,3	10,0	103,0	61,0
SDR0502094	9,4	10,0	103,0	61,0
SDR0502095	9,5	10,0	103,0	61,0
SDR0502096	9,6	10,0	103,0	61,0
SDR0502097	9,7	10,0	103,0	61,0
SDR0502098	9,8	10,0	103,0	61,0
SDR0502099	9,9	10,0	103,0	61,0
* SDR0502100	10,0	10,0	103,0	61,0
SDR0502102	10,2	12,0	118,0	71,0
SDR0502105	10,5	12,0	118,0	71,0
SDR0502108	10,8	12,0	118,0	71,0
SDR0502110	11,0	12,0	118,0	71,0
SDR0502112	11,2	12,0	118,0	71,0
SDR0502115	11,5	12,0	118,0	71,0
SDR0502118	11,8	12,0	118,0	71,0
* SDR0502120	12,0	12,0	118,0	71,0
SDR0502122	12,2	14,0	124,0	77,0
SDR0502125	12,5	14,0	124,0	77,0
SDR0502128	12,8	14,0	124,0	77,0
SDR0502130	13,0	14,0	124,0	77,0
SDR0502132	13,2	14,0	124,0	77,0
SDR0502135	13,5	14,0	124,0	77,0
SDR0502138	13,8	14,0	124,0	77,0
* SDR0502140	14,0	14,0	124,0	77,0
SDR0502142	14,2	16,0	133,0	83,0
SDR0502145	14,5	16,0	133,0	83,0
SDR0502148	14,8	16,0	133,0	83,0

ART.	ØD	Ød	H	L1
SDR0502150	15,0	16,0	133,0	83,0
SDR0502152	15,2	16,0	133,0	83,0
SDR0502155	15,5	16,0	133,0	83,0
SDR0502158	15,8	16,0	133,0	83,0
* SDR0502160	16,0	16,0	133,0	83,0
SDR0502165	16,5	18,0	143,0	93,0
SDR0502170	17,0	18,0	143,0	93,0
SDR0502175	17,5	18,0	143,0	93,0
* SDR0502180	18,0	18,0	143,0	93,0
SDR0502185	18,5	20,0	153,0	101,0
SDR0502190	19,0	20,0	153,0	101,0
SDR0502195	19,5	20,0	153,0	101,0
* SDR0502200	20,0	20,0	153,0	101,0

* = COSTRUITI IN TOLLERANZA h7
 * = MADE WITH h7 TOLERANCE
 * = GEBAUT MIT TOLERANZ h7
 * = RÉALISÉS EN TOLÉRANCE h7

Applicazione - Application

MATERIALI - MATERIALS															Pag. H 73					
P				M	K			N			S	H	G							
ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●															(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●															3÷4	90	0,035	8189	287
	●															4÷5	90	0,045	6369	287
	●															5÷6	90	0,060	5211	313
	●															6÷7	90	0,070	4410	309
	●															7÷8	90	0,080	3822	306
	●															8÷9	90	0,100	3372	337
	●															9÷10	90	0,110	3017	332
	●															10÷12	90	0,120	2606	313
	●															12÷14	90	0,130	2205	287
	●															14÷16	90	0,165	1911	315
	●															16÷18	90	0,190	1686	320
	●															18÷20	90	0,210	1509	317

		●														3÷4	80	0,035	7279	255
		●														4÷5	80	0,045	5662	255
		●														5÷6	80	0,060	4632	278
		●														6÷7	80	0,070	3920	274
		●														7÷8	80	0,080	3397	272
		●														8÷9	80	0,100	2997	300
		●														9÷10	80	0,110	2682	295
		●														10÷12	80	0,120	2316	278
		●														12÷14	80	0,130	1960	255
		●														14÷16	80	0,165	1699	280
		●														16÷18	80	0,190	1499	285
		●														18÷20	80	0,210	1341	282

				○												3÷4	40	0,080	3640	291
				○												4÷5	40	0,080	2831	226
				○												5÷6	40	0,120	2316	278
				○												6÷7	40	0,120	1960	235
				○												7÷8	40	0,120	1699	204
				○												8÷9	40	0,150	1499	225
				○												9÷10	40	0,150	1341	201
				○												10÷12	40	0,150	1158	174
				○												12÷14	40	0,200	980	196
				○												14÷16	40	0,200	849	170
				○												16÷18	40	0,250	749	187
				○												18÷20	40	0,250	670	168

					○											3÷4	110	0,090	10009	901
					○											4÷5	110	0,120	7785	934
					○											5÷6	110	0,150	6369	955
					○											6÷7	110	0,170	5390	916
					○											7÷8	110	0,190	4671	887
					○											8÷9	110	0,210	4121	865
					○											9÷10	110	0,230	3688	848
					○											10÷12	110	0,260	3185	828
					○											12÷14	110	0,300	2695	808
					○											14÷16	110	0,340	2335	794
					○											16÷18	110	0,370	2061	762
					○											18÷20	110	0,410	1844	756

						○										3÷4	90	0,090	8189	737
						○										4÷5	90	0,120	6369	764
						○										5÷6	90	0,150	5211	782
						○										6÷7	90	0,170	4410	750
						○										7÷8	90	0,190	3822	726
						○										8÷9	90	0,210	3372	708
						○										9÷10	90	0,230	3017	694
						○										10÷12	90	0,260	2606	677
						○										12÷14	90	0,300	2205	661
						○										14÷16	90	0,340	1911	650
						○										16÷18	90	0,370	1686	624
						○										18÷20	90	0,410	1509	619

- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

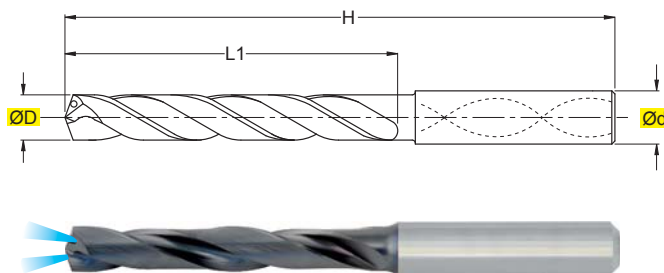
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0502

ØD = 3 - 20

NEW

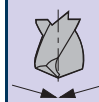
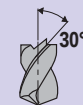


TOLLERANZE
TOLERANCE RANGE

D	d
m7	h6

RIVESTIM.
COATED
TIALN

5xD



DIN
6535



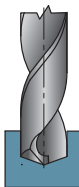
MG

ART.	ØD	Ød	H	L1
SDF0502030	3,0	6	66	28
SDF0502031	3,1	6	66	28
SDF0502032	3,2	6	66	28
SDF0502033	3,3	6	66	28
SDF0502034	3,4	6	66	28
SDF0502035	3,5	6	66	28
SDF0502036	3,6	6	66	28
SDF0502037	3,7	6	66	28
SDF0502038	3,8	6	74	36
SDF0502039	3,9	6	74	36
SDF0502040	4,0	6	74	36
SDF0502041	4,1	6	74	36
SDF0502042	4,2	6	74	36
SDF0502043	4,3	6	74	36
SDF0502044	4,4	6	74	36
SDF0502045	4,5	6	74	36
SDF0502046	4,6	6	74	36
SDF0502047	4,7	6	74	36
SDF0502048	4,8	6	82	44
SDF0502049	4,9	6	82	44
SDF0502050	5,0	6	82	44
SDF0502051	5,1	6	82	44
SDF0502052	5,2	6	82	44
SDF0502053	5,3	6	82	44
SDF0502054	5,4	6	82	44
SDF0502055	5,5	6	82	44
SDF0502056	5,6	6	82	44
SDF0502057	5,7	6	82	44
SDF0502058	5,8	6	82	44
SDF0502059	5,9	6	82	44
* SDF0502060	6,0	6	82	44
SDF0502061	6,1	8	91	53
SDF0502062	6,2	8	91	53
SDF0502063	6,3	8	91	53
SDF0502064	6,4	8	91	53
SDF0502065	6,5	8	91	53
SDF0502066	6,6	8	91	53
SDF0502067	6,7	8	91	53
SDF0502068	6,8	8	91	53
SDF0502069	6,9	8	91	53
SDF0502070	7,0	8	91	53
SDF0502071	7,1	8	91	53
SDF0502072	7,2	8	91	53
SDF0502073	7,3	8	91	53
SDF0502074	7,4	8	91	53

ART.	ØD	Ød	H	L1
SDF0502075	7,5	8	91	53
SDF0502076	7,6	8	91	53
SDF0502077	7,7	8	91	53
SDF0502078	7,8	8	91	53
SDF0502079	7,9	8	91	53
* SDF0502080	8,0	8	91	53
SDF0502081	8,1	10	103	61
SDF0502082	8,2	10	103	61
SDF0502083	8,3	10	103	61
SDF0502084	8,4	10	103	61
SDF0502085	8,5	10	103	61
SDF0502086	8,6	10	103	61
SDF0502087	8,7	10	103	61
SDF0502088	8,8	10	103	61
SDF0502089	8,9	10	103	61
SDF0502090	9,0	10	103	61
SDF0502091	9,1	10	103	61
SDF0502092	9,2	10	103	61
SDF0502093	9,3	10	103	61
SDF0502094	9,4	10	103	61
SDF0502095	9,5	10	103	61
SDF0502096	9,6	10	103	61
SDF0502097	9,7	10	103	61
SDF0502098	9,8	10	103	61
SDF0502099	9,9	10	103	61
* SDF0502100	10,0	10	103	61
SDF0502102	10,2	12	118	71
SDF0502103	10,3	12	118	71
SDF0502105	10,5	12	118	71
SDF0502108	10,8	12	118	71
SDF0502110	11,0	12	118	71
SDF0502112	11,2	12	118	71
SDF0502115	11,5	12	118	71
SDF0502118	11,8	12	118	71
* SDF0502120	12,0	12	118	71
SDF0502122	12,2	14	124	77
SDF0502125	12,5	14	124	77
SDF0502128	12,8	14	124	77
SDF0502130	13,0	14	124	77
SDF0502132	13,2	14	124	77
SDF0502135	13,5	14	124	77
SDF0502138	13,8	14	124	77
* SDF0502140	14,0	14	124	77
SDF0502142	14,2	16	133	83
SDF0502145	14,5	16	133	83

ART.	ØD	Ød	H	L1
SDF0502148	14,8	16	133	83
SDF0502150	15,0	16	133	83
SDF0502152	15,2	16	133	83
SDF0502155	15,5	16	133	83
SDF0502158	15,8	16	133	83
* SDF0502160	16,0	16	133	83
SDF0502165	16,5	18	143	93
SDF0502170	17,0	18	143	93
SDF0502175	17,5	18	143	93
* SDF0502180	18,0	18	143	93
SDF0502185	18,5	20	153	101
SDF0502190	19,0	20	153	101
SDF0502195	19,5	20	153	101
* SDF0502200	20,0	20	153	101

* = COSTRUITI IN TOLLERANZA h7
 * = MADE WITH h7 TOLERANCE
 * = GEBAUT MIT TOLERANZ h7
 * = RÉALISÉS EN TOLÉRANCE h7

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P		M	K		N		S		H	G									
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●																3÷4	120	0,160	10919	1747
	●																4÷5	120	0,160	8493	1359
	●																5÷6	120	0,220	6948	1529
	●																6÷7	120	0,220	5879	1293
	●																7÷8	120	0,220	5096	1121
	●																8÷9	120	0,280	4496	1259
	●																9÷10	120	0,280	4023	1126
	●																10÷12	120	0,280	3474	973
	●																12÷14	120	0,340	2940	1000
	●																14÷16	120	0,340	2548	866
																	16÷18	120	0,380	2248	854
																	18÷20	120	0,380	2011	764
	●																3÷4	110	0,080	10009	801
	●																4÷5	110	0,080	7785	623
	●																5÷6	110	0,120	6369	764
	●																6÷7	110	0,120	5390	647
	●																7÷8	110	0,120	4671	561
	●																8÷9	110	0,150	4121	618
	●																9÷10	110	0,150	3688	553
	●																10÷12	110	0,150	3185	478
	●																12÷14	110	0,200	2695	539
	●																14÷16	110	0,200	2335	467
	●																16÷18	110	0,250	2061	515
	●																18÷20	110	0,250	1844	461
		●															3÷4	70	0,080	6369	510
		●															4÷5	70	0,080	4954	396
		●															5÷6	70	0,120	4053	486
		●															6÷7	70	0,120	3430	412
		●															7÷8	70	0,120	2972	357
		●															8÷9	70	0,150	2623	393
		●															9÷10	70	0,150	2347	352
		●															10÷12	70	0,150	2027	304
		●															12÷14	70	0,200	1715	343
		●															14÷16	70	0,200	1486	297
		●															16÷18	70	0,250	1311	328
		●															18÷20	70	0,250	1173	293
					○												3÷4	45	0,080	4095	328
					○												4÷5	45	0,080	3185	255
					○												5÷6	45	0,120	2606	313
					○												6÷7	45	0,120	2205	265
					○												7÷8	45	0,120	1911	229
					○												8÷9	45	0,150	1686	253
					○												9÷10	45	0,150	1509	226
					○												10÷12	45	0,150	1303	195
					○												12÷14	45	0,200	1102	220
					○												14÷16	45	0,200	955	191
					○												16÷18	45	0,250	843	211
					○												18÷20	45	0,250	754	189
							○										3÷4	110	0,125	10009	1251
							○										4÷5	110	0,125	7785	973
							○										5÷6	110	0,175	6369	1115
							○										6÷7	110	0,175	5390	943
							○										7÷8	110	0,175	4671	817
							○										8÷9	110	0,225	4121	927
							○										9÷10	110	0,225	3688	830
							○										10÷12	110	0,225	3185	717
							○										12÷14	110	0,300	2695	808
							○										14÷16	110	0,300	2335	701
							○										16÷18	110	0,375	2061	773
							○										18÷20	110	0,375	1844	691
														○			3÷4	30	0,040	2730	109
														○			4÷5	30	0,040	2123	85
														○			5÷6	30	0,080	1737	139
														○			6÷7	30	0,080	1470	118
														○			7÷8	30	0,080	1274	102
														○			8÷9	30	0,120	1124	135
														○			9÷10	30	0,120	1006	121
														○			10÷12	30	0,120	869	104
														○			12÷14	30	0,160	735	118
														○			14÷16	30	0,160	637	102
														○			16÷18	30	0,200	562	112
														○			18÷20	30	0,200	503	101

● APPLICAZIONE CONSIGLIATA - RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

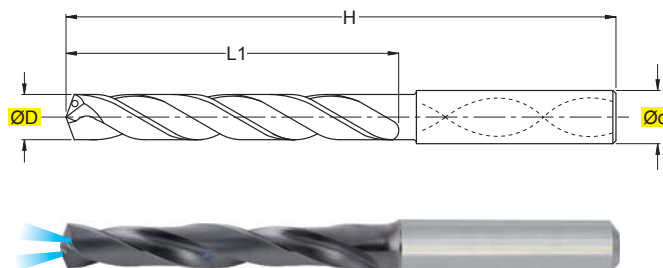
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0551

ØD = 3 - 16

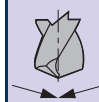
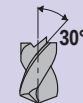


TOLLERANZE
TOLERANCE RANGE

D	d
h7	h5

RIVESTIM.
COATED
TIALN

5xD



DIN
6535

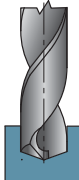


MG

ART.	ØD	Ød	H	L1
SDF0551030	3,00	6	66	28
SDF0551031	3,10	6	66	28
SDF0551032	3,20	6	66	28
SDF0551033	3,30	6	66	28
SDF0551034	3,40	6	66	28
SDF0551035	3,50	6	66	28
SDF0551036	3,60	6	66	28
SDF0551037	3,70	6	66	28
SDF0551038	3,80	6	74	36
SDF0551039	3,90	6	74	36
SDF0551040	4,00	6	74	36
SDF0551041	4,10	6	74	36
SDF0551042	4,20	6	74	36
SDF0551043	4,30	6	74	36
SDF0551044	4,40	6	74	36
SDF0551045	4,50	6	74	36
SDF0551046	4,60	6	74	36
SDF0551047	4,70	6	74	36
SDF0551048	4,80	6	82	44
SDF0551049	4,90	6	82	44
SDF0551050	5,00	6	82	44
SDF0551051	5,10	6	82	44
SDF0551052	5,20	6	82	44
SDF0551053	5,30	6	82	44
SDF0551054	5,40	6	82	44
SDF0551055	5,50	6	82	44
SDF0551056	5,60	6	82	44
SDF0551057	5,70	6	82	44
SDF0551058	5,80	6	82	44
SDF0551059	5,90	6	82	44
SDF0551060	6,00	6	82	44
SDF0551061	6,10	8	91	53
SDF0551062	6,20	8	91	53
SDF0551063	6,30	8	91	53
SDF0551064	6,40	8	91	53
SDF0551065	6,50	8	91	53
SDF0551066	6,60	8	91	53
SDF0551067	6,70	8	91	53
SDF0551068	6,80	8	91	53
SDF0551069	6,90	8	91	53
SDF0551070	7,00	8	91	53
SDF0551071	7,10	8	91	53
SDF0551072	7,20	8	91	53
SDF0551073	7,30	8	91	53
SDF0551074	7,40	8	91	53

