

MVX + MINI MVX

PUNTA A INSERTI

CORPO A ELEVATA RIGIDITÀ

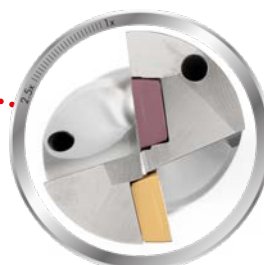


MVX + MINI MVX

PUNTA AD INSERTI A ELEVATA STABILITÀ



4 TAGLIENTI



Inserto economico a 4 taglienti.

AMPIA GAMMA DI INSERTI



Per un'ampia gamma di applicazioni e materiali da lavorare.

ECCELLENTE FINITURA SUPERFICIALE



Wiper

Una geometria di tipo wiper per il tagliente periferico garantisce un'eccellente precisione delle superfici lavorate.

COMBINAZIONE IDEALE DI INSERTI CVD E PVD

Grado rivestito CVD, altamente resistente all'usura, per l'inserto esterno e grado rivestito PVD, con elevata stabilità, per l'inserto interno.

MINI MVX: PROFONDITÀ DI FORATURA ~ LD 5

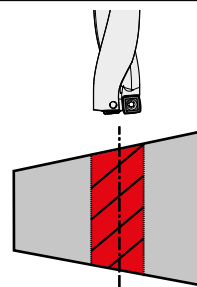
Il corpo a elevata rigidità e la posizione dell'inserto ottimizzata controllano la deformazione e le vibrazioni.

ESEMPI DI APPLICAZIONI SPECIALI

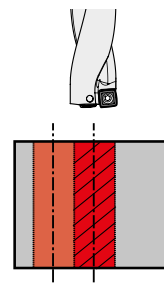
Esempi di applicazione

Metodo di taglio

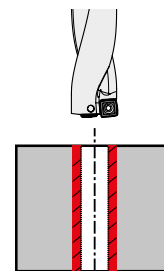
FORATURA SU SUPERFICIE INCLINATA



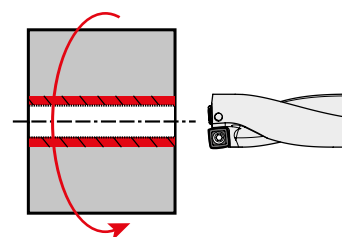
FORI SOVRAPPosti



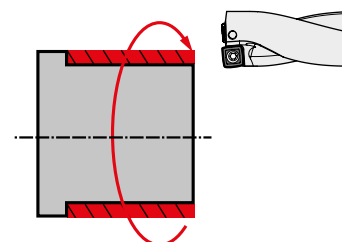
BARENATURA



TORNITURA INTERNA



TORNITURA ESTERNA



Per applicazioni speciali, utilizzare MVX solo fino a 4 volte il diametro.

ROMPITRUCIOLI

ROMPITRUCIOLO UH PER ACCIAIO TEMPRATO

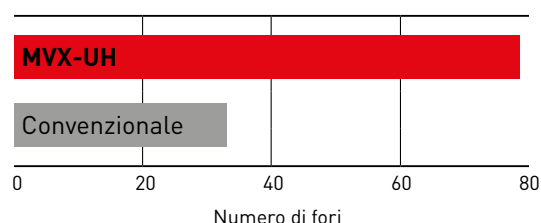
Tagliente rinforzato per forare l'acciaio temprato fino a 45 HRC.

PRESTAZIONI DI TAGLIO

Diametro	MVX1700X3F20
Inserti	Esterno MC1020-UM Interno DP8020-UH
Materiale da lavorare	DIN X40CrMoV51 (45 HRC)
Vc (m/min)	50
f (mm/giro)	0.08
ap (mm)	30 (foro passante)



Confronto numero di fori eseguiti



ROMPITRUCIOLO UN PER LEGHE DI ALLUMINIO

Progettato con un tagliente affilato e preciso, il rompitruciolo UN consente un' eccellente evacuazione dei trucioli. Le superfici lucidate della spoglia evitano inoltre l'incollamento del materiale asportato.