ART.	ØD	Ød	H	L1
SDF0551075	7,50	8	91	53
SDF0551076	7,60	8	91	53
SDF0551077	7,70	8	91	53
SDF0551078	7,80	8	91	53
SDF0551079	7,90	8	91	53
SDF0551080	8,00	8	91	53
SDF0551081	8,10	10	103	61
SDF0551082	8,20	10	103	61
SDF0551083	8,30	10	103	61
SDF0551084	8,40	10	103	61
SDF0551085	8,50	10	103	61
SDF0551086	8,60	10	103	61
SDF0551087	8,70	10	103	61
SDF0551088	8,80	10	103	61
SDF0551089	8,90	10	103	61
SDF0551090	9,00	10	103	61
SDF0551091	9,10	10	103	61
SDF0551092	9,20	10	103	61
SDF0551093	9,30	10	103	61
SDF0551094	9,40	10	103	61
SDF0551095	9,50	10	103	61
SDF0551096	9,60	10	103	61
SDF0551097	9,70	10	103	61
SDF0551098	9,80	10	103	61
SDF0551099	9,90	10	103	61
SDF0551100	10,00	10	103	61
SDF0551102	10,20	12	118	71
SDF0551103	10,30	12	118	71
SDF0551105	10,50	12	118	71
SDF0551108	10,80	12	118	71
SDF0551110	11,00	12	118	71
SDF0551112	11,20	12	118	71
SDF0551115	11,50	12	118	71
SDF0551118	11,80	12	118	71
SDF0551120	12,00	12	118	71
SDF0551122	12,20	14	124	77
SDF0551125	12,50	14	124	77
SDF0551128	12,80	14	124	77
SDF0551130	13,00	14	124	77
SDF0551135	13,50	14	124	77
SDF0551138	13,80	14	124	77
SDF0551140	14,00	14	124	77
SDF0551142	14,20	16	133	83
SDF0551145	14,50	16	133	83
SDF0551148	14,80	16	133	83

ART.	ØD	Ød	H	L1
SDF0551150	15,00	16	133	83
SDF0551152	15,20	16	133	83
SDF0551155	15,50	16	133	83
SDF0551158	15,80	16	133	83
SDF0551160	16,00	16	133	83

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	○																(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	○																3÷4	100	0,065	9099	591
	○																4÷5	100	0,085	7077	602
	○																5÷6	100	0,110	5790	637
	○																6÷7	100	0,135	4900	661
	○																7÷8	100	0,160	4246	679
	○																8÷9	100	0,180	3747	674
	○																9÷10	100	0,195	3352	654
	○																10÷12	100	0,215	2895	622
	○																12÷14	100	0,245	2450	600
○																14÷16	100	0,285	2123	605	
	○																3÷4	75	0,035	6824	239
	○																4÷5	75	0,045	5308	239
	○																5÷6	75	0,060	4343	261
	○																6÷7	75	0,070	3675	257
	○																7÷8	75	0,080	3185	255
	○																8÷9	75	0,090	2810	253
	○																9÷10	75	0,100	2514	251
	○																10÷12	75	0,115	2171	250
	○																12÷14	75	0,130	1837	239
	○																14÷16	75	0,150	1592	239
					●												3÷4	80	0,035	7279	255
					●												4÷5	80	0,045	5662	255
					●												5÷6	80	0,060	4632	278
					●												6÷7	80	0,070	3920	274
					●												7÷8	80	0,080	3397	272
					●												8÷9	80	0,090	2997	270
					●												9÷10	80	0,100	2682	268
					●												10÷12	80	0,115	2316	266
					●												12÷14	80	0,130	1960	255
					●												14÷16	80	0,150	1699	255
						○											3÷4	126	0,090	11465	1032
						○											4÷5	126	0,110	8917	981
						○											5÷6	126	0,140	7296	1021
						○											6÷7	126	0,160	6173	988
						○											7÷8	126	0,180	5350	963
						○											8÷9	126	0,225	4721	1062
						○											9÷10	126	0,240	4224	1014
						○											10÷12	126	0,270	3648	985
						○											12÷14	126	0,320	3087	988
						○											14÷16	126	0,340	2675	910
							○										3÷4	105	0,090	9554	860
							○										4÷5	105	0,110	7431	817
							○										5÷6	105	0,140	6080	851
							○										6÷7	105	0,160	5145	823
							○										7÷8	105	0,180	4459	803
							○										8÷9	105	0,225	3934	885
							○										9÷10	105	0,240	3520	845
							○										10÷12	105	0,270	3040	821
							○										12÷14	105	0,320	2572	823
							○										14÷16	105	0,340	2229	758
													○				3÷4	25	0,014	2275	32
													○				4÷5	25	0,022	1769	39
													○				5÷6	25	0,030	1448	43
													○				6÷7	25	0,040	1225	49
													○				7÷8	25	0,050	1062	53
													○				8÷9	25	0,060	937	56
													○				9÷10	25	0,070	838	59
													○				10÷12	25	0,090	724	65
													○				12÷14	25	0,110	612	67
													○				14÷16	25	0,130	531	69

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

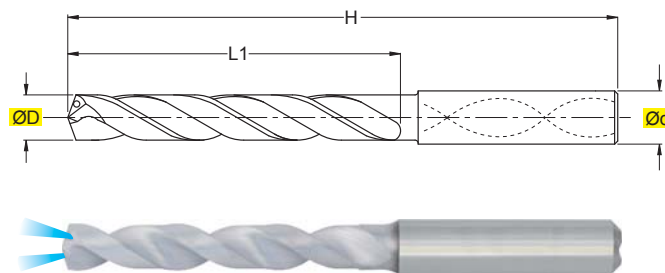
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0511

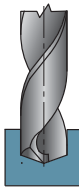
ØD = 3 - 20



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h5

RIVESTIM. COATED TIALN SILVER	5xD
 140°	 38°
 140°	DIN 6535
 140°	MG

(mm)					(mm)					(mm)				
ART.	ØD	Ød	H	L1	ART.	ØD	Ød	H	L1	ART.	ØD	Ød	H	L1
SDF0511030	3,0	6	66	28	SDF0511075	7,5	8	91	53	SDF0511150	15,0	16	133	83
SDF0511031	3,1	6	66	28	SDF0511076	7,6	8	91	53	SDF0511152	15,2	16	133	83
SDF0511032	3,2	6	66	28	SDF0511077	7,7	8	91	53	SDF0511155	15,5	16	133	83
SDF0511033	3,3	6	66	28	SDF0511078	7,8	8	91	53	SDF0511158	15,8	16	133	83
SDF0511034	3,4	6	66	28	SDF0511079	7,9	8	91	53	SDF0511160	16,0	16	133	83
SDF0511035	3,5	6	66	28	SDF0511080	8,0	8	91	53	SDF0511165	16,5	18	143	93
SDF0511036	3,6	6	66	28	SDF0511081	8,1	10	103	61	SDF0511168	16,8	18	143	93
SDF0511037	3,7	6	66	28	SDF0511082	8,2	10	103	61	SDF0511170	17,0	18	143	93
SDF0511038	3,8	6	66	28	SDF0511083	8,3	10	103	61	SDF0511175	17,5	18	143	93
SDF0511039	3,9	6	66	28	SDF0511084	8,4	10	103	61	SDF0511180	18,0	18	143	93
SDF0511040	4,0	6	66	28	SDF0511085	8,5	10	103	61	SDF0511185	18,5	20	153	101
SDF0511041	4,1	6	82	44	SDF0511086	8,6	10	103	61	SDF0511188	18,8	20	153	101
SDF0511042	4,2	6	82	44	SDF0511087	8,7	10	103	61	SDF0511190	19,0	20	153	101
SDF0511043	4,3	6	82	44	SDF0511088	8,8	10	103	61	SDF0511195	19,5	20	153	101
SDF0511044	4,4	6	82	44	SDF0511089	8,9	10	103	61	SDF0511200	20,0	20	153	101
SDF0511045	4,5	6	82	44	SDF0511090	9,0	10	103	61					
SDF0511046	4,6	6	82	44	SDF0511091	9,1	10	103	61					
SDF0511047	4,7	6	82	44	SDF0511092	9,2	10	103	61					
SDF0511048	4,8	6	82	44	SDF0511093	9,3	10	103	61					
SDF0511049	4,9	6	82	44	SDF0511094	9,4	10	103	61					
SDF0511050	5,0	6	82	44	SDF0511095	9,5	10	103	61					
SDF0511051	5,1	6	82	44	SDF0511096	9,6	10	103	61					
SDF0511052	5,2	6	82	44	SDF0511097	9,7	10	103	61					
SDF0511053	5,3	6	82	44	SDF0511098	9,8	10	103	61					
SDF0511054	5,4	6	82	44	SDF0511099	9,9	10	103	61					
SDF0511055	5,5	6	82	44	SDF0511100	10,0	10	103	61					
SDF0511056	5,6	6	82	44	SDF0511102	10,2	12	118	71					
SDF0511057	5,7	6	82	44	SDF0511105	10,5	12	118	71					
SDF0511058	5,8	6	82	44	SDF0511108	10,8	12	118	71					
SDF0511059	5,9	6	82	44	SDF0511110	11,0	12	118	71					
SDF0511060	6,0	6	82	44	SDF0511112	11,2	12	118	71					
SDF0511061	6,1	8	91	53	SDF0511115	11,5	12	118	71					
SDF0511062	6,2	8	91	53	SDF0511118	11,8	12	118	71					
SDF0511063	6,3	8	91	53	SDF0511120	12,0	12	118	71					
SDF0511064	6,4	8	91	53	SDF0511122	12,2	14	124	77					
SDF0511065	6,5	8	91	53	SDF0511125	12,5	14	124	77					
SDF0511066	6,6	8	91	53	SDF0511128	12,8	14	124	77					
SDF0511067	6,7	8	91	53	SDF0511130	13,0	14	124	77					
SDF0511068	6,8	8	91	53	SDF0511132	13,2	14	124	77					
SDF0511069	6,9	8	91	53	SDF0511135	13,5	14	124	77					
SDF0511070	7,0	8	91	53	SDF0511138	13,8	14	124	77					
SDF0511071	7,1	8	91	53	SDF0511140	14,0	14	124	77					
SDF0511072	7,2	8	91	53	SDF0511142	14,2	16	133	83					
SDF0511073	7,3	8	91	53	SDF0511145	14,5	16	133	83					
SDF0511074	7,4	8	91	53	SDF0511148	14,8	16	133	83					

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	○																3÷4	120	0,085	10919	928
	○																4÷5	120	0,105	8493	892
	○																5÷6	120	0,120	6948	834
	○																6÷7	120	0,135	5879	794
	○																7÷8	120	0,150	5096	764
	○																8÷9	120	0,165	4496	742
	○																9÷10	120	0,175	4023	704
	○																10÷12	120	0,200	3474	695
	○																12÷14	120	0,250	2940	735
	○																14÷16	120	0,270	2548	688
	○																16÷18	120	0,290	2248	652
	○																18÷20	120	0,310	2011	624
					○												3÷4	75	0,045	6824	307
					○												4÷5	75	0,060	5308	318
					○												5÷6	75	0,070	4343	304
					○												6÷7	75	0,080	3675	294
					○												7÷8	75	0,090	3185	287
					○												8÷9	75	0,098	2810	275
					○												9÷10	75	0,105	2514	264
					○												10÷12	75	0,115	2171	250
					○												12÷14	75	0,135	1837	248
					○												14÷16	75	0,155	1592	247
					○												16÷18	75	0,165	1405	232
					○												18÷20	75	0,175	1257	220
									●								3÷4	190	0,190	17288	3285
									●								4÷5	190	0,240	13447	3227
									●								5÷6	190	0,250	11002	2750
									●								6÷7	190	0,300	9309	2793
									●								7÷8	190	0,320	8068	2582
									●								8÷9	190	0,350	7119	2492
									●								9÷10	190	0,380	6369	2420
									●								10÷12	190	0,420	5501	2310
									●								12÷14	190	0,450	4655	2095
									●								14÷16	190	0,480	4034	1936
									●								16÷18	190	0,520	3559	1851
									●								18÷20	190	0,580	3185	1847
												●					3÷4	25	0,020	2275	45
												●					4÷5	25	0,030	1769	53
												●					5÷6	25	0,040	1448	58
												●					6÷7	25	0,050	1225	61
												●					7÷8	25	0,060	1062	64
												●					8÷9	25	0,068	937	64
												●					9÷10	25	0,076	838	64
												●					10÷12	25	0,088	724	64
												●					12÷14	25	0,104	612	64
												●					14÷16	25	0,120	531	64
												●					16÷18	25	0,128	468	60
												●					18÷20	25	0,131	419	55
													●				3÷4	30	0,020	2730	55
													●				4÷5	30	0,030	2123	64
													●				5÷6	30	0,040	1737	69
													●				6÷7	30	0,050	1470	73
													●				7÷8	30	0,060	1274	76
													●				8÷9	30	0,068	1124	76
													●				9÷10	30	0,076	1006	76
													●				10÷12	30	0,088	869	76
													●				12÷14	30	0,104	735	76
													●				14÷16	30	0,120	637	76
													●				16÷18	30	0,128	562	72
													●				18÷20	30	0,132	503	66

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

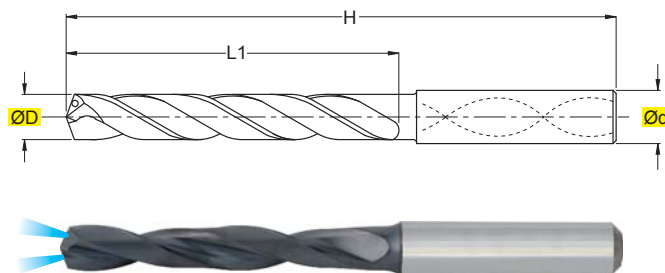
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0505

ØD = 3 - 16

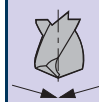
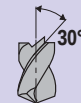


TOLLERANZE
 TOLERANCE RANGE

D	d
h7	h5

RIVESTIM.
 COATED
TIALN

5xD



DIN
 6535

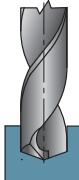


MG

ART.	ØD	Ød	H	L1
SDF0505030	3,0	6	66	28
SDF0505031	3,1	6	66	28
SDF0505032	3,2	6	66	28
SDF0505033	3,3	6	66	28
SDF0505034	3,4	6	66	28
SDF0505035	3,5	6	66	28
SDF0505036	3,6	6	66	28
SDF0505037	3,7	6	66	28
SDF0505038	3,8	6	74	36
SDF0505039	3,9	6	74	36
SDF0505040	4,0	6	74	36
SDF0505041	4,1	6	74	36
SDF0505042	4,2	6	74	36
SDF0505043	4,3	6	74	36
SDF0505044	4,4	6	74	36
SDF0505045	4,5	6	74	36
SDF0505046	4,6	6	74	36
SDF0505047	4,7	6	74	36
SDF0505048	4,8	6	82	44
SDF0505049	4,9	6	82	44
SDF0505050	5,0	6	82	44
SDF0505051	5,1	6	82	44
SDF0505052	5,2	6	82	44
SDF0505053	5,3	6	82	44
SDF0505054	5,4	6	82	44
SDF0505055	5,5	6	82	44
SDF0505056	5,6	6	82	44
SDF0505057	5,7	6	82	44
SDF0505058	5,8	6	82	44
SDF0505059	5,9	6	82	44
SDF0505060	6,0	6	82	44
SDF0505061	6,1	8	91	53
SDF0505062	6,2	8	91	53
SDF0505063	6,3	8	91	53
SDF0505064	6,4	8	91	53
SDF0505065	6,5	8	91	53
SDF0505066	6,6	8	91	53
SDF0505067	6,7	8	91	53
SDF0505068	6,8	8	91	53
SDF0505069	6,9	8	91	53
SDF0505070	7,0	8	91	53
SDF0505071	7,1	8	91	53
SDF0505072	7,2	8	91	53
SDF0505073	7,3	8	91	53
SDF0505074	7,4	8	91	53

ART.	ØD	Ød	H	L1
SDF0505075	7,5	8	91	53
SDF0505076	7,6	8	91	53
SDF0505077	7,7	8	91	53
SDF0505078	7,8	8	91	53
SDF0505079	7,9	8	91	53
SDF0505080	8,0	8	91	53
SDF0505081	8,1	10	103	61
SDF0505082	8,2	10	103	61
SDF0505083	8,3	10	103	61
SDF0505084	8,4	10	103	61
SDF0505085	8,5	10	103	61
SDF0505086	8,6	10	103	61
SDF0505087	8,7	10	103	61
SDF0505088	8,8	10	103	61
SDF0505089	8,9	10	103	61
SDF0505090	9,0	10	103	61
SDF0505091	9,1	10	103	61
SDF0505092	9,2	10	103	61
SDF0505093	9,3	10	103	61
SDF0505094	9,4	10	103	61
SDF0505095	9,5	10	103	61
SDF0505096	9,6	10	103	61
SDF0505097	9,7	10	103	61
SDF0505098	9,8	10	103	61
SDF0505099	9,9	10	103	61
SDF0505100	10,0	10	103	61
SDF0505102	10,2	12	118	71
SDF0505105	10,5	12	118	71
SDF0505108	10,8	12	118	71
SDF0505110	11,0	12	118	71
SDF0505112	11,2	12	118	71
SDF0505115	11,5	12	118	71
SDF0505118	11,8	12	118	71
SDF0505120	12,0	12	118	71
SDF0505122	12,2	14	124	77
SDF0505125	12,5	14	124	77
SDF0505128	12,8	14	124	77
SDF0505130	13,0	14	124	77
SDF0505132	13,2	14	124	77
SDF0505135	13,5	14	124	77
SDF0505138	13,8	14	124	77
SDF0505140	14,0	14	124	77
SDF0505142	14,2	16	133	83
SDF0505145	14,5	16	133	83
SDF0505148	14,8	16	133	83