PRESTAZIONI DI TAGLIO

Diametro	MVX1700X5F20
Inserti	Esterno TF15-UN Interno TF15-UN
Materiale da lavorare	JIS ADC12
Vc (m/min)	400
f (mm/giro)	0.05
ap (mm)	40 (foro cieco)



Confronto finitura superficiale



Rompitruciolo UN (TF15)



Convenzionale

ROMPITRUCIOLO US PER ACCIAIO INOSSIDABILE

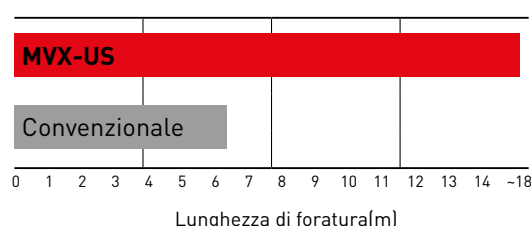
Specificamente progettato per il tagliente interno. Eccellente resistenza a rottura e tagliente di riporto.

PRESTAZIONI DI TAGLIO

Diametro	MVX3000X3F32
Inserti	Esterno MC1020-UM Interno VP15TF-US
Materiale da lavorare	DIN X5CrNi18-10
Vc (m/min)	120
f (mm/giro)	0.12
ap (mm)	50 (foro passante)



Confronto lunghezza di foratura



ROMPITRUCIOLO UM AVANZAMENTI MEDIO-ALTI

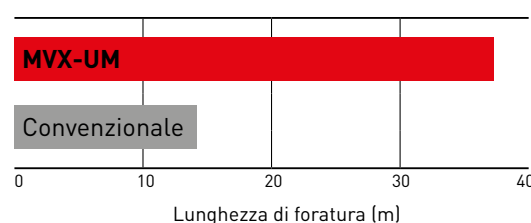
Rompitruciolo universale per acciaio, acciaio inossidabile, ghisa e acciaio temprato.

PRESTAZIONI DI TAGLIO

Diametro	MVX1900X3F25
Inserti	Esterno MC1020-UM Interno VP15TF-UM
Materiale da lavorare	DIN C50
Vc (m/min)	220
f (mm/giro)	0.1
ap (mm)	50 (foro passante)



Confronto lunghezza di foratura



CRITERI DI SELEZIONE DEGLI INSERTI

La velocità di taglio periferica è naturalmente meno elevata verso il centro della punta, pertanto può facilmente verificarsi l'incollamento dei trucioli (tagliente di riporto). Di seguito, vengono riportati alcuni punti importanti che consentiranno di selezionare correttamente l'inserto.

	1ª scelta		Quando l'inserto esterno si rompe	
	Esterno	Interno	Esterno	Interno
P	MC1020	VP15TF	VP15TF	VP15TF
				
	UM	UM	UM	UM
M	MC1020	VP15TF	VP15TF	VP15TF
				
	UM	US	UM	US
K	MC5020	VP15TF	VP15TF	VP15TF
				
	UM	UM	UM	UM
N	TF15	TF15		
				
	UN	UN		
H	MC1020	DP8020	VP15TF	DP8020
				
	UM	UH	UM	UH

CARATTERISTICHE DEI GRADI

MC1020

MC1020 è un grado CVD rivestito per velocità di taglio superiori. La proprietà principale è l'elevata resistenza all'usura e alla deformazione plastica, per una maggiore affidabilità.

DP8020

Combina uno speciale substrato in metallo duro estremamente resistente e un rivestimento in Ti-Al-Si ad elevata durezza.
DP8020 è un grado in metallo duro rivestito in PVD adatto all'acciaio temprato (45 HRC o inferiore) che previene la scheggiatura quando si lavorano acciai e ghise di elevata durezza.

MC5020

MC5020 è un grado rivestito in CVD, adatto per forare la ghisa. Ha un'eccellente resistenza all'abrasione e garantisce una lunga vita utensile controllando la scheggiatura e la frattura termica che si possono verificare forando la ghisa nodulare.