ART.	ØD	Ød	H	L1
SDF0505150	15,0	16	133	83
SDF0505152	15,2	16	133	83
SDF0505155	15,5	16	133	83
SDF0505158	15,8	16	133	83
SDF0505160	16,0	16	133	83

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	○																3÷4	100	0,090	9099	819
	○																4÷5	100	0,125	7077	885
	○																5÷6	100	0,155	5790	898
	○																6÷7	100	0,165	4900	808
	○																7÷8	100	0,185	4246	786
	○																8÷9	100	0,200	3747	749
	○																9÷10	100	0,215	3352	721
	○																10÷12	100	0,230	2895	666
	○																12÷14	100	0,270	2450	661
	○																14÷16	100	0,310	2123	658
	○																3÷4	60	0,070	5460	382
	○																4÷5	60	0,100	4246	425
	○																5÷6	60	0,130	3474	452
	○																6÷7	60	0,140	2940	412
	○																7÷8	60	0,155	2548	395
	○																8÷9	60	0,170	2248	382
	○																9÷10	60	0,180	2011	362
	○																10÷12	60	0,210	1737	365
	○																12÷14	60	0,230	1470	338
	○																14÷16	60	0,250	1274	318
	●						●										3÷4	160	0,135	14559	1965
	●						●										4÷5	160	0,165	11323	1868
	●						●										5÷6	160	0,190	9265	1760
	●						●										6÷7	160	0,210	7839	1646
	●						●										7÷8	160	0,250	6794	1699
	●						●										8÷9	160	0,280	5995	1679
	●						●										9÷10	160	0,300	5364	1609
	●						●										10÷12	160	0,320	4632	1482
	●						●										12÷14	160	0,350	3920	1372
	●						●										14÷16	160	0,390	3397	1325
	●						●										3÷4	120	0,135	10919	1474
	●						●										4÷5	120	0,165	8493	1401
	●						●										5÷6	120	0,190	6948	1320
	●						●										6÷7	120	0,210	5879	1235
	●						●										7÷8	120	0,250	5096	1274
	●						●										8÷9	120	0,280	4496	1259
	●						●										9÷10	120	0,300	4023	1207
	●						●										10÷12	120	0,320	3474	1112
	●						●										12÷14	120	0,350	2940	1029
	●						●										14÷16	120	0,390	2548	994
		</																			

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

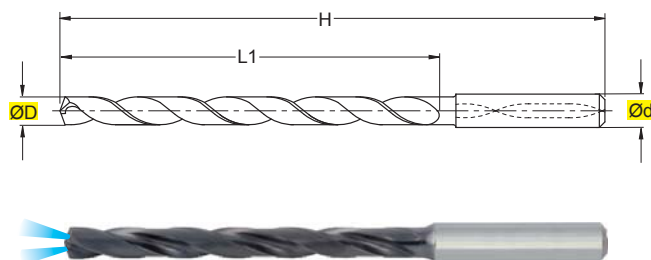
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF0802

ØD = 3 - 16

NEW

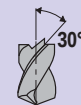


TOLLERANZE
TOLERANCE RANGE

D	d
m7	h6

RIVESTIM.
COATED
TIALN

8xD



DIN
6535



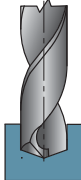
MG

ART.	ØD	Ød	H	L1
SDF0802030	3,0	6	74	34
SDF0802031	3,1	6	74	34
SDF0802032	3,2	6	74	34
SDF0802033	3,3	6	74	34
SDF0802034	3,4	6	74	34
SDF0802035	3,5	6	74	34
SDF0802036	3,6	6	74	34
SDF0802037	3,7	6	74	34
SDF0802038	3,8	6	85	45
SDF0802039	3,9	6	85	45
SDF0802040	4,0	6	85	45
SDF0802041	4,1	6	85	45
SDF0802042	4,2	6	85	45
SDF0802043	4,3	6	85	45
SDF0802044	4,4	6	85	45
SDF0802045	4,5	6	85	45
SDF0802046	4,6	6	85	45
SDF0802047	4,7	6	85	45
SDF0802048	4,8	6	97	57
SDF0802049	4,9	6	97	57
SDF0802050	5,0	6	97	57
SDF0802051	5,1	6	97	57
SDF0802052	5,2	6	97	57
SDF0802053	5,3	6	97	57
SDF0802054	5,4	6	97	57
SDF0802055	5,5	6	97	57
SDF0802056	5,6	6	97	57
SDF0802057	5,7	6	97	57
SDF0802058	5,8	6	97	57
SDF0802059	5,9	6	97	57
* SDF0802060	6,0	6	97	57
SDF0802061	6,1	8	106	66
SDF0802062	6,2	8	106	66
SDF0802063	6,3	8	106	66
SDF0802064	6,4	8	106	66
SDF0802065	6,5	8	106	66
SDF0802066	6,6	8	106	66
SDF0802067	6,7	8	106	66
SDF0802068	6,8	8	106	66
SDF0802069	6,9	8	106	66
SDF0802070	7,0	8	106	66
SDF0802071	7,1	8	116	76
SDF0802072	7,2	8	116	76
SDF0802073	7,3	8	116	76
SDF0802074	7,4	8	116	76

ART.	ØD	Ød	H	L1
SDF0802075	7,5	8	116	76
SDF0802076	7,6	8	116	76
SDF0802077	7,7	8	116	76
SDF0802078	7,8	8	116	76
SDF0802079	7,9	8	116	76
* SDF0802080	8,0	8	116	76
SDF0802081	8,1	10	139	95
SDF0802082	8,2	10	139	95
SDF0802083	8,3	10	139	95
SDF0802084	8,4	10	139	95
SDF0802085	8,5	10	139	95
SDF0802086	8,6	10	139	95
SDF0802087	8,7	10	139	95
SDF0802088	8,8	10	139	95
SDF0802089	8,9	10	139	95
SDF0802090	9,0	10	139	95
SDF0802091	9,1	10	139	95
SDF0802092	9,2	10	139	95
SDF0802093	9,3	10	139	95
SDF0802094	9,4	10	139	95
SDF0802095	9,5	10	139	95
SDF0802096	9,6	10	139	95
SDF0802097	9,7	10	139	95
SDF0802098	9,8	10	139	95
SDF0802099	9,9	10	139	95
* SDF0802100	10,0	10	139	95
SDF0802101	10,1	12	163	114
SDF0802102	10,2	12	163	114
SDF0802103	10,3	12	163	114
SDF0802104	10,4	12	163	114
SDF0802105	10,5	12	163	114
SDF0802106	10,6	12	163	114
SDF0802107	10,7	12	163	114
SDF0802108	10,8	12	163	114
SDF0802109	10,9	12	163	114
SDF0802110	11,0	12	163	114
SDF0802111	11,1	12	163	114
SDF0802112	11,2	12	163	114
SDF0802113	11,3	12	163	114
SDF0802114	11,4	12	163	114
SDF0802115	11,5	12	163	114
SDF0802116	11,6	12	163	114
SDF0802117	11,7	12	163	114
SDF0802118	11,8	12	163	114
SDF0802119	11,9	12	163	114

ART.	ØD	Ød	H	L1
* SDF0802120	12,0	12	163	114
SDF0802125	12,5	14	182	133
SDF0802128	12,8	14	178	133
SDF0802130	13,0	14	182	133
SDF0802135	13,5	14	182	133
SDF0802138	13,8	14	178	133
* SDF0802140	14,0	14	182	133
SDF0802145	14,5	16	204	152
SDF0802148	14,8	16	203	152
SDF0802150	15,0	16	204	152
SDF0802155	15,5	16	203	152
SDF0802158	15,8	16	203	152
* SDF0802160	16,0	16	204	152

* = COSTRUITI IN TOLLERANZA h7
 * = MADE WITH h7 TOLERANCE
 * = GEBAUT MIT TOLERANZ h7
 * = RÉALISÉS EN TOLÉRANCE h7

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73				
		P				M	K			N			S	H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE							
	●															3÷4	85	0,050	7734	387	
	●															4÷5	85	0,080	6016	481	
	●															5÷6	85	0,110	4922	541	
	●															6÷7	85	0,130	4165	541	
	●															7÷8	85	0,150	3609	541	
	●															8÷9	85	0,170	3185	541	
	●															9÷10	85	0,190	2849	541	
	●															10÷11	85	0,200	2707	541	
	●															11÷12	85	0,210	2461	517	
	●															12÷13	85	0,220	2256	496	
	●															13÷14	85	0,230	2082	479	
	●															14÷15	85	0,240	1934	464	
●															15÷16	85	0,250	1805	451		
	●															3÷4	75	0,035	6824	239	
	●															4÷5	75	0,045	5308	239	
	●															5÷6	75	0,060	4343	261	
	●															6÷7	75	0,075	3675	276	
	●															7÷8	75	0,085	3185	271	
	●															8÷9	75	0,095	2810	267	
	●															9÷10	75	0,105	2514	264	
	●															10÷11	75	0,110	2275	250	
	●															11÷12	75	0,115	2077	239	
	●															12÷13	75	0,120	1911	229	
	●															13÷14	75	0,130	1769	230	
	●															14÷15	75	0,140	1647	231	
	●															15÷16	75	0,150	1541	231	
	●															3÷4	55	0,035	5005	175	
	●															4÷5	55	0,045	3892	175	
	●															5÷6	55	0,060	3185	191	
	●															6÷7	55	0,075	2695	202	
	●															7÷8	55	0,085	2335	199	
	●															8÷9	55	0,095	2061	196	
	●															9÷10	55	0,105	1844	194	
	●															10÷11	55	0,110	1668	184	
	●															11÷12	55	0,115	1523	175	
	●															12÷13	55	0,120	1401	168	
	●															13÷14	55	0,130	1297	169	
	●															14÷15	55	0,140	1208	169	
	●															15÷16	55	0,150	1130	170	
	●															3÷4	50	0,035	4550	159	
	●															4÷5	50	0,045	3539	159	
	●															5÷6	50	0,060	2895	174	
	●															6÷7	50	0,075	2450	184	
	●															7÷8	50	0,085	2123	180	
	●															8÷9	50	0,095	1873	178	
	●															9÷10	50	0,105	1676	176	
	●															10÷11	50	0,110	1517	167	
	●															11÷12	50	0,115	1385	159	
	●															12÷13	50	0,120	1274	153	
	●															13÷14	50	0,120	1180	142	
	●															14÷15	50	0,125	1098	137	
	●															15÷16	50	0,125	1027	128	
	●															3÷4	80	0,075	7279	546	
	●															4÷5	80	0,100	5662	566	
	●															5÷6	80	0,130	4632	602	
	●															6÷7	80	0,150	3920	588	
	●															7÷8	80	0,170	3397	577	
	●															8÷9	80	0,190	2997	570	
	●															9÷10	80	0,215	2682	577	
	●															10÷11	80	0,230	2548	586	
	●															11÷12	80	0,255	2316	591	
	●															12÷13	80	0,280	2123	594	
	●															13÷14	80	0,290	1960	568	
	●															14÷15	80	0,300	1820	546	
	●															15÷16	80	0,310	1699	527	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

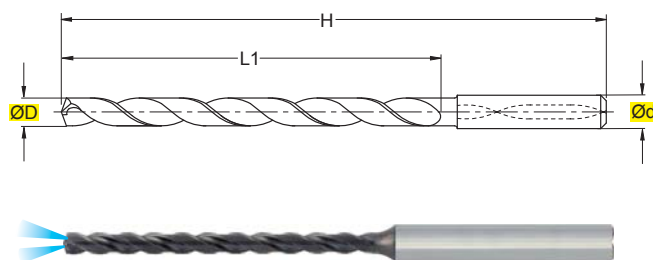
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF1201

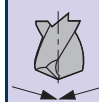
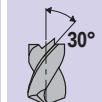
ØD = 3 - 16



TOLLERANZE	D	d
TOLERANCE RANGE	h7	h6

RIVESTIM.
COATED
TIALN

12xD

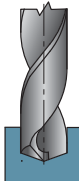


DIN
6535



MG

(mm)					(mm)					(mm)				
ART.	ØD	Ød	H	L1	ART.	ØD	Ød	H	L1	ART.	ØD	Ød	H	L1
SDF1201030	3,0	6	92	54	SDF1201075	7,5	8	146	108	SDF1201120	12,0	12	204	156
SDF1201031	3,1	6	92	54	SDF1201076	7,6	8	146	108	SDF1201125	12,5	14	230	182
SDF1201032	3,2	6	92	54	SDF1201077	7,7	8	146	108	SDF1201128	12,8	14	230	182
SDF1201033	3,3	6	92	54	SDF1201078	7,8	8	146	108	SDF1201130	13,0	14	230	182
SDF1201034	3,4	6	92	54	SDF1201079	7,9	8	146	108	SDF1201135	13,5	14	230	182
SDF1201035	3,5	6	92	54	SDF1201080	8,0	8	146	108	SDF1201138	13,8	14	230	182
SDF1201036	3,6	6	92	54	SDF1201081	8,1	10	162	120	SDF1201140	14,0	14	230	182
SDF1201037	3,7	6	92	54	SDF1201082	8,2	10	162	120	SDF1201145	14,5	16	260	208
SDF1201038	3,8	6	102	64	SDF1201083	8,3	10	162	120	SDF1201148	14,8	16	260	208
SDF1201039	3,9	6	102	64	SDF1201084	8,4	10	162	120	SDF1201150	15,0	16	260	208
SDF1201040	4,0	6	102	64	SDF1201085	8,5	10	162	120	SDF1201155	15,5	16	260	208
SDF1201041	4,1	6	102	64	SDF1201086	8,6	10	162	120	SDF1201158	15,8	16	260	208
SDF1201042	4,2	6	102	64	SDF1201087	8,7	10	162	120	SDF1201160	16,0	16	260	208
SDF1201043	4,3	6	102	64	SDF1201088	8,8	10	162	120					
SDF1201044	4,4	6	102	64	SDF1201089	8,9	10	162	120					
SDF1201045	4,5	6	102	64	SDF1201090	9,0	10	162	120					
SDF1201046	4,6	6	102	64	SDF1201091	9,1	10	162	120					
SDF1201047	4,7	6	102	64	SDF1201092	9,2	10	162	120					
SDF1201048	4,8	6	116	78	SDF1201093	9,3	10	162	120					
SDF1201049	4,9	6	116	78	SDF1201094	9,4	10	162	120					
SDF1201050	5,0	6	116	78	SDF1201095	9,5	10	162	120					
SDF1201051	5,1	6	116	78	SDF1201096	9,6	10	162	120					
SDF1201052	5,2	6	116	78	SDF1201097	9,7	10	162	120					
SDF1201053	5,3	6	116	78	SDF1201098	9,8	10	162	120					
SDF1201054	5,4	6	116	78	SDF1201099	9,9	10	162	120					
SDF1201055	5,5	6	116	78	SDF1201100	10,0	10	162	120					
SDF1201056	5,6	6	116	78	SDF1201101	10,1	12	204	156					
SDF1201057	5,7	6	116	78	SDF1201102	10,2	12	204	156					
SDF1201058	5,8	6	116	78	SDF1201103	10,3	12	204	156					
SDF1201059	5,9	6	116	78	SDF1201104	10,4	12	204	156					
SDF1201060	6,0	6	116	78	SDF1201105	10,5	12	204	156					
SDF1201061	6,1	8	146	108	SDF1201106	10,6	12	204	156					
SDF1201062	6,2	8	146	108	SDF1201107	10,7	12	204	156					
SDF1201063	6,3	8	146	108	SDF1201108	10,8	12	204	156					
SDF1201064	6,4	8	146	108	SDF1201109	10,9	12	204	156					
SDF1201065	6,5	8	146	108	SDF1201110	11,0	12	204	156					
SDF1201066	6,6	8	146	108	SDF1201111	11,1	12	204	156					
SDF1201067	6,7	8	146	108	SDF1201112	11,2	12	204	156					
SDF1201068	6,8	8	146	108	SDF1201113	11,3	12	204	156					
SDF1201069	6,9	8	146	108	SDF1201114	11,4	12	204	156					
SDF1201070	7,0	8	146	108	SDF1201115	11,5	12	204	156					
SDF1201071	7,1	8	146	108	SDF1201116	11,6	12	204	156					
SDF1201072	7,2	8	146	108	SDF1201117	11,7	12	204	156					
SDF1201073	7,3	8	146	108	SDF1201118	11,8	12	204	156					
SDF1201074	7,4	8	146	108	SDF1201119	11,9	12	204	156					

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73				
		P				M	K			N			S	H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE							
	●	●														3÷4	80	0,050	7279	364	
	●	●														4÷5	80	0,080	5662	453	
	●	●														5÷6	80	0,110	4632	510	
	●	●														6÷7	80	0,130	3920	510	
	●	●														7÷8	80	0,150	3397	510	
	●	●														8÷9	80	0,170	2997	510	
	●	●														9÷10	80	0,190	2682	510	
	●	●														10÷11	80	0,200	2548	510	
	●	●														11÷12	80	0,210	2316	486	
	●	●														12÷13	80	0,220	2123	467	
	●	●														13÷14	80	0,230	1960	451	
	●	●														14÷15	80	0,240	1820	437	
	●	●														15÷16	80	0,250	1699	425	
		●															3÷4	50	0,035	4550	159
		●															4÷5	50	0,045	3539	159
	●															5÷6	50	0,060	2895	174	
	●															6÷7	50	0,075	2450	184	
	●															7÷8	50	0,085	2123	180	
	●															8÷9	50	0,095	1873	178	
	●															9÷10	50	0,105	1676	176	
	●															10÷11	50	0,110	1592	175	
	●															11÷12	50	0,115	1448	166	
	●															12÷13	50	0,120	1327	159	
	●															13÷14	50	0,130	1225	159	
	●															14÷15	50	0,140	1137	159	
	●															15÷16	50	0,150	1062	159	
		●														3÷4	30	0,035	2730	96	
		●														4÷5	30	0,045	2123	96	
		●														5÷6	30	0,060	1737	104	
		●														6÷7	30	0,075	1470	110	
		●														7÷8	30	0,085	1274	108	
		●														8÷9	30	0,095	1124	107	
		●														9÷10	30	0,105	1006	106	
		●														10÷11	30	0,110	955	105	
		●														11÷12	30	0,115	869	100	
		●														12÷13	30	0,120	796	96	
		●														13÷14	30	0,130	735	96	
		●														14÷15	30	0,140	682	96	
		●														15÷16	30	0,150	637	96	
			●													3÷4	50	0,035	4550	159	
			●													4÷5	50	0,045	3539	159	
			●													5÷6	50	0,060	2895	174	
			●													6÷7	50	0,075	2450	184	
			●													7÷8	50	0,085	2123	180	
			●													8÷9	50	0,095	1873	178	
			●													9÷10	50	0,105	1676	176	
			●													10÷11	50	0,110	1517	167	
			●													11÷12	50	0,115	1385	159	
			●													12÷13	50	0,120	1274	153	
			●													13÷14	50	0,120	1180	142	
			●													14÷15	50	0,125	1098	137	
			●													15÷16	50	0,125	1027	128	
				●		●										3÷4	75	0,075	6824	512	
				●		●										4÷5	75	0,100	5308	531	
				●		●										5÷6	75	0,130	4343	565	
				●		●										6÷7	75	0,150	3675	551	
				●		●										7÷8	75	0,170	3185	541	
				●		●										8÷9	75	0,190	2810	534	
				●		●										9÷10	75	0,215	2514	541	
				●		●										10÷11	75	0,230	2389	549	
				●		●										11÷12	75	0,255	2171	554	
				●		●										12÷13	75	0,280	1990	557	
				●		●										13÷14	75	0,290	1837	533	
				●		●										14÷15	75	0,300	1706	512	
				●		●										15÷16	75	0,310	1592	494	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

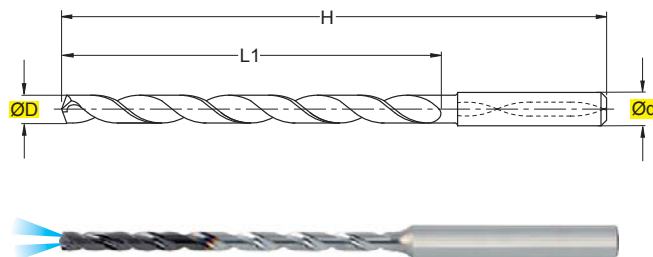
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF1601

ØD = 3 - 12

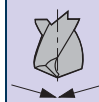
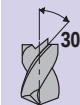


TOLLERANZE
TOLERANCE RANGE

D	d
h7	h5

RIVESTIM.
COATED
TIALN

16xD



DIN
6535



MG

ART.	ØD	Ød	H	L1
SDF1601030	3,0	6	100	60
SDF1601032	3,2	6	100	60
SDF1601033	3,3	6	100	60
SDF1601035	3,5	6	100	60
SDF1601038	3,8	6	115	75
SDF1601040	4,0	6	115	75
SDF1601042	4,2	6	115	75
SDF1601045	4,5	6	130	90
SDF1601048	4,8	6	130	90
SDF1601050	5,0	6	130	90
SDF1601055	5,5	6	150	108
SDF1601058	5,8	6	150	108
SDF1601060	6,0	6	150	108
SDF1601065	6,5	8	165	125
SDF1601068	6,8	8	165	125
SDF1601070	7,0	8	165	125
SDF1601075	7,5	8	180	140
SDF1601078	7,8	8	180	140
SDF1601080	8,0	8	180	140
SDF1601085	8,5	10	205	160
SDF1601088	8,8	10	205	160
SDF1601090	9,0	10	205	160
SDF1601098	9,8	10	225	180
SDF1601100	10,0	10	225	180
SDF1601102	10,2	12	240	190
SDF1601108	10,8	12	240	190
SDF1601118	11,8	12	265	215
SDF1601120	12,0	12	265	215

PRIMA DELL'UTILIZZO DELLA PUNTA
LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE
ART. SDF0371 PAG C 32

BEFORE USING THE DRILL READ THE
TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE
THE PRE-BORE

VOR DEM GEBRAUCH SIEHE DIE
HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE
C 32 VERWENDEN

AVANT D'UTILISER LA POINTE, LIRE LES
CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TRou,
UTILISER ART. SDF0371 PAGE C 32

Applicazione - Application

MATERIALI - MATERIALS															Pag. H 73					
P					M	K			N			S	H	G						
ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
●																3÷4	105	0,070	9554	669
●																4÷5	105	0,090	7431	669
●																5÷6	105	0,110	6080	669
●																6÷7	105	0,125	5145	643
●																7÷8	105	0,140	4459	624
●																8÷9	105	0,160	3934	629
●																9÷10	105	0,185	3412	631
●																10÷12	105	0,200	3096	619
	●															3÷4	80	0,050	7279	364
	●															4÷5	80	0,065	5662	368
	●															5÷6	80	0,075	4632	347
	●															6÷7	80	0,090	3920	353
	●															7÷8	80	0,110	3397	374
	●															8÷9	80	0,125	2997	375
	●															9÷10	80	0,140	2600	364
	●															10÷12	80	0,150	2359	354
					●											3÷4	50	0,035	4550	159
					●											4÷5	50	0,045	3539	159
					●											5÷6	50	0,060	2895	174
					●											6÷7	50	0,075	2450	184
					●											7÷8	50	0,085	2123	180
					●											8÷9	50	0,095	1873	178
					●											9÷10	50	0,105	1625	171
					●											10÷12	50	0,115	1474	170
						●										3÷4	120	0,110	10919	1201
					●											4÷5	120	0,140	8493	1189
					●											5÷6	120	0,170	6948	1181
					●											6÷7	120	0,215	5879	1264
					●											7÷8	120	0,245	5096	1248
					●											8÷9	120	0,280	4496	1259
					●											9÷10	120	0,300	4023	1207
					●											10÷12	120	0,320	3474	1112
						●										3÷4	100	0,110	9099	1001
						●										4÷5	100	0,140	7077	991
						●										5÷6	100	0,170	5790	984
						●										6÷7	100	0,215	4900	1053
						●										7÷8	100	0,245	4246	1040
						●										8÷9	100	0,280	3747	1049
						●										9÷10	100	0,300	3250	975
						●										10÷12	100	0,320	2949	944

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

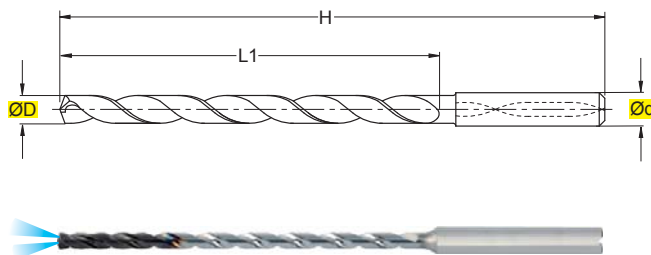
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF2001

$\varnothing D = 2 - 12$

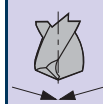
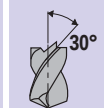


TOLLERANZE
TOLERANCE RANGE

D	d
h7	h5

RIVESTIM.
COATED
TIALN

20xD



DIN
6535



MG

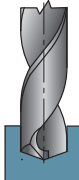
ART.	(mm)			
ART.	ØD	Ød	H	L1
SDF2001020	2,0	4	92	50
SDF2001022	2,2	4	92	50
SDF2001023	2,3	4	92	50
SDF2001024	2,4	4	112	70
SDF2001025	2,5	4	112	70
SDF2001027	2,7	4	112	70
SDF2001028	2,8	4	112	70
SDF2001030	3,0	6	120	80
SDF2001032	3,2	6	120	80
SDF2001033	3,3	6	120	80
SDF2001035	3,5	6	120	80
SDF2001038	3,8	6	130	90
SDF2001040	4,0	6	130	90
SDF2001042	4,2	6	160	110
SDF2001045	4,5	6	160	110
SDF2001048	4,8	6	160	120
SDF2001050	5,0	6	160	120
SDF2001055	5,5	6	185	140
SDF2001058	5,8	6	185	140
SDF2001060	6,0	6	185	140
SDF2001065	6,5	8	210	160
SDF2001068	6,8	8	210	160
SDF2001070	7,0	8	210	160
SDF2001075	7,5	8	230	180
SDF2001078	7,8	8	230	180
SDF2001080	8,0	8	230	180
SDF2001085	8,5	10	260	195
SDF2001088	8,8	10	290	230
SDF2001090	9,0	10	290	230
SDF2001098	9,8	10	290	230
SDF2001100	10,0	10	290	230
SDF2001102	10,2	12	315	268
SDF2001108	10,8	12	315	268
SDF2001118	11,8	12	315	268
SDF2001120	12,0	12	315	268

ITALY -PRIMA DELL'UTILIZZO DELLA PUNTA
LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE
ART. SDF0371 PAG C 32

ENGLAND -BEFORE USING THE DRILL READ THE
TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE
THE PRE-BORE

GERMANY -VOR DEM GEBRAUCH SIEHE DIE
HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE
C 32 VERWENDEN

FRANCE -AVANT D'UTILISER LA POINTE, LIRE LES
CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TRON,
UTILISER ART. SDF0371 PAGE C 32

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●																2÷3	105	0,050	13376	669
	●																3÷4	105	0,070	9554	669
	●																4÷5	105	0,090	7431	669
	●																5÷6	105	0,110	6080	669
	●																6÷7	105	0,125	5145	643
	●																7÷8	105	0,140	4459	624
	●																8÷9	105	0,160	3934	629
	●																9÷10	105	0,185	3412	631
	●																10÷12	105	0,200	3096	619
	●																2÷3	80	0,035	10191	357
	●																3÷4	80	0,050	7279	364
	●																4÷5	80	0,065	5662	368
	●																5÷6	80	0,075	4632	347
	●																6÷7	80	0,090	3920	353
	●																7÷8	80	0,110	3397	374
	●																8÷9	80	0,125	2997	375
	●																9÷10	80	0,140	2600	364
	●																10÷12	80	0,150	2359	354
					●												2÷3	50	0,025	6369	159
					●												3÷4	50	0,035	4550	159
					●												4÷5	50	0,045	3539	159
					●												5÷6	50	0,060	2895	174
					●												6÷7	50	0,075	2450	184
					●												7÷8	50	0,085	2123	180
					●												8÷9	50	0,095	1873	178
					●												9÷10	50	0,105	1625	171
					●												10÷12	50	0,115	1474	170
						●											2÷3	120	0,075	15287	1146
						●											3÷4	120	0,110	10919	1201
						●											4÷5	120	0,140	8493	1189
						●											5÷6	120	0,170	6948	1181
						●											6÷7	120	0,215	5879	1264
						●											7÷8	120	0,245	5096	1248
						●											8÷9	120	0,280	4496	1259
						●											9÷10	120	0,300	4023	1207
						●											10÷12	120	0,320	3474	1112
							●										2÷3	100	0,075	12739	955
							●										3÷4	100	0,110	9099	1001
							●										4÷5	100	0,140	7077	991
							●										5÷6	100	0,170	5790	984
							●										6÷7	100	0,215	4900	1053
							●										7÷8	100	0,245	4246	1040
							●										8÷9	100	0,280	3747	1049
							●										9÷10	100	0,300	3250	975
							●										10÷12	100	0,320	2949	944

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

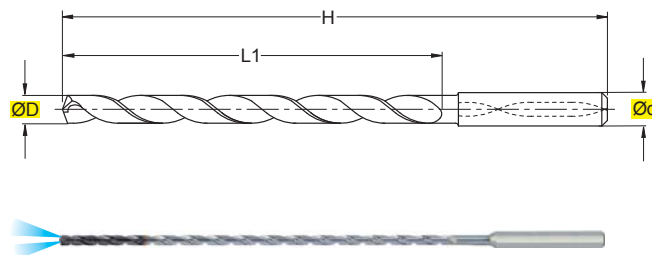
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SDF3001

$\varnothing D = 2 - 12$

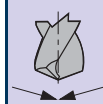
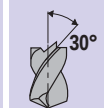


TOLLERANZE
TOLERANCE RANGE

D	d
h7	h5

RIVESTIM.
COATED
TIALN

30xD



DIN
6535



MG

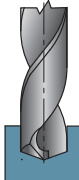
ART.	ØD	Ød	H	L1
SDF3001020	2,0	4	115	70
SDF3001022	2,2	4	115	70
SDF3001023	2,3	4	115	70
SDF3001024	2,4	4	138	90
SDF3001025	2,5	4	138	90
SDF3001027	2,7	4	138	90
SDF3001028	2,8	4	138	90
SDF3001030	3,0	6	150	105
SDF3001032	3,2	6	150	105
SDF3001033	3,3	6	185	135
SDF3001035	3,5	6	185	135
SDF3001038	3,8	6	185	135
SDF3001040	4,0	6	185	135
SDF3001042	4,2	6	185	135
SDF3001045	4,5	6	215	165
SDF3001048	4,8	6	215	165
SDF3001050	5,0	6	215	165
SDF3001055	5,5	6	230	180
SDF3001058	5,8	6	230	180
SDF3001060	6,0	6	230	180
SDF3001065	6,5	8	280	215
SDF3001068	6,8	8	280	230
SDF3001070	7,0	8	280	230
SDF3001075	7,5	8	280	230
SDF3001078	7,8	8	315	265
SDF3001080	8,0	8	315	265
SDF3001085	8,5	10	350	295
SDF3001088	8,8	10	380	330
SDF3001090	9,0	10	380	330
SDF3001098	9,8	10	380	330
SDF3001100	10,0	10	380	330
SDF3001102	10,2	12	430	380
SDF3001108	10,8	12	430	380
SDF3001118	11,8	12	430	380
SDF3001120	12,0	12	430	380

PRIMA DELL'UTILIZZO DELLA PUNTA
LEGGERE GLI ACCORGIMENTI DI PAG H 31
-PER ESEGUIRE IL PREFORO UTILIZZARE
ART. SDF0371 PAG C 32

BEFORE USING THE DRILL READ THE
TIPS ON PAGE H 31
-USE ART. SDF0371 PAGE C 32 TO MAKE
THE PRE-BORE

VOR DEM GEBRAUCH SIEHE DIE
HINWEISE AUF SEITE H 31
-ZUM VORBOHREN ART. SDF0371, SEITE
C 32 VERWENDEN

AVANT D'UTILISER LA POINTE, LIRE LES
CONSIGNES DE PAGE H 31
-POUR EXECUTER LE PRE-TRou,
UTILISER ART. SDF0371 PAGE C 32

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●																2÷3	90	0,050	11465	573
	●																3÷4	90	0,070	8189	573
	●																4÷5	90	0,090	6369	573
	●																5÷6	90	0,110	5211	573
	●																6÷7	90	0,125	4410	551
	●																7÷8	90	0,140	3822	535
	●																8÷9	90	0,160	3372	540
	●																9÷10	90	0,185	2925	541
	●																10÷12	90	0,200	2654	531
	●																2÷3	70	0,035	8917	312
	●																3÷4	70	0,050	6369	318
	●																4÷5	70	0,065	4954	322
	●																5÷6	70	0,075	4053	304
	●																6÷7	70	0,090	3430	309
	●																7÷8	70	0,110	2972	327
	●																8÷9	70	0,125	2623	328
	●																9÷10	70	0,140	2275	318
	●																10÷12	70	0,150	2064	310
					●												2÷3	45	0,025	5732	143
					●												3÷4	45	0,035	4095	143
					●												4÷5	45	0,045	3185	143
					●												5÷6	45	0,060	2606	156
					●												6÷7	45	0,075	2205	165
					●												7÷8	45	0,085	1911	162
					●												8÷9	45	0,095	1686	160
					●												9÷10	45	0,105	1462	154
					●												10÷12	45	0,115	1327	153
						●											2÷3	102	0,075	12994	975
						●											3÷4	102	0,110	9281	1021
						●											4÷5	102	0,140	7219	1011
						●											5÷6	102	0,170	5906	1004
						●											6÷7	102	0,215	4998	1074
						●											7÷8	102	0,245	4331	1061
						●											8÷9	102	0,280	3822	1070
						●											9÷10	102	0,300	3419	1026
						●											10÷12	102	0,320	2953	945
							●										2÷3	85	0,075	10828	812
							●										3÷4	85	0,110	7734	851
							●										4÷5	85	0,140	6016	842
							●										5÷6	85	0,170	4922	837
							●										6÷7	85	0,215	4165	895
							●										7÷8	85	0,245	3609	884
							●										8÷9	85	0,280	3185	892
							●										9÷10	85	0,300	2762	829
							●										10÷12	85	0,320	2506	802