VP15TF

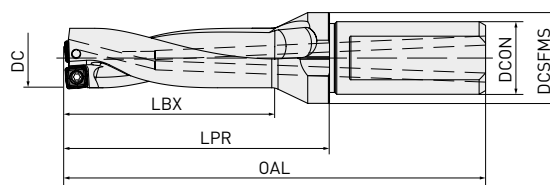
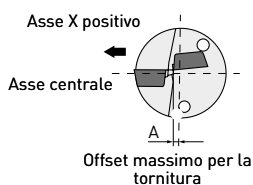
VP15TF è un grado rivestito in PVD, adatto a un'ampia gamma di applicazioni. Il substrato in microgranuli e il rivestimento Miracle assicurano un'eccellente resistenza al tagliente di riporto.

TF15

TF15 è un metallo duro micrograna non rivestito con un tagliente affilatissimo ideale per la foratura di leghe di alluminio.

MINI MVX

P M K

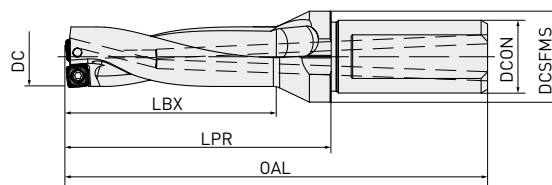
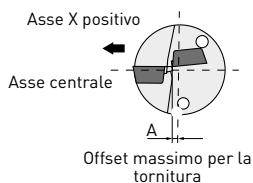


Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX1400X2F20	14.0	2	●	35	50	93	20	25	0.6	S0X05
MVX1400X3F20		3	●	49	64	107	20	25	0.6	
MVX1400X4F20		4	●	63	78	121	20	25	0.6	
MVX1400X5F20		5	●	77	92	135	20	25	0.6	
MVX1450X2F20	14.5	2	●	36	51	94	20	25	0.5	S0X05
MVX1450X3F20		3	●	50.5	65.5	108.5	20	25	0.5	
MVX1450X4F20		4	●	65	80	123	20	25	0.5	
MVX1450X5F20		5	●	79.5	94.5	137.5	20	25	0.5	
MVX1500X2F20	15.0	2	●	37	52	95	20	25	0.35	S0X05
MVX1500X3F20		3	●	52	67	110	20	25	0.35	
MVX1500X4F20		4	●	67	82	125	20	25	0.35	
MVX1500X5F20		5	●	82	97	140	20	25	0.35	
MVX1550X2F20	15.5	2	●	38	53	96	20	25	0.3	S0X05
MVX1550X3F20		3	●	53.5	68.5	111.5	20	25	0.3	
MVX1550X4F20		4	●	69	84	127	20	25	0.3	
MVX1550X5F20		5	●	84.5	99.5	142.5	20	25	0.3	
MVX1600X2F20	16.0	2	●	39	54	97	20	25	0.25	S0X05
MVX1600X3F20		3	●	55	70	113	20	25	0.25	
MVX1600X4F20		4	●	71	86	129	20	25	0.25	
MVX1600X5F20		5	●	87	102	145	20	25	0.25	
MVX1650X2F20	16.5	2	●	40	55	98	20	25	0.25	S0X05
MVX1650X3F20		3	●	56.5	71.5	114.5	20	25	0.25	
MVX1650X4F20		4	●	73	88	131	20	25	0.25	
MVX1650X5F20		5	●	89.5	104.5	147.5	20	25	0.25	