NEL CASO DI FORI PASSANTI RIDURRE L'AVANZAMENTO IN USCITA DEL 40%
IN CASE OF THROUGH BORES REDUCE EXIT FEED BY 40%

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

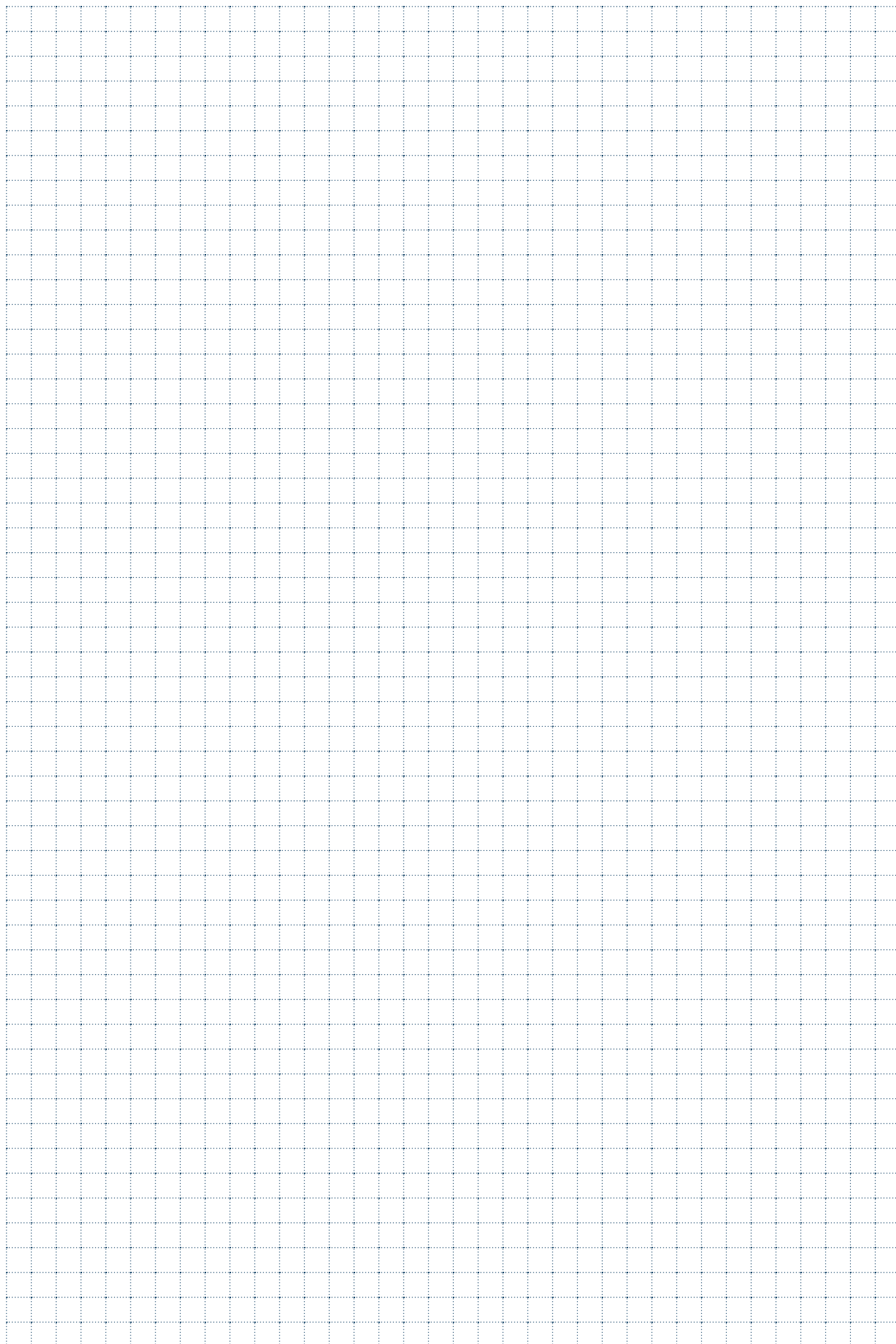
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED



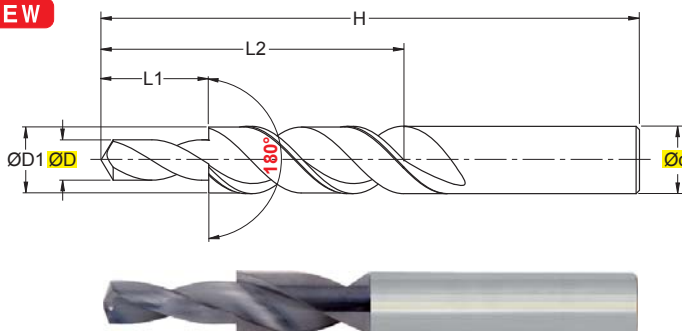


PUNTE A GRADINO

STEP DRILLS / STUFENBOHRER / POINTES A GRADIN /
PUNTAS ESCALÓN

GENERIC / ALL PURPOSE

NEW



 **DISPONIBILE DA
SETTEMBRE 2014**

 **AVAILABLE FROM
SEPTEMBER 2014**

 **AB SEPTEMBER 2014
LIEFERBAR**

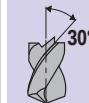
 **DISPONIBILE À PARTIR
DE SEPTEMBRE 2014**

> COUNTER SINK 180°
> SFOR HEAD SCREW DIN 84-912-6912-7513-7984

(mm)						
ART.	ØD	ød	ØD1	H	L1	L2
SDN0102030	3,4	6	6	66	9	28
SDN0102040	4,5	8	8	80	11	37
SDN0102050	5,5	10	10	89	13	43
SDN0102060	6,6	12	11	95	15	47
SDN0102080	9,0	16	15	110	19	56
SDN0102100	11,0	18	18	123	23	62

RIVESTIM.
COATED.

TIALN



MG

[illegible]

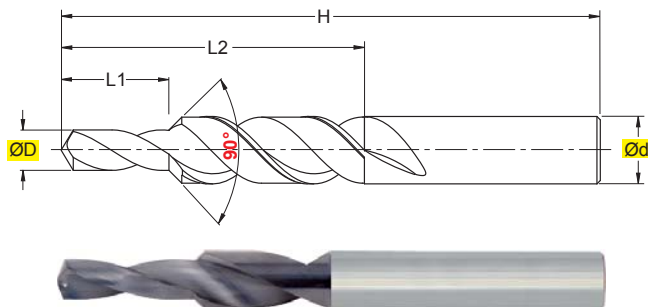
- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

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

SDR0102

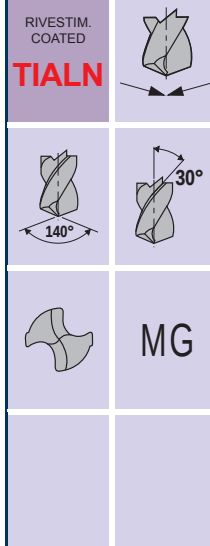
GENERICO / ALL PURPOSE

$\varnothing D = 2,5 - 14$

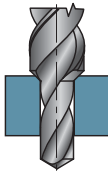


> ANGOLO DI SVASATURA 90°
 > RIVESTIMENTO TIALN

> CHAMFER 90°
 > TIALN COATED



(mm)					
ART.	ØD	Ød	H	L1	L2
SDR0102030	2,5	6	66	8,8	20
SDR0102040	3,3	6	66	11,4	24
SDR0102050	4,2	6	66	13,6	28
SDR0102060	5,0	8	79	16,5	34
SDR0102080	6,8	10	89	21,0	47
SDR0102100	8,5	12	102	25,5	55
SDR0102120	10,2	14	107	30,0	60
SDR0102140	12,0	16	115	34,5	65
SDR0102160	14,0	18	123	38,5	73

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAMME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●																(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf
	●																2,5	80	0,100	10191	1019
	●																3,3	80	0,180	7721	1390
	●																4,2	80	0,180	6066	1092
	●																5,0	80	0,240	5096	1223
	●																6,8	80	0,240	3747	899
	●																8,5	80	0,300	2997	899
	●																10,2	80	0,300	2498	749
	●																12,0	80	0,350	2123	743
	●																14,0	80	0,350	1820	637
	●																2,5	50	0,080	6369	510
	●																3,3	50	0,150	4825	724
	●																4,2	50	0,150	3791	569
	●																5,0	50	0,210	3185	669
	●																6,8	50	0,210	2342	492
	●																8,5	50	0,270	1873	506
	●																10,2	50	0,270	1561	422
	●																12,0	50	0,320	1327	425
	●																14,0	50	0,320	1137	364
							●										2,5	75	0,150	9554	1433
							●										3,3	75	0,230	7238	1665
							●										4,2	75	0,230	5687	1308
							●										5,0	75	0,335	4777	1600
							●										6,8	75	0,335	3513	1177
							●										8,5	75	0,425	2810	1194
							●										10,2	75	0,425	2342	995
							●										12,0	75	0,520	1990	1035
							●										14,0	75	0,520	1706	887
								●									2,5	75	0,125	9554	1194
								●									3,3	75	0,200	7238	1448
								●									4,2	75	0,200	5687	1137
								●									5,0	75	0,250	4777	1194
								●									6,8	75	0,250	3513	878
								●									8,5	75	0,350	2810	984
								●									10,2	75	0,350	2342	820
								●									12,0	75	0,400	1990	796
								●									14,0	75	0,400	1706	682

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFÖHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

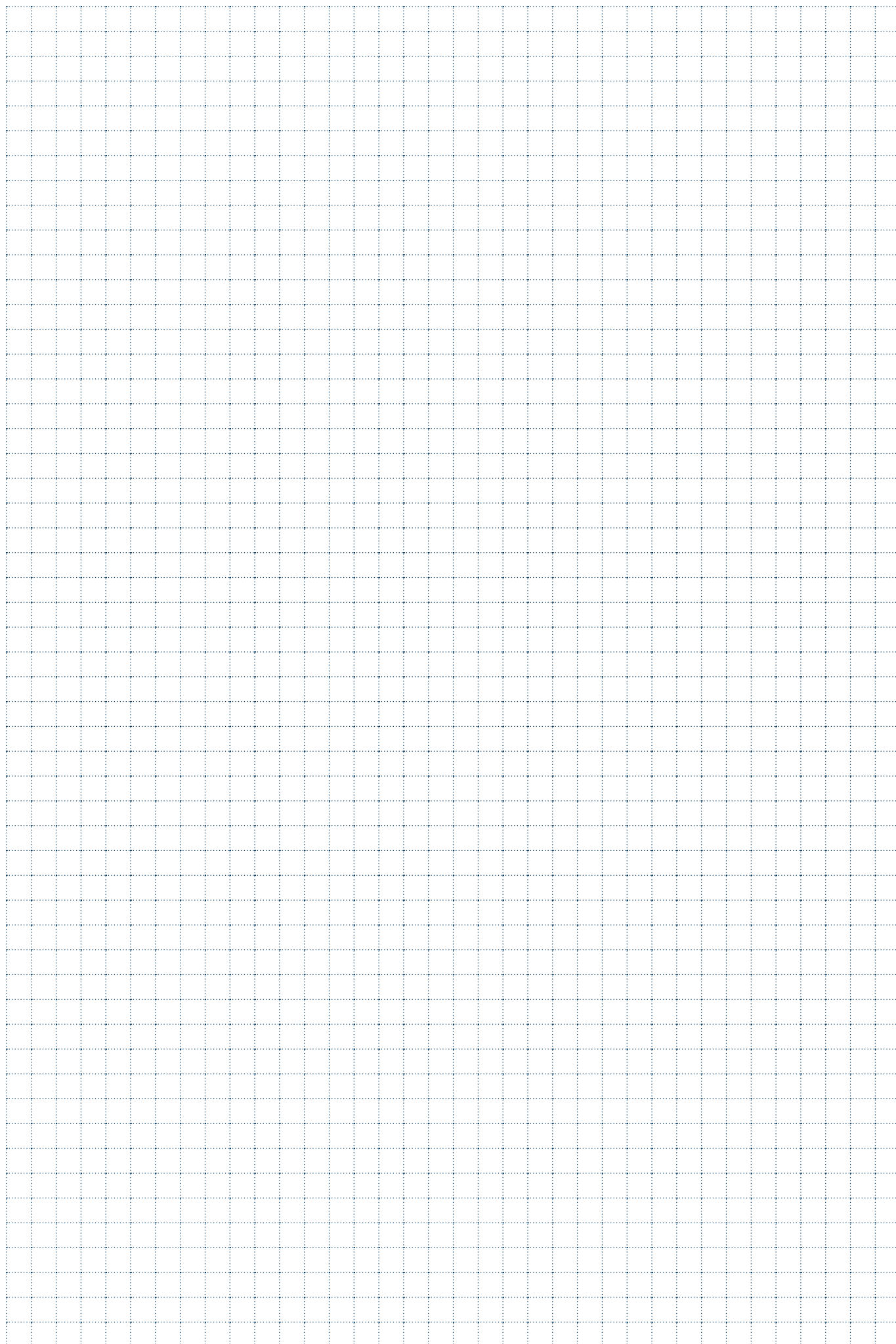
Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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





PUNTE A CENTRARE

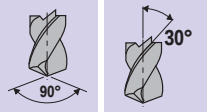
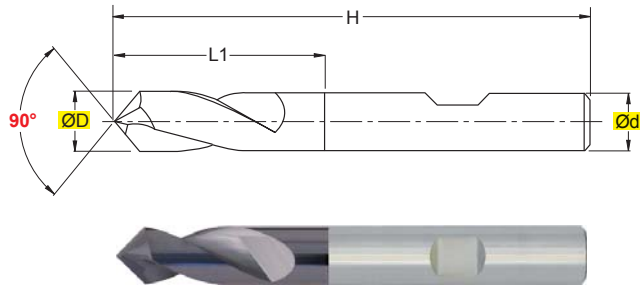
CENTER DRILLS / ZENTRIERBOHRER / POINTES A CENTRER /
BROCAS CENTRADORAS

SCR0184

GENERICO / ALL PURPOSE

RIVESTIM.
COATED
TIALN

$\varnothing D = 3 - 20$

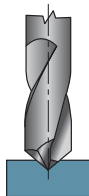


MG

> PUNTA A CENTRARE PER MACCHINE CN
> ANGOLO DI TESTA 90°
> ATTACCO DIN 6535 HB

> CENTER DRILL ON NC-AND DRILLING MACHINES
> HEAD ANGLE 90°
> SHANK DIN 6535 HB

(mm)					
ART.	$\varnothing D$	$\varnothing d$	H	L1	Z
SCR0184030	3	3	38	8	2
SCR0184040	4	4	50	10	2
SCR0184050	5	5	50	13	2
SCR0184060	6	6	57	13	2
SCR0184080	8	8	63	19	2
SCR0184100	10	10	66	20	2
SCR0184120	12	12	73	22	2
SCR0184160	16	16	82	24	2
SCR0184200	20	20	92	30	2

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73																			
		P				M	K			N			S	H	G						
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●																3	80	0,100	8493	849
	●																4	80	0,140	6369	892
	●																5	80	0,140	5096	713
	●																6	80	0,200	4246	849
	●																8	80	0,200	3185	637
	●																10	80	0,275	2548	701
	●																12	80	0,275	2123	584
	●																16	80	0,350	1592	557
	●																20	80	0,450	1274	573
	●																3	50	0,075	5308	398
	●																4	50	0,100	3981	398
	●																5	50	0,100	3185	318
	●																6	50	0,150	2654	398
	●																8	50	0,150	1990	299
	●																10	50	0,200	1592	318
	●																12	50	0,200	1327	265
	●																16	50	0,260	995	259
	●																20	50	0,325	796	259
							●										3	70	0,075	7431	557
							●										4	70	0,125	5573	697
							●										5	70	0,125	4459	557
							●										6	70	0,175	3715	650
							●										8	70	0,175	2787	488
							●										10	70	0,225	2229	502
							●										12	70	0,225	1858	418
							●										16	70	0,300	1393	418
							●										20	70	0,375	1115	418
								●									3	70	0,075	7431	557
								●									4	70	0,100	5573	557
								●									5	70	0,100	4459	446
								●									6	70	0,150	3715	557
								●									8	70	0,150	2787	418
								●									10	70	0,200	2229	446
								●									12	70	0,200	1858	372
								●									16	70	0,260	1393	362
								●									20	70	0,325	1115	362
									○								3	200	0,020	21231	425
									○								4	200	0,030	15924	478
									○								5	200	0,030	12739	382
									○								6	200	0,070	10616	743
									○								8	200	0,070	7962	557
									○								10	200	0,110	6369	701
									○								12	200	0,110	5308	584
									○								16	200	0,150	3981	597
									○								20	200	0,200	3185	637

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

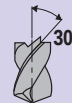
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

GENERIC / ALL PURPOSE

Technical drawing of a double-flute drill bit. The drawing shows the side profile of the bit with dimensions: $L1$ (length of the cutting edge), H (total length), $\varnothing D$ (outer diameter), and $\varnothing d$ (inner diameter). The angle of the cutting edge is 120° . Below the drawing is a 3D rendering of the drill bit.

TIALN



MG

- > CENTER DRILL ON NC-AND DRILLING MACHINES
- > HEAD ANGLE 120°
- > SHANK DIN 6535 HB

(mm)					
ART.	ØD	Ød	H	L1	Z
SCR0185060	6	6	57	13	2
SCR0185080	8	8	63	19	2
SCR0185100	10	10	66	20	2
SCR0185120	12	12	73	22	2
SCR0185160	16	16	82	24	2
SCR0185200	20	20	92	30	2

[illegible]

- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

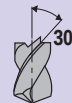
GENERIC / ALL PURPOSE

Technical drawing of a double-flute drill bit. The drawing shows the side profile of the bit with the following dimensions and features:

- 142°**: The cutting angle of the flutes, indicated by a red arc on the left.
- ØD**: The outer diameter of the drill bit, shown at both the cutting edge and the shank.
- L1**: The length of the cutting edge, indicated by a dimension line.
- H**: The total length of the drill bit, indicated by a dimension line.

Below the technical drawing is a 3D perspective view of the drill bit, showing its double-flute design and the transition between the cutting edge and the shank.

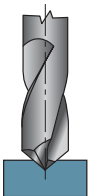
TIALN



MG

- > CENTER DRILL ON NC-AND DRILLING MACHINES
- > HEAD ANGLE 142°
- > SHANK DIN 6535 HB

(mm)					
ART.	ØD	Ød	H	L1	Z
SCR0186060	6	6	57	11	2
SCR0186080	8	8	63	19	2
SCR0186100	10	10	66	20	2
SCR0186120	12	12	73	22	2
SCR0186160	16	16	82	24	2
SCR0186200	20	20	92	30	2

		MATERIALI - MATERIALS											Pag. H 73								
Applicazione - Application		P				M	K			N			S	H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●																6	80	0,200	4246	849
	●																8	80	0,200	3185	637
	●																10	80	0,275	2548	701
	●																12	80	0,275	2123	584
	●																16	80	0,350	1592	557
	●																20	80	0,450	1274	573

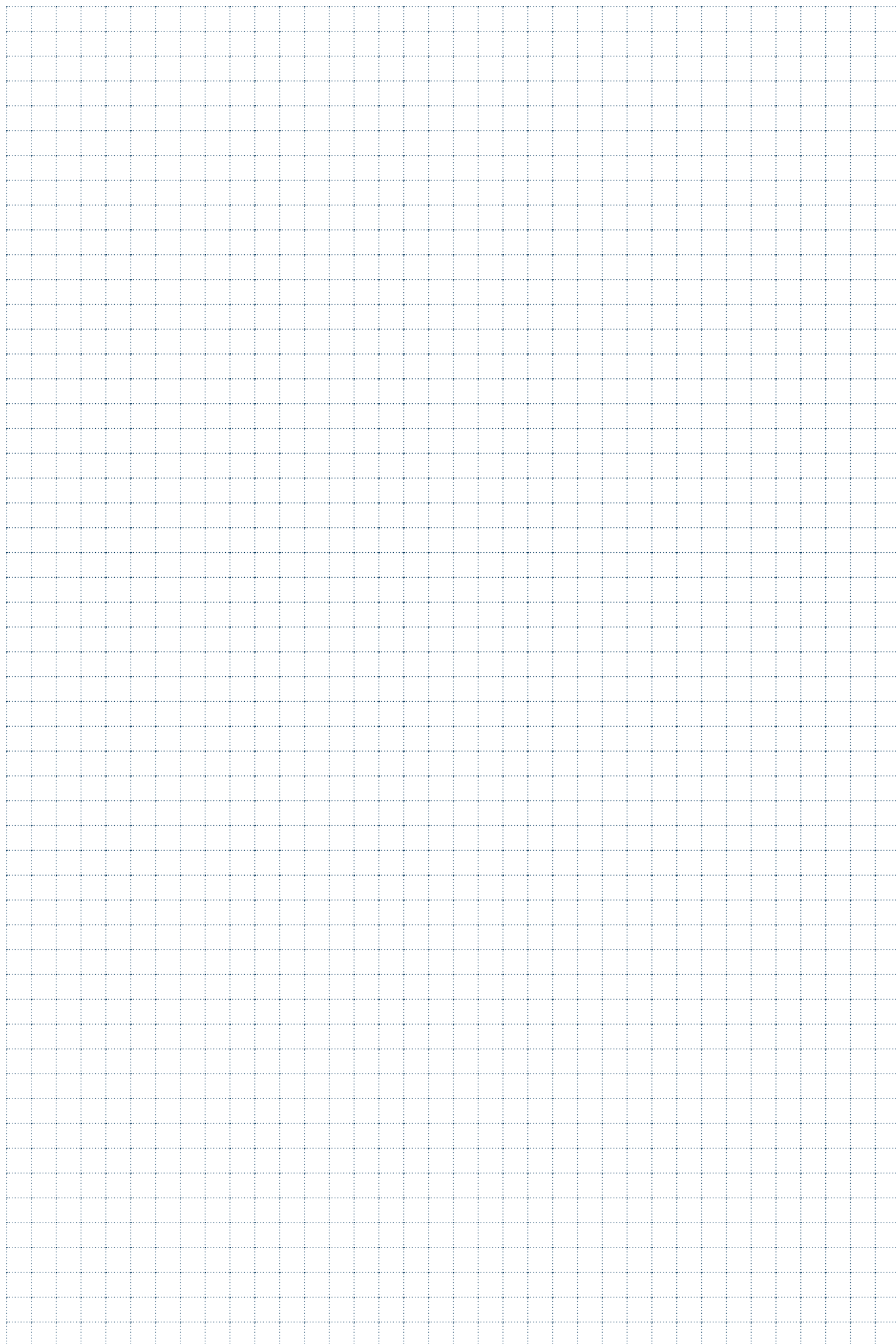
- **APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION**
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- **APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION**
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED





PUNTE FORALESA

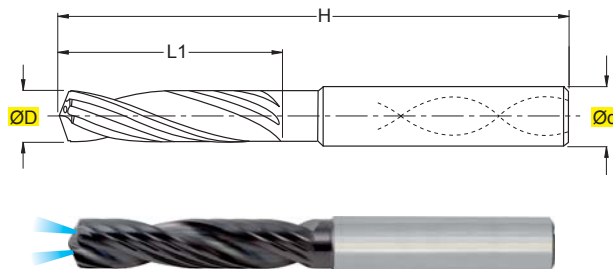
REAMER-DRILLS / REIBAHLEN-BOHRER / FORETS DE PERÇAGE ET ALÉSAGE /
BROCAS ESCARIADORAS

SPFAR3

GENERIC / ALL PURPOSE

ØD = 2,97 - 20,02

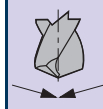
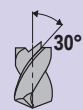
NEW



TOLLERANZE	D	d
TOLERANCE RANGE	±0,003	h6

RIVESTIM.
COATED
TIALN

3xD



MG

ART.	ØD	Ød	H	L1
SPFAR3 2.97	2,97	6,0	62	20
SPFAR3 2.98	2,98	6,0	62	20
SPFAR3 2.99	2,99	6,0	62	20
SPFAR3 3.00	3,00	6,0	62	20
*SPFAR3 3.01	3,01	6,0	62	20
SPFAR3 3.02	3,02	6,0	62	20
SPFAR3 3.97	3,97	6,0	66	28
SPFAR3 3.98	3,98	6,0	66	28
SPFAR3 3.99	3,99	6,0	66	28
SPFAR3 4.00	4,00	6,0	66	28
*SPFAR3 4.01	4,01	6,0	66	28
SPFAR3 4.02	4,02	6,0	66	28
SPFAR3 4.97	4,97	6,0	66	28
SPFAR3 4.98	4,98	6,0	66	28
SPFAR3 4.99	4,99	6,0	66	28
SPFAR3 5.00	5,00	6,0	66	28
*SPFAR3 5.01	5,01	6,0	66	28
SPFAR3 5.02	5,02	6,0	66	28
SPFAR3 5.97	5,97	6,0	66	28
SPFAR3 5.98	5,98	6,0	66	28
SPFAR3 5.99	5,99	6,0	66	28
SPFAR3 6.00	6,00	6,0	66	28
*SPFAR3 6.01	6,01	6,0	66	28
SPFAR3 6.02	6,02	6,0	66	28
SPFAR3 6.97	6,97	8,0	79	34
SPFAR3 6.98	6,98	8,0	79	34
SPFAR3 6.99	6,99	8,0	79	34
SPFAR3 7.00	7,00	8,0	79	34
*SPFAR3 7.01	7,01	8,0	79	34
SPFAR3 7.02	7,02	8,0	79	34
SPFAR3 7.97	7,97	8,0	79	34
SPFAR3 7.98	7,98	8,0	79	34
SPFAR3 7.99	7,99	8,0	79	34
SPFAR3 8.00	8,00	8,0	79	34
*SPFAR3 8.01	8,01	8,0	79	34
SPFAR3 8.02	8,02	8,0	79	34
SPFAR3 8.97	8,97	10,0	89	47
SPFAR3 8.98	8,98	10,0	89	47
SPFAR3 8.99	8,99	10,0	89	47
SPFAR3 9.00	9,00	10,0	89	47
*SPFAR3 9.01	9,01	10,0	89	47
SPFAR3 9.02	9,02	10,0	89	47
SPFAR3 9.97	9,97	10,0	89	47
SPFAR3 9.98	9,98	10,0	89	47
SPFAR3 9.99	9,99	10,0	89	47

ART.	ØD	Ød	H	L1
SPFAR3 10.00	10,00	10,0	89	47
*SPFAR3 10.01	10,01	10,0	89	47
SPFAR3 10.02	10,02	10,0	89	47
SPFAR3 10.97	10,97	12,0	102	55
SPFAR3 10.98	10,98	12,0	102	55
SPFAR3 10.99	10,99	12,0	102	55
SPFAR3 11.00	11,00	12,0	102	55
*SPFAR3 11.01	11,01	12,0	102	55
SPFAR3 11.02	11,02	12,0	102	55
SPFAR3 11.97	11,97	12,0	102	55
SPFAR3 11.98	11,98	12,0	102	55
SPFAR3 11.99	11,99	12,0	102	55
SPFAR3 12.00	12,00	12,0	102	55
*SPFAR3 12.01	12,01	12,0	102	55
SPFAR3 12.02	12,02	12,0	102	55
SPFAR3 12.97	12,97	14,0	107	60
SPFAR3 12.98	12,98	14,0	107	60
SPFAR3 12.99	12,99	14,0	107	60
SPFAR3 13.00	13,00	14,0	107	60
*SPFAR3 13.01	13,01	14,0	107	60
SPFAR3 13.02	13,02	14,0	107	60
SPFAR3 13.97	13,97	14,0	107	60
SPFAR3 13.98	13,98	14,0	107	60
SPFAR3 13.99	13,99	14,0	107	60
SPFAR3 14.00	14,00	14,0	107	60
*SPFAR3 14.01	14,01	14,0	107	60
SPFAR3 14.02	14,02	14,0	107	60
SPFAR3 14.97	14,97	16,0	115	65
SPFAR3 14.98	14,98	16,0	115	65
SPFAR3 14.99	14,99	16,0	115	65
SPFAR3 15.00	15,00	16,0	115	65
*SPFAR3 15.01	15,01	16,0	115	65
SPFAR3 15.02	15,02	16,0	115	65
SPFAR3 15.97	15,97	16,0	115	65
SPFAR3 15.98	15,98	16,0	115	65
SPFAR3 15.99	15,99	16,0	115	65
SPFAR3 16.00	16,00	16,0	115	65
*SPFAR3 16.01	16,01	16,0	115	65
SPFAR3 16.02	16,02	16,0	115	65
SPFAR3 16.97	16,97	18,0	123	73
SPFAR3 16.98	16,98	18,0	123	73
SPFAR3 16.99	16,99	18,0	123	73
SPFAR3 17.00	17,00	18,0	123	73
*SPFAR3 17.01	17,01	18,0	123	73
SPFAR3 17.02	17,02	18,0	123	73

ART.	ØD	Ød	H	L1
SPFAR3 17.97	17,97	18,0	123	73
SPFAR3 17.98	17,98	18,0	123	73
SPFAR3 17.99	17,99	18,0	123	73
SPFAR3 18.00	18,00	18,0	123	73
*SPFAR3 18.01	18,01	18,0	123	73
SPFAR3 18.02	18,02	18,0	123	73
SPFAR3 18.97	18,97	20,0	131	79
SPFAR3 18.98	18,98	20,0	131	79
SPFAR3 18.99	18,99	20,0	131	79
SPFAR3 19.00	19,00	20,0	131	79
*SPFAR3 19.01	19,01	20,0	131	79
SPFAR3 19.02	19,02	20,0	131	79
SPFAR3 19.97	19,97	20,0	131	79
SPFAR3 19.98	19,98	20,0	131	79
SPFAR3 19.99	19,99	20,0	131	79
SPFAR3 20.00	20,00	20,0	131	79
*SPFAR3 20.01	20,01	20,0	131	79
SPFAR3 20.02	20,02	20,0	131	79

* = PER OTTENERE FORI IN TOLLERANZA H7
 * = TO OBTAIN BORES IN H7 TOLERANCE
 * = UM BOHRUNGEN IN H7-TOLERANZ ZU ERHALTEN
 * = POUR OBTENIR DES TROUS DANS LA TOLÉRANCE H7

[illegible]

- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

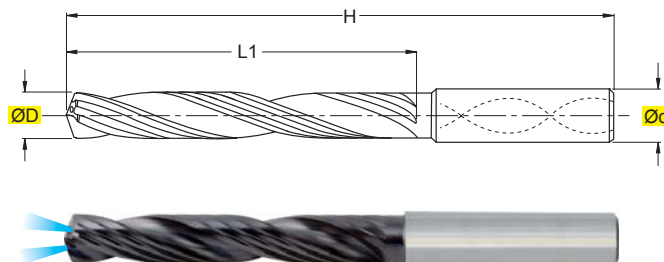
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

SPFAR5

GENERIC / ALL PURPOSE

ØD = 2,97 - 20,02

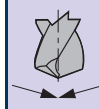
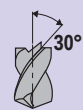
NEW



TOLLERANZE	D	d
TOLERANCE RANGE	±0,003	h6

RIVESTIM.
COATED
TIALN

5xD



MG

ART.	ØD	Ød	H	L1
SPFAR5 2.97	2,97	6,0	66	28
SPFAR5 2.98	2,98	6,0	66	28
SPFAR5 2.99	2,99	6,0	66	28
SPFAR5 3.00	3,00	6,0	66	28
*SPFAR5 3.01	3,01	6,0	66	28
SPFAR5 3.02	3,02	6,0	66	28
SPFAR5 3.97	3,97	6,0	82	44
SPFAR5 3.98	3,98	6,0	82	44
SPFAR5 3.99	3,99	6,0	82	44
SPFAR5 4.00	4,00	6,0	82	44
*SPFAR5 4.01	4,01	6,0	82	44
SPFAR5 4.02	4,02	6,0	82	44
SPFAR5 4.97	4,97	6,0	82	44
SPFAR5 4.98	4,98	6,0	82	44
SPFAR5 4.99	4,99	6,0	82	44
SPFAR5 5.00	5,00	6,0	82	44
*SPFAR5 5.01	5,01	6,0	82	44
SPFAR5 5.02	5,02	6,0	82	44
SPFAR5 5.97	5,97	6,0	82	44
SPFAR5 5.98	5,98	6,0	82	44
SPFAR5 5.99	5,99	6,0	82	44
SPFAR5 6.00	6,00	6,0	82	44
*SPFAR5 6.01	6,01	6,0	82	44
SPFAR5 6.02	6,02	6,0	82	44
SPFAR5 6.97	6,97	8,0	91	53
SPFAR5 6.98	6,98	8,0	91	53
SPFAR5 6.99	6,99	8,0	91	53
SPFAR5 7.00	7,00	8,0	91	53
*SPFAR5 7.01	7,01	8,0	91	53
SPFAR5 7.02	7,02	8,0	91	53
SPFAR5 7.97	7,97	8,0	91	53
SPFAR5 7.98	7,98	8,0	91	53
SPFAR5 7.99	7,99	8,0	91	53
SPFAR5 8.00	8,00	8,0	91	53
*SPFAR5 8.01	8,01	8,0	91	53
SPFAR5 8.02	8,02	8,0	91	53
SPFAR5 8.97	8,97	10,0	103	61
SPFAR5 8.98	8,98	10,0	103	61
SPFAR5 8.99	8,99	10,0	103	61
SPFAR5 9.00	9,00	10,0	103	61
*SPFAR5 9.01	9,01	10,0	103	61
SPFAR5 9.02	9,02	10,0	103	61
SPFAR5 9.97	9,97	10,0	103	61
SPFAR5 9.98	9,98	10,0	103	61
SPFAR5 9.99	9,99	10,0	103	61