1/1



MVX



Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX1700X2F20	17.0	2	●	41	56	99	20	25	0.5	SOX06
MVX1700X3F20		3	●	58	73	116	20	25	0.5	
MVX1700X4F20		4	●	75	90	133	20	25	0.5	
MVX1700X5F20		5	●	92	107	150	20	25	0.5	
MVX1700X6F20		6	●	109	124	167	20	25	0.5	
MVX1750X2F25	17.5	2	●	42	62	112	25	32	0.45	SOX06
MVX1750X3F25		3	●	59.5	79.5	129.5	25	32	0.45	
MVX1750X4F25		4	●	77	97	147	25	32	0.45	
MVX1750X5F25		5	●	94.5	114.5	164.5	25	32	0.45	
MVX1750X6F25		6	●	112	132	182	25	32	0.45	
MVX1800X2F25	18.0	2	●	43	63	113	25	32	0.4	SOX06
MVX1800X3F25		3	●	61	81	131	25	32	0.4	
MVX1800X4F25		4	●	79	99	149	25	32	0.4	
MVX1800X5F25		5	●	97	117	167	25	32	0.4	
MVX1800X6F25		6	●	115	135	185	25	32	0.4	
MVX1850X2F25	18.5	2	●	44	64	114	25	32	0.35	SOX06
MVX1850X3F25		3	●	62.5	82.5	132.5	25	32	0.35	
MVX1850X4F25		4	●	81	101	151	25	32	0.35	
MVX1850X5F25		5	●	99.5	119.5	169.5	25	32	0.35	
MVX1850X6F25		6	●	118	138	188	25	32	0.35	
MVX1900X2F25	19.0	2	●	45	65	115	25	32	0.3	SOX06
MVX1900X3F25		3	●	64	84	134	25	32	0.3	
MVX1900X4F25		4	●	83	103	153	25	32	0.3	
MVX1900X5F25		5	●	102	122	172	25	32	0.3	
MVX1900X6F25		6	●	121	141	191	25	32	0.3	
MVX1950X2F25	19.5	2	●	46	66	116	25	32	0.25	SOX06
MVX1950X3F25		3	●	65.5	85.5	135.5	25	32	0.25	
MVX1950X4F25		4	●	85	105	155	25	32	0.25	
MVX1950X5F25		5	●	104.5	124.5	174.5	25	32	0.25	
MVX1950X6F25		6	●	124	144	194	25	32	0.25	
MVX2000X2F25	20.0	2	●	47	67	117	25	32	0.6	SOX07
MVX2000X3F25		3	●	67	87	137	25	32	0.6	
MVX2000X4F25		4	●	87	107	157	25	32	0.6	
MVX2000X5F25		5	●	107	127	177	25	32	0.6	
MVX2000X6F25		6	●	127	147	197	25	32	0.6	
MVX2050X2F25	20.5	2	●	48	68	118	25	32	0.55	SOX07
MVX2050X3F25		3	●	68.5	88.5	138.5	25	32	0.55	

1/7

MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX2100X2F25	21.0	2	●	49	69	119	25	32	0.5	SOX07
MVX2100X3F25		3	●	70	90	140	25	32	0.5	
MVX2100X4F25		4	●	91	111	161	25	32	0.5	
MVX2100X5F25		5	●	112	132	182	25	32	0.5	
MVX2100X6F25		6	●	133	153	203	25	32	0.5	
MVX2150X2F25	21.5	2	●	50	70	120	25	32	0.45	SOX07
MVX2150X3F25		3	●	71.5	91.5	141.5	25	32	0.45	
MVX2200X2F25	22.0	2	●	51	71	121	25	32	0.4	SOX07
MVX2200X3F25		3	●	73	93	143	25	32	0.4	
MVX2200X4F25		4	●	95	115	165	25	32	0.4	
MVX2200X5F25		5	●	117	137	187	25	32	0.4	
MVX2200X6F25		6	●	139	159	209	25	32	0.4	
MVX2250X2F25	22.5	2	●	52	72	122	25	32	0.35	SOX07
MVX2250X3F25		3	●	74.5	94.5	144.5	25	32	0.35	
MVX2300X2F25	23.0	2	●	53	73	123	25	32	0.8	SOX08
MVX2300X3F25		3	●	76	96	146	25	32	0.8	
MVX2300X4F25		4	●	99	119	169	25	32	0.8	
MVX2300X5F25		5	●	122	142	192	25	32	0.8	
MVX2300X6F25		6	●	145	165	215	25	32	0.8	
MVX2350X2F25	23.5	2	●	54	74	124	25	32	0.75	SOX08
MVX2350X3F25		3	●	77.5	97.5	147.5	25	32	0.75	
MVX2400X2F25	24.0	2	●	55	75	125	25	32	0.7	SOX08
MVX2400X3F25		3	●	79	99	149	25	32	0.7	
MVX2400X4F25		4	●	103	123	173	25	32	0.7	
MVX2400X5F25		5	●	127	147	197	25	32	0.7	
MVX2400X6F25		6	●	151	171	221	25	32	0.7	
MVX2450X2F25	24.5	2	●	56	76	126	25	32	0.65	
MVX2450X3F25		3	●	80.5	100.5	150.5	25	32	0.65	
MVX2500X2F25	25.0	2	●	57	77	127	25	32	0.6	SOX08
MVX2500X3F25		3	●	82	102	152	25	32	0.6	
MVX2500X4F25		4	●	107	127	177	25	32	0.6	
MVX2500X5F25		5	●	132	152	202	25	32	0.6	
MVX2500X6F25		6	●	157	177	227	25	32	0.6	
MVX2550X2F25	25.5	2	●	58	78	128	25	32	0.6	SOX08
MVX2550X3F25		3	●	83.5	103.5	153.5	25	32	0.6	
MVX2600X2F32	26.0	2	●	59	79	134	32	42	0.5	SOX08
MVX2600X3F32		3	●	85	105	160	32	42	0.5	
MVX2600X4F32		4	●	111	131	186	32	42	0.5	
MVX2600X5F32		5	●	137	157	212	32	42	0.5	
MVX2600X6F32		6	●	163	183	238	32	42	0.5	
MVX2650X2F32	26.5	2	●	60	80	135	32	42	0.5	SOX08
MVX2650X3F32		3	●	86.5	106.5	161.5	32	42	0.5	
MVX2700X2F32	27.0	2	●	61	81	136	32	42	0.45	SOX08
MVX2700X3F32		3	●	88	108	163	32	42	0.45	
MVX2700X4F32		4	●	115	135	190	32	42	0.45	
MVX2700X5F32		5	●	142	162	217	32	42	0.45	
MVX2700X6F32		6	●	169	189	244	32	42	0.45	
MVX2750X2F32	27.5	2	●	62	82	137	32	42	0.4	SOX08
MVX2750X3F32		3	●	89.5	109.5	164.5	32	42	0.4	