ART.	ØD	Ød	H	L1
SPFAR5 10.00	10,00	10,0	103	61
*SPFAR5 10.01	10,01	10,0	103	61
SPFAR5 10.02	10,02	10,0	103	61
SPFAR5 10.97	10,97	12,0	118	71
SPFAR5 10.98	10,98	12,0	118	71
SPFAR5 10.99	10,99	12,0	118	71
SPFAR5 11.00	11,00	12,0	118	71
*SPFAR5 11.01	11,01	12,0	118	71
SPFAR5 11.02	11,02	12,0	118	71
SPFAR5 11.97	11,97	12,0	118	71
SPFAR5 11.98	11,98	12,0	118	71
SPFAR5 11.99	11,99	12,0	118	71
SPFAR5 12.00	12,00	12,0	118	71
*SPFAR5 12.01	12,01	12,0	118	71
SPFAR5 12.02	12,02	12,0	118	71
SPFAR5 12.97	12,97	14,0	124	77
SPFAR5 12.98	12,98	14,0	124	77
SPFAR5 12.99	12,99	14,0	124	77
SPFAR5 13.00	13,00	14,0	124	77
*SPFAR5 13.01	13,01	14,0	124	77
SPFAR5 13.02	13,02	14,0	124	77
SPFAR5 13.97	13,97	14,0	124	77
SPFAR5 13.98	13,98	14,0	124	77
SPFAR5 13.99	13,99	14,0	124	77
SPFAR5 14.00	14,00	14,0	124	77
*SPFAR5 14.01	14,01	14,0	124	77
SPFAR5 14.02	14,02	14,0	124	77
SPFAR5 14.97	14,97	16,0	133	83
SPFAR5 14.98	14,98	16,0	133	83
SPFAR5 14.99	14,99	16,0	133	83
SPFAR5 15.00	15,00	16,0	133	83
*SPFAR5 15.01	15,01	16,0	133	83
SPFAR5 15.02	15,02	16,0	133	83
SPFAR5 15.97	15,97	16,0	133	83
SPFAR5 15.98	15,98	16,0	133	83
SPFAR5 15.99	15,99	16,0	133	83
SPFAR5 16.00	16,00	16,0	133	83
*SPFAR5 16.01	16,01	16,0	133	83
SPFAR5 16.02	16,02	16,0	133	83
SPFAR5 16.97	16,97	18,0	143	93
SPFAR5 16.98	16,98	18,0	143	93
SPFAR5 16.99	16,99	18,0	143	93
SPFAR5 17.00	17,00	18,0	143	93
*SPFAR5 17.01	17,01	18,0	143	93
SPFAR5 17.02	17,02	18,0	143	93

ART.	ØD	Ød	H	L1
SPFAR5 17.97	17,97	18,0	143	93
SPFAR5 17.98	17,98	18,0	143	93
SPFAR5 17.99	17,99	18,0	143	93
SPFAR5 18.00	18,00	18,0	143	93
*SPFAR5 18.01	18,01	18,0	143	93
SPFAR5 18.02	18,02	18,0	143	93
SPFAR5 18.97	18,97	20,0	153	101
SPFAR5 18.98	18,98	20,0	153	101
SPFAR5 18.99	18,99	20,0	153	101
SPFAR5 19.00	19,00	20,0	153	101
*SPFAR5 19.01	19,01	20,0	153	101
SPFAR5 19.02	19,02	20,0	153	101
SPFAR5 19.97	19,97	20,0	153	101
SPFAR5 19.98	19,98	20,0	153	101
SPFAR5 19.99	19,99	20,0	153	101
SPFAR5 20.00	20,00	20,0	153	101
*SPFAR5 20.01	20,01	20,0	153	101
SPFAR5 20.02	20,02	20,0	153	101

* = PER OTTENERE FORI IN TOLLERANZA H7
 * = TO OBTAIN BORES IN H7 TOLERANCE
 * = UM BOHRUNGEN IN H7-TOLERANZ ZU ERHALTEN
 * = POUR OBTENIR DES TROUS DANS LA TOLÉRANCE H7

[illegible]

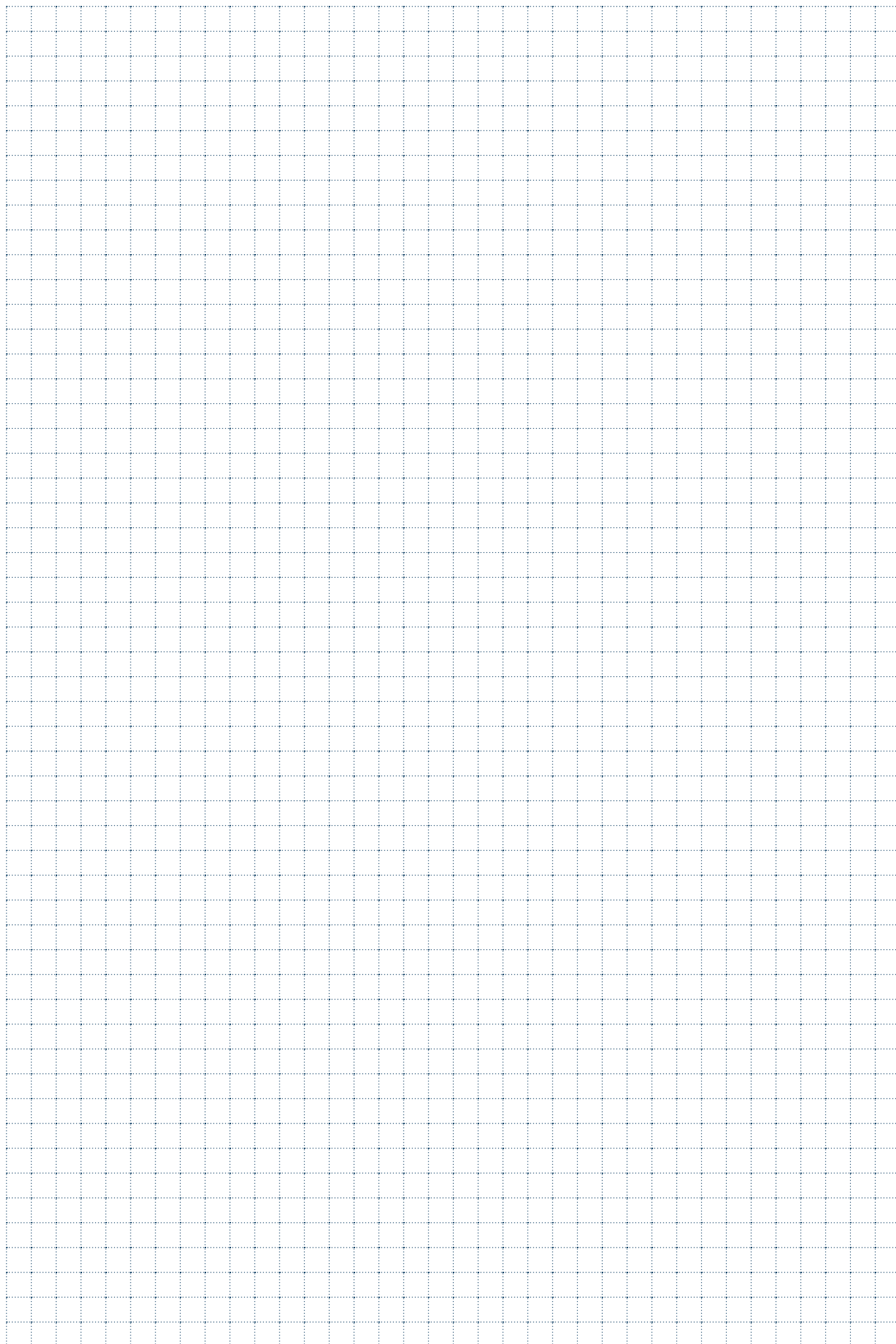
- APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE
- APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED



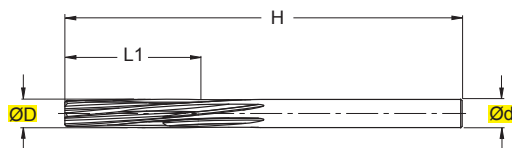


ALESATORI

REAMERS / REIBAHLEN / ALESOIRS / ESCARIADORES

SAN0508

ØD = 4 - 18



TOLLERANZE	D	d
TOLERANCE RANGE	H7	h8



MG

(mm)					
ART.	ØD	Ød	H	L1	Z
*SAN0508040	4	3,5	56	20	6
*SAN0508045	4,5	4	63	22	6
*SAN0508050	5	4	63	22	6
*SAN0508055	5,5	5	63	22	6
SAN0508060	6	5	63	22	6
SAN0508065	6,5	5	63	22	6
SAN0508070	7	6	71	25	6
SAN0508075	7,5	6	71	25	6
SAN0508080	8	6	71	25	6
SAN0508085	8,5	6	71	25	6
SAN0508090	9	8	71	25	6
SAN0508095	9,5	8	71	25	6
SAN0508100	10	8	71	25	6
SAN0508105	10,5	8	80	28	6
SAN0508110	11	10	80	28	6
SAN0508115	11,5	10	80	28	6
SAN0508120	12	10	80	28	6
SAN0508130	13	10	80	28	6
SAN0508140	14	12,5	90	32	6
SAN0508150	15	12,5	90	32	8
SAN0508160	16	14	90	32	8
SAN0508170	17	14	90	32	8
SAN0508180	18	16	100	36	8



- CON CENTRINO ESTERNO
- WITH EXTERNAL CENTERING POINT
- MIT AUSSENZENTRIERPUNKT
- AVEC POINT CENTRAL EXTERNE

- ESEGUE FORI CON TOLLERANZA H7
- FOR BORES WITH H7 TOLERANCE
- FÜHRT BOHRUNGEN MIT TOLERANZ H7 AUS
- M.D.I. ALESOIR DECIMAL H7

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73															(mm) ØD (m/min) Vc (mm) fn (mm) n (mm) Vf				
		P			M	K			N			S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3,1+5	20-30	0,15	-	-	
	●															5+10	20-30	0,25	-	-	
	●															10+20	20-30	0,40	-	-	
		●														3,1+5	10-15	0,12	-	-	
		●														5+10	10-15	0,20	-	-	
		●														10+20	10-15	0,30	-	-	
			●													3,1+5	5-10	0,08	-	-	
			●													5+10	5-10	0,15	-	-	
			●													10+20	5-10	0,25	-	-	
					●											3,1+5	10-15	0,08	-	-	
					●											5+10	10-15	0,15	-	-	
					●											10+20	10-15	0,20	-	-	
						●										3,1+5	10-12	0,15	-	-	
						●										5+10	10-12	0,30	-	-	
						●										10+20	10-12	0,50	-	-	
									●							3,1+5	25-35	0,15	-	-	
									●							5+10	25-35	0,25	-	-	
									●							10+20	25-35	0,40	-	-	
									●							3,1+5	25-35	0,20	-	-	
									●							5+10	25-35	0,25	-	-	
									●							10+20	25-35	0,40	-	-	
										●						3,1+5	25-30	0,15	-	-	
										●						5+10	25-30	0,25	-	-	
										●						10+20	25-30	0,45	-	-	

●

APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○

APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

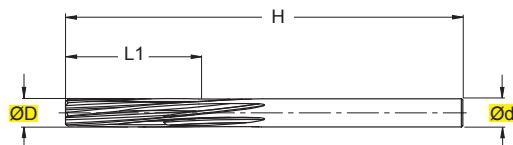
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SAN0509

ØD = 3,80 - 18,20



TOLLERANZE	D	d
TOLERANCE RANGE	-0/+0,004	h8



MG

(mm)					
ART.	ØD	Ød	H	L1	Z
*SAN0509 ...	3,80-4,10	3,5	56	20	6
*SAN0509 ...	4,11-4,60	4	63	22	6
*SAN0509 ...	4,61-5,10	4	63	22	6
*SAN0509 ...	5,11-5,60	5	63	22	6
SAN0509 ...	5,61-6,15	5	63	22	6
SAN0509 ...	6,16-6,65	5	63	22	6
SAN0509 ...	6,66-7,15	6	71	25	6
SAN0509 ...	7,16-7,65	6	71	25	6
SAN0509 ...	7,66-8,15	6	71	25	6
SAN0509 ...	8,16-8,65	6	71	25	6
SAN0509 ...	8,66-9,20	8	71	25	6
SAN0509 ...	9,21-9,70	8	71	25	6
SAN0509 ...	9,71-10,20	8	71	25	6
SAN0509 ...	10,21-10,70	8	80	28	6
SAN0509 ...	10,71-11,20	10	80	28	6
SAN0509 ...	11,21-11,70	10	80	28	6
SAN0509 ...	11,71-12,20	10	80	28	6
SAN0509 ...	12,21-13,20	10	80	28	6
SAN0509 ...	13,21-14,20	12,5	90	32	6
SAN0509 ...	14,21-15,20	12,5	90	32	8
SAN0509 ...	15,21-16,20	14	90	32	8
SAN0509 ...	16,21-17,20	14	90	32	8
SAN0509 ...	17,21-18,20	16	100	36	8



- * CON CENTRINO ESTERNO
- * WITH EXTERNAL CENTERING POINT
- * MIT AUSSENZENTRIERPUNKT
- * AVEC POINT CENTRAL EXTERNE

- ESEGUE FORI CON TOLLERANZA -0/+0,004
- FOR BORES WITH -0/+0,004 TOLERANCE
- FÜHRT BOHRUNGEN MIT -0/+0,004 TOLERANZ AUS
- EXECUTE TROUS AVEC TOLERANCE -0/+0,004

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73															(mm) ØD (m/min) Vc (mm) fn (mm) n (mm) Vf					
		P			M	K			N			S	H	G								
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●																3,1+5	20-30	0,15	-	-	
	●																5+10	20-30	0,25	-	-	
	●																10+20	20-30	0,40	-	-	
		●																3,1+5	10-15	0,12	-	-
		●																5+10	10-15	0,20	-	-
		●																10+20	10-15	0,30	-	-
				●														3,1+5	5-10	0,08	-	-
				●														5+10	5-10	0,15	-	-
				●														10+20	5-10	0,25	-	-
						●												3,1+5	10-15	0,08	-	-
						●												5+10	10-15	0,15	-	-
						●												10+20	10-15	0,20	-	-
							●											3,1+5	10-12	0,15	-	-
							●											5+10	10-12	0,30	-	-
							●											10+20	10-12	0,50	-	-
								●										3,1+5	10-12	0,15	-	-
								●										5+10	10-12	0,30	-	-
								●										10+20	10-12	0,50	-	-
										●								3,1+5	25-35	0,15	-	-
										●								5+10	25-35	0,25	-	-
										●								10+20	25-35	0,40	-	-
											●							3,1+5	25-35	0,20	-	-
											●							5+10	25-35	0,25	-	-
											●							10+20	25-35	0,40	-	-
											●						3,1+5	25-30	0,15	-	-	
											●						5+10	25-30	0,25	-	-	
											●						10+20	25-30	0,45	-	-	

●

 APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○

 APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

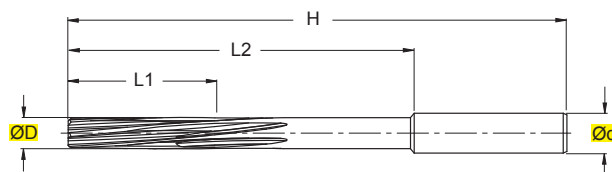
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SAN0708