2/7

MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX2800X2F32	28.0	2	●	63	83	138	32	42	0.85	SOX09
MVX2800X3F32		3	●	91	111	166	32	42	0.85	
MVX2800X4F32		4	●	119	139	194	32	42	0.85	
MVX2800X5F32		5	●	147	167	222	32	42	0.85	
MVX2800X6F32		6	●	175	195	250	32	42	0.85	
MVX2850X2F32	28.5	2	●	64	84	139	32	42	0.8	SOX09
MVX2850X3F32		3	●	92.5	112.5	167.5	32	42	0.8	
MVX2900X2F32	29.0	2	●	65	85	140	32	42	0.75	SOX09
MVX2900X3F32		3	●	94	114	169	32	42	0.75	
MVX2900X4F32		4	●	123	143	198	32	42	0.75	
MVX2900X5F32		5	●	152	172	227	32	42	0.75	
MVX2900X6F32		6	●	181	201	256	32	42	0.75	
MVX2950X2F32	29.5	2	●	66	86	141	32	42	0.7	SOX09
MVX2950X3F32		3	●	95.5	115.5	170.5	32	42	0.7	
MVX3000X2F32	30.0	2	●	67	87	142	32	42	0.65	SOX09
MVX3000X3F32		3	●	97	117	172	32	42	0.65	
MVX3000X4F32		4	●	127	147	202	32	42	0.65	
MVX3000X5F32		5	●	157	177	232	32	42	0.65	
MVX3000X6F32		6	●	187	207	262	32	42	0.65	
MVX3050X3F32	30.5	3	●	98.5	118.5	173.5	32	42	0.6	SOX09
MVX3100X2F40	31.0	2	●	69	89	154	40	50	0.55	SOX09
MVX3100X3F40		3	●	100	120	185	40	50	0.55	
MVX3100X4F40		4	●	131	151	216	40	50	0.55	
MVX3100X5F40		5	●	162	182	247	40	50	0.55	
MVX3100X6F40		6	●	193	213	278	40	50	0.55	
MVX3150X3F40	31.5	3	●	101.5	121.5	186.5	40	50	0.55	SOX09
MVX3200X2F40	32.0	2	●	71	91	156	40	50	0.45	SOX09
MVX3200X3F40		3	●	103	123	188	40	50	0.45	
MVX3200X4F40		4	●	135	155	220	40	50	0.45	
MVX3200X5F40		5	●	167	187	252	40	50	0.45	
MVX3200X6F40		6	●	199	219	284	40	50	0.45	
MVX3250X3F40	32.5	3	●	104.5	124.5	189.5	40	50	0.45	SOX09
MVX3300X2F40	33.0	2	●	73	93	158	40	50	0.4	SOX09
MVX3300X3F40		3	●	106	126	191	40	50	0.4	
MVX3300X4F40		4	●	139	159	224	40	50	0.4	
MVX3300X5F40		5	●	172	192	257	40	50	0.4	
MVX3300X6F40		6	●	205	225	290	40	50	0.4	
MVX3350X3F40	33.5	3	●	107.5	127.5	192.5	40	50	1.2	SOX11
MVX3400X2F40	34.0	2	●	75	105	170	40	50	1.1	SOX11
MVX3400X3F40		3	●	109	139	204	40	50	1.1	
MVX3400X4F40		4	●	143	173	238	40	50	1.1	
MVX3400X5F40		5	●	177	207	272	40	50	1.1	
MVX3400X6F40		6	●	211	241	306	40	50	1.1	
MVX3450X3F40	34.5	3	●	110.5	140.5	205.5	40	50	1.1	SOX11
MVX3500X2F40	35.0	2	●	77	107	172	40	50	1.0	SOX11
MVX3500X3F40		3	●	112	142	207	40	50	1.0	
MVX3500X4F40		4	●	147	177	242	40	50	1.0	
MVX3500X5F40		5	●	182	212	277	40	50	1.0	
MVX3500X6F40		6	●	217	247	312	40	50	1.0	
MVX3550X3F40	35.5	3	●	113.5	143.5	208.5	40	50	1.0	SOX11

3/7

MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX3600X2F40	36.0	2	●	79	109	174	40	50	1.0	SOX11
MVX3600X3F40		3	●	115	145	210	40	50	1.0	
MVX3600X4F40		4	●	151	181	246	40	50	1.0	
MVX3600X5F40		5	●	187	217	282	40	50	1.0	
MVX3600X6F40		6	●	223	253	318	40	50	0.9	
MVX3700X2F40	37.0	2	●	81	111	176	40	50	0.9	SOX11
MVX3700X3F40		3	●	118	148	213	40	50	0.9	
MVX3700X4F40		4	●	155	185	250	40	50	0.9	
MVX3700X5F40		5	●	192	222	287	40	50	0.9	
MVX3700X6F40		6	●	229	259	324	40	50	0.9	
MVX3800X2F40	38.0	2	●	83	113	178	40	50	0.8	SOX11
MVX3800X3F40		3	●	121	151	216	40	50	0.8	
MVX3800X4F40		4	●	159	189	254	40	50	0.8	
MVX3800X5F40		5	●	197	227	292	40	50	0.8	
MVX3800X6F40		6	●	235	265	330	40	50	0.8	
MVX3900X2F40	39.0	2	●	85	115	180	40	50	0.7	SOX11
MVX3900X3F40		3	●	124	154	219	40	50	0.7	
MVX3900X4F40		4	●	163	193	258	40	50	0.7	
MVX3900X5F40		5	●	202	232	297	40	50	0.7	
MVX3900X6F40		6	●	241	271	336	40	50	0.7	
MVX4000X2F40	40.0	2	●	87	117	182	40	50	1.5	SOX13
MVX4000X3F40		3	●	127	157	222	40	50	1.5	
MVX4000X4F40		4	●	167	197	262	40	50	1.5	
MVX4000X5F40		5	●	207	237	302	40	50	1.5	
MVX4000X6F40		6	●	247	277	342	40	50	1.4	
MVX4100X2F40	41.0	2	●	89	119	184	40	50	1.4	SOX13
MVX4100X3F40		3	●	130	160	225	40	50	1.4	
MVX4100X4F40		4	●	171	201	266	40	50	1.4	
MVX4100X5F40		5	●	212	242	307	40	50	1.4	
MVX4100X6F40		6	●	253	283	348	40	50	1.4	
MVX4200X2F40	42.0	2	●	91	121	186	40	50	1.3	SOX13
MVX4200X3F40		3	●	133	163	228	40	50	1.3	
MVX4200X4F40		4	●	175	205	270	40	63	1.3	
MVX4200X4F50		4	★	175	205	280	50	63	1.3	
MVX4200X5F40		5	●	217	247	312	40	63	1.3	
MVX4200X5F50		5	★	217	247	322	50	63	1.3	
MVX4200X6F40		6	●	259	289	354	40	63	1.3	
MVX4200X6F50		6	★	259	289	364	50	63	1.3	
MVX4300X2F40	43.0	2	●	93	123	188	40	50	1.2	SOX13
MVX4300X3F40		3	●	136	166	231	40	50	1.2	
MVX4300X4F40		4	●	179	209	274	40	63	1.2	
MVX4300X4F50		4	★	179	209	284	50	63	1.2	
MVX4300X5F40		5	●	222	252	317	40	63	1.2	
MVX4300X5F50		5	★	222	252	327	50	63	1.2	
MVX4300X6F40		6	●	265	295	360	40	63	1.2	
MVX4300X6F50		6	★	265	295	370	50	63	1.2	

4/7



MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX4400X2F40	44.0	2	●	95	125	190	40	50	1.1	SOX13
MVX4400X3F40		3	●	139	169	234	40	50	1.1	
MVX4400X4F40		4	●	183	213	278	40	63	1.1	
MVX4400X4F50		4	★	183	213	288	50	63	1.1	
MVX4400X5F40		5	●	227	257	322	40	63	1.1	
MVX4400X5F50		5	★	227	257	332	50	63	1.1	
MVX4500X2F40	45.0	2	●	97	127	192	40	50	1.0	SOX13
MVX4500X3F40		3	●	142	172	237	40	50	1.0	
MVX4500X4F40		4	●	187	217	282	40	63	1.0	
MVX4500X4F50		4	★	187	217	292	50	63	1.0	
MVX4500X5F40		5	●	232	262	327	40	63	1.0	
MVX4500X5F50		5	★	232	262	337	50	63	1.0	
MVX4600X2F40	46.0	2	●	99	129	194	40	50	0.9	SOX13
MVX4600X3F40		3	●	145	175	240	40	50	0.9	
MVX4600X4F40		4	●	191	221	286	40	63	0.9	
MVX4600X4F50		4	★	191	221	296	50	63	0.9	
MVX4600X5F40		5	●	237	267	332	40	63	0.9	
MVX4600X5F50		5	★	237	267	342	50	63	0.9	
MVX4700X2F40	47.0	2	●	101	141	206	40	63	1.9	SOX16
MVX4700X3F40		3	●	148	188	253	40	63	1.9	
MVX4700X4F40		4	●	195	235	300	40	63	1.9	
MVX4700X4F50		4	★	195	235	310	50	63	1.9	
MVX4700X5F40		5	●	242	282	347	40	63	1.9	
MVX4700X5F50		5	★	242	282	357	50	63	1.9	
MVX4800X2F40	48.0	2	●	103	143	208	40	63	1.8	SOX16
MVX4800X3F40		3	●	151	191	256	40	63	1.8	
MVX4800X4F40		4	●	199	239	304	40	63	1.8	
MVX4800X4F50		4	★	199	239	314	50	63	1.8	
MVX4800X5F40		5	●	247	287	352	40	63	1.8	
MVX4800X5F50		5	★	247	287	362	50	63	1.8	
MVX4900X2F40	49.0	2	●	105	145	210	40	63	1.7	SOX16
MVX4900X3F40		3	●	154	194	259	40	63	1.7	
MVX4900X4F40		4	●	203	243	308	40	63	1.7	
MVX4900X4F50		4	★	203	243	318	50	63	1.7	
MVX4900X5F40		5	●	252	292	357	40	63	1.7	
MVX4900X5F50		5	★	252	292	367	50	63	1.7	
MVX5000X2F40	50.0	2	●	107	147	212	40	63	1.6	SOX16
MVX5000X3F40		3	●	157	197	262	40	63	1.6	
MVX5000X4F40		4	●	207	247	312	40	63	1.6	
MVX5000X4F50		4	★	207	247	322	50	63	1.6	
MVX5000X5F40		5	●	257	297	362	40	63	1.6	
MVX5000X5F50		5	★	257	297	372	50	63	1.6	
MVX5100X2F40	51.0	2	●	109	149	214	40	63	1.5	SOX16
MVX5100X3F40		3	●	160	200	265	40	63	1.5	
MVX5100X4F40		4	●	211	251	316	40	63	1.5	
MVX5100X4F50		4	★	211	251	326	50	63	1.5	
MVX5100X5F40		5	●	262	302	367	40	63	1.5	
MVX5100X5F50		5	★	262	302	377	50	63	1.5	