$\varnothing D = 1,0 - 18,2$



TOLLERANZE	D	d
TOLERANCE RANGE	H7	h8



MG

ART.	ØD	Ød	H	L1	L2	Z
*SAN07080010	1	1	40	8	—	4
*SAN0708 ...	1,1-1,4	—	40	8	—	4
*SAN07080015	1,5	1,5	40	8	—	4
*SAN0708 ...	1,6-1,9	—	43	9	—	4
*SAN07080020	2	2	49	11	—	4
*SAN07080021	2,1	2	49	11	—	4
*SAN0708 ...	2,2-2,3	2	53	12	—	4
*SAN07080024	2,4	2,3	57	14	—	4
*SAN07080025	2,5	2,5	57	14	—	4
*SAN07080026	2,6	2,5	57	14	—	4
*SAN0708 ...	2,7-2,9	2,5	61	15	—	4
*SAN07080030	3	3	65	16	—	4
*SAN0708 ...	3,1-3,3	3	65	16	—	4
*SAN0708 ...	3,4-3,7	3,5	70	18	45	4
*SAN0708 ...	3,8-4,2	4	75	19	47	6
*SAN0708 ...	4,3-4,7	4,5	80	21	51	6
*SAN0708 ...	4,8-5,1	5	86	23	56	6
SAN0708 ...	5,2-5,6	5	93	26	58	6
SAN0708 ...	5,7-6,1	6	93	26	58	6
SAN0708 ...	6,2-6,7	6	101	28	63	6
SAN0708 ...	6,8-7,6	7	109	31	71	6
SAN0708 ...	7,7-8,6	8	117	33	77	6
SAN0708 ...	8,7-9,6	9	125	36	80	6
SAN0708 ...	9,7-10,6	10	133	38	85	6
SAN0708 ...	10,7-11,6	10	142	41	92	6
SAN0708 ...	11,7-12,2	12	151	44	99	6
SAN0708 ...	12,3-13,2	12,5	151	44	99	6
SAN0708 ...	13,3-14,2	14	160	47	105	6
SAN0708 ...	14,3-15,2	14	162	50	107	8
SAN0708 ...	15,3-16,2	16	170	52	115	8
SAN0708 ...	16,3-17,2	16	175	54	119	8
SAN0708 ...	17,3-18,2	18	182	56	122	8



- * CON CENTRINO ESTERNO
- * WITH EXTERNAL CENTERING POINT
- * MIT AUSSENZENTRIERPUNKT
- * AVEC POINT CENTRAL EXTERNE

- ESEGUE FORI CON TOLLERANZA H7
- FOR BORES WITH H7 TOLERANCE
- FÜHRT BOHRUNGEN MIT TOLERANZ H7 AUS
- M.D.I. ALESOIR DECIMAL H7

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73					
		P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●																3,1+5	20-30	0,15	-	-	
	●																5+10	20-30	0,25	-	-	
	●																10+20	20-30	0,40	-	-	
		●															3,1+5	10-15	0,12	-	-	
		●															5+10	10-15	0,20	-	-	
		●															10+20	10-15	0,30	-	-	
				●														3,1+5	5-10	0,08	-	-
				●														5+10	5-10	0,15	-	-
				●														10+20	5-10	0,25	-	-
						●											3,1+5	10-15	0,08	-	-	
					●												5+10	10-15	0,15	-	-	
					●												10+20	10-15	0,20	-	-	
						●											3,1+5	10-12	0,15	-	-	
					●												5+10	10-12	0,30	-	-	
					●												10+20	10-12	0,50	-	-	
							●										3,1+5	10-12	0,15	-	-	
							●										5+10	10-12	0,30	-	-	
							●										10+20	10-12	0,50	-	-	
									●								3,1+5	25-35	0,15	-	-	
									●								5+10	25-35	0,25	-	-	
									●								10+20	25-35	0,40	-	-	
										●							3,1+5	25-35	0,20	-	-	
										●							5+10	25-35	0,25	-	-	
										●							10+20	25-35	0,40	-	-	
											●						3,1+5	25-30	0,15	-	-	
											●						5+10	25-30	0,25	-	-	
											●						10+20	25-30	0,45	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

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Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

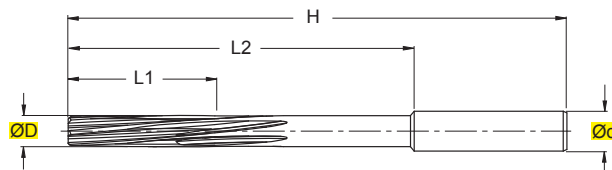
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SAN0709

ØD = 1,00 - 18,20



TOLLERANZE	D	d
TOLERANCE RANGE	-0/+0,004	h8



MG

ART.	ØD	Ød	H	L1	L2	Z
*SAN0709 ...	1,00-1,50	—	40	8	—	4
*SAN0709 ...	1,51-1,90	—	43	9	—	4
*SAN0709 ...	1,91-2,12	2	49	11	26	4
*SAN0709 ...	2,13-2,36	2	53	12	—	4
*SAN0709 ...	2,37-2,48	2,3	57	14	—	4
*SAN0709 ...	2,49-2,65	2,5	57	14	—	4
*SAN0709 ...	2,66-2,96	2,5	61	15	—	4
*SAN0709 ...	2,97-3,35	3	65	16	40	4
*SAN0709 ...	3,36-3,75	3,5	70	18	45	4
*SAN0709 ...	3,76-4,25	4	75	19	47	6
*SAN0709 ...	4,26-4,75	4,5	80	21	51	6
*SAN0709 ...	4,76-5,15	5	86	23	56	6
*SAN0709 ...	5,16-5,65	5	93	26	58	6
SAN0709 ...	5,66-6,15	6	93	26	58	6
SAN0709 ...	6,16-6,70	6	101	28	63	6
SAN0709 ...	6,71-7,65	7	109	31	71	6
SAN0709 ...	7,66-8,65	8	117	33	77	6
SAN0709 ...	8,66-9,65	9	125	36	80	6
SAN0709 ...	9,66-10,65	10	133	38	85	6
SAN0709 ...	10,66-11,65	10	142	41	92	6
SAN0709 ...	11,66-12,20	12	151	44	99	6
SAN0709 ...	12,21-13,20	12,5	151	44	99	6
SAN0709 ...	13,21-14,20	14	160	47	105	6
SAN0709 ...	14,21-15,20	14	162	50	107	8
SAN0709 ...	15,21-16,20	16	170	52	115	8
SAN0709 ...	16,21-17,20	16	175	54	119	8
SAN0709 ...	17,21-18,20	18	182	56	122	8



- * CON CENTRINO ESTERNO
- * WITH EXTERNAL CENTERING POINT
- * MIT AUSSENZENTRIERPUNKT
- * AVEC POINT CENTRAL EXTERNE

- ESEGUE FORI CON TOLLERANZA -0/+0,004
- FOR BORES WITH -0/+0,004 TOLERANCE
- FÜHRT BOHRUNGEN MIT -0/+0,004 TOLERANZ AUS
- EXECUTE TROUS AVEC TOLERANCE -0/+0,004

Applicazione - Application		MATERIALI - MATERIALS Pag. H 73															(mm) ØD (m/min) Vc (mm) fn (mm) n (mm) Vf				
		P			M	K			N			S	H	G							
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE					
	●															3,1+5	20-30	0,15	-	-	
	●															5+10	20-30	0,25	-	-	
	●															10+20	20-30	0,40	-	-	
		●														3,1+5	10-15	0,12	-	-	
		●														5+10	10-15	0,20	-	-	
		●														10+20	10-15	0,30	-	-	
			●														3,1+5	5-10	0,08	-	-
			●														5+10	5-10	0,15	-	-
		●														10+20	5-10	0,25	-	-	
					●											3,1+5	10-15	0,08	-	-	
					●											5+10	10-15	0,15	-	-	
					●											10+20	10-15	0,20	-	-	
						●										3,1+5	10-12	0,15	-	-	
						●										5+10	10-12	0,30	-	-	
						●										10+20	10-12	0,50	-	-	
									●							3,1+5	10-12	0,15	-	-	
									●							5+10	10-12	0,30	-	-	
									●							10+20	10-12	0,50	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

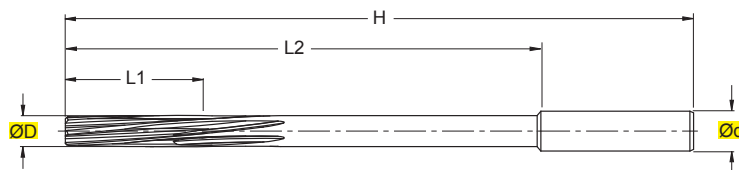
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SAN0808

$\varnothing D = 1,5 - 12,2$



TOLLERANZE	D	d
TOLERANCE RANGE	H7	h8



MG

(mm)						
ART.	ØD	Ød	H	L1	L2	Z
*SAN08080015	1,5	1,5	110	18	65	4
*SAN08080020	2	2	110	18	65	4
*SAN0808 ...	2,1-2,3	2	110	18	65	4
*SAN08080024	2,4	2,3	120	20	65	4
*SAN08080025	2,5	2,5	120	20	65	4
*SAN0808 ...	2,6-2,7	2,5	120	20	65	4
*SAN0808 ...	2,8-3,1	3	120	20	65	4
*SAN0808 ...	3,2-3,3	3	150	30	90	4
*SAN0808 ...	3,4-3,8	3,5	150	30	90	4
*SAN0808 ...	3,9-4,2	4	150	30	90	6
*SAN0808 ...	4,3-4,8	4,5	180	35	115	6
*SAN0808 ...	4,9-5,1	5	180	35	115	6
*SAN0808 ...	5,2-5,9	5	200	40	130	6
*SAN08080060	6	6	200	40	130	6
*SAN08080061	6,1	6	200	40	130	6
*SAN0808 ...	6,2-6,9	6	200	45	130	6
*SAN08080070	7	7	200	45	130	6
*SAN08080071	7,1	7	200	45	130	6
*SAN0808 ...	7,2-7,9	7	200	45	130	6
*SAN08080080	8	8	200	45	130	6
*SAN08080081	8,1	8	200	45	130	6
*SAN0808 ...	8,2-8,9	8	220	50	145	6
*SAN08080090	9	9	220	50	145	6
SAN08080091	9,1	9	220	50	145	6
SAN0808 ...	9,2-9,9	9	220	50	145	6
SAN08080100	10	10	220	50	145	6
SAN0808 ...	10,1-10,2	10	220	50	145	6
SAN0808 ...	10,3-10,7	10	250	55	170	6
SAN0808 ...	10,8-11,2	11	250	55	170	6
SAN0808 ...	11,3-11,7	11	250	55	170	6
SAN0808 ...	11,8-12,2	12	250	55	170	6



- * CON CENTRINO ESTERNO
- * WITH EXTERNAL CENTERING POINT
- * MIT AUSSENZENTRIERPUNKT
- * AVEC POINT CENTRAL EXTERNE



ESEGUE FORI CON TOLLERANZA H7
 FOR BORES WITH H7 TOLERANCE
 FÜHRT BOHRUNGEN MIT TOLERANZ H7 AUS
 M.D.I. ALESOIR DECIMAL H7

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73					
		P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●																3,1+5	20-30	0,15	-	-	
	●																5+10	20-30	0,25	-	-	
	●																10+20	20-30	0,40	-	-	
		●																3,1+5	10-15	0,12	-	-
		●																5+10	10-15	0,20	-	-
		●																10+20	10-15	0,30	-	-
				●														3,1+5	5-10	0,08	-	-
				●														5+10	5-10	0,15	-	-
				●														10+20	5-10	0,25	-	-
						●												3,1+5	10-15	0,08	-	-
						●												5+10	10-15	0,15	-	-
						●												10+20	10-15	0,20	-	-
							●											3,1+5	10-12	0,15	-	-
							●											5+10	10-12	0,30	-	-
							●											10+20	10-12	0,50	-	-
								●										3,1+5	10-12	0,15	-	-
								●										5+10	10-12	0,30	-	-
								●										10+20	10-12	0,50	-	-
										●								3,1+5	25-35	0,15	-	-
										●								5+10	25-35	0,25	-	-
										●								10+20	25-35	0,40	-	-
											●							3,1+5	25-35	0,20	-	-
											●							5+10	25-35	0,25	-	-
											●							10+20	25-35	0,40	-	-
												●						3,1+5	25-30	0,15	-	-
											●						5+10	25-30	0,25	-	-	
											●						10+20	25-30	0,45	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

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

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

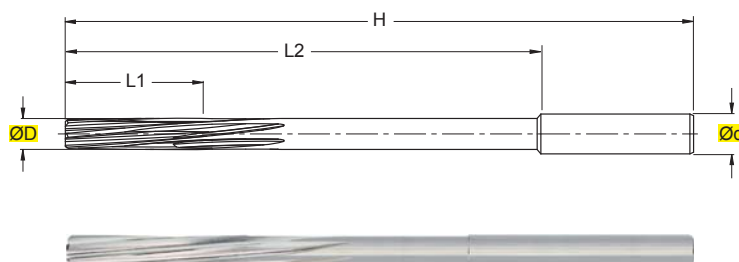
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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

SAN0809

ØD = 2,00 - 12,20



TOLLERANZE	D	d
TOLERANCE RANGE	-0/+0,004	h8



MG

(mm)						
ART.	ØD	Ød	H	L1	L2	Z
*SAN0809 ...	2,00-2,31	2	110	18	65	4
*SAN0809 ...	2,32-2,41	2,3	120	20	65	4
*SAN0809 ...	2,42-2,71	2,5	120	20	65	4
*SAN0809 ...	2,72-3,11	3	120	20	65	4
*SAN0809 ...	3,12-3,31	3	150	30	90	4
*SAN0809 ...	3,32-3,81	3,5	150	30	90	4
*SAN0809 ...	3,82-4,24	4	150	30	90	6
*SAN0809 ...	4,25-4,91	4	180	35	115	6
*SAN0809 ...	4,92-5,11	5	180	35	115	6
*SAN0809 ...	5,12-5,91	5	200	40	130	6
*SAN0809 ...	5,92-6,11	6	200	40	130	6
*SAN0809 ...	6,12-6,91	6	200	45	130	6
*SAN0809 ...	6,92-7,11	7	200	45	130	6
*SAN0809 ...	7,12-7,91	7	200	45	130	6
*SAN0809 ...	7,92-8,11	8	200	45	130	6
*SAN0809 ...	8,12-8,91	8	220	50	145	6
*SAN0809 ...	8,92-9,11	9	220	50	145	6
*SAN0809 ...	9,12-9,91	9	220	50	145	6
SAN0809 ...	9,92-10,20	10	220	50	145	6
SAN0809 ...	10,21-10,80	10	250	55	170	6
SAN0809 ...	10,81-11,20	11	250	55	170	6
SAN0809 ...	11,21-11,80	11	250	55	170	6
SAN0809 ...	11,81-12,20	12	250	55	170	6



- * CON CENTRINO ESTERNO
- * WITH EXTERNAL CENTERING POINT
- * MIT AUSSENZENTRIERPUNKT
- * AVEC POINT CENTRAL EXTERNE

- ESEGUE FORI CON TOLLERANZA -0/+0,004
- FOR BORES WITH -0/+0,004 TOLERANCE
- FÜHRT BOHRUNGEN MIT -0/+0,004 TOLERANZ AUS
- EXECUTE TROUS AVEC TOLERANCE -0/+0,004

Applicazione - Application		MATERIALI - MATERIALS															Pag. H 73					
		P				M	K			N			S		H	G	(mm) ØD	(m/min) Vc	(mm) fn	(mm) n	(mm) Vf	
		ACCIAIO NON LEGATO NOT ALLOY STEEL	ACCIAIO POCO LEGATO LOW ALLOY STEEL	ACCIAIO ALTO LEGATO ALLOY STEEL	INOX MARTENSITICO STAINLESS STEEL MART.	INOX AUST. DUPLEX STAINLESS STEEL AUST.	GHISA GRIGIA GREY CAST IRON	GHISA SFEROIDALE SPHEROIDAL GRAPHITE	GHISA MALLEABILE MALLEABLE CAST IRON	ALLUMINIO E SUE LEGHE ALUMINIUM	RAME E SUE LEGHE COPPER	NON METALLICI PLASTICS	LEGHE RESIST. CALORE HIGH TEMP. ALLOY	TITANIO E SUE LEGHE TITANIUM	ACCIAIO TEMPRATO HARDENED STEEL	GRAFITE GRAPHITE						
	●																3,1+5	20-30	0,15	-	-	
	●																5+10	20-30	0,25	-	-	
	●																10+20	20-30	0,40	-	-	
		●																3,1+5	10-15	0,12	-	-
		●																5+10	10-15	0,20	-	-
		●																10+20	10-15	0,30	-	-
				●														3,1+5	5-10	0,08	-	-
				●														5+10	5-10	0,15	-	-
				●														10+20	5-10	0,25	-	-
						●												3,1+5	10-15	0,08	-	-
						●												5+10	10-15	0,15	-	-
						●												10+20	10-15	0,20	-	-
							●											3,1+5	10-12	0,15	-	-
							●											5+10	10-12	0,30	-	-
							●											10+20	10-12	0,50	-	-
										●								3,1+5	10-12	0,15	-	-
										●								5+10	10-12	0,30	-	-
										●								10+20	10-12	0,50	-	-
										●								3,1+5	25-35	0,15	-	-
										●								5+10	25-35	0,25	-	-
										●								10+20	25-35	0,40	-	-
											●							3,1+5	25-35	0,20	-	-
											●							5+10	25-35	0,25	-	-
											●							10+20	25-35	0,40	-	-
											●						3,1+5	25-30	0,15	-	-	
											●						5+10	25-30	0,25	-	-	
											●						10+20	25-30	0,45	-	-	

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
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EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
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fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

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

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