5/7



MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX5200X2F40	52.0	2	●	111	151	216	40	63	1.4	SOX16
MVX5200X3F40		3	●	163	203	268	40	63	1.4	
MVX5200X4F40		4	●	215	255	320	40	63	1.4	
MVX5200X4F50		4	★	215	255	330	50	63	1.4	
MVX5200X5F40		5	●	267	307	372	40	63	1.4	
MVX5200X5F50		5	★	267	307	382	50	63	1.4	
MVX5300X2F40	53.0	2	●	113	153	218	40	63	1.3	SOX16
MVX5300X3F40		3	●	166	206	271	40	63	1.3	
MVX5300X4F40		4	●	219	259	324	40	63	1.3	
MVX5300X4F50		4	★	219	259	334	50	63	1.3	
MVX5300X5F40		5	●	272	312	377	40	63	1.3	
MVX5300X5F50		5	★	272	312	387	50	63	1.3	
MVX5400X2F40	54.0	2	●	115	155	220	40	63	1.2	SOX16
MVX5400X3F40		3	●	169	209	274	40	63	1.2	
MVX5400X4F40		4	●	223	263	328	40	63	1.2	
MVX5400X4F50		4	★	223	263	338	50	63	1.2	
MVX5400X5F40		5	●	277	317	382	40	63	1.2	
MVX5400X5F50		5	★	277	317	392	50	63	1.2	
MVX5500X2F40	55.0	2	●	117	157	222	40	63	1.1	SOX16
MVX5500X3F40		3	●	172	212	277	40	63	1.1	
MVX5500X4F40		4	●	227	267	332	40	63	1.1	
MVX5500X4F50		4	★	227	267	342	50	63	1.1	
MVX5500X5F40		5	●	282	322	387	40	63	1.1	
MVX5500X5F50		5	★	282	322	397	50	63	1.1	
MVX5600X2F40	56.0	2	●	119	159	224	40	63	1.0	SOX16
MVX5600X3F40		3	●	175	215	280	40	63	1.0	
MVX5600X4F40		4	●	231	271	336	40	63	1.0	
MVX5600X4F50		4	★	231	271	346	50	63	1.0	
MVX5600X5F40		5	●	287	327	392	40	63	1.0	
MVX5600X5F50		5	★	287	327	402	50	63	1.0	
MVX5700X2F40	57.0	2	●	121	161	226	40	68	1.5	SOX18
MVX5700X3F40		3	●	178	218	283	40	68	1.5	
MVX5700X4F40		4	●	235	275	340	40	68	1.5	
MVX5700X4F50		4	★	235	275	350	50	68	1.5	
MVX5700X5F40		5	●	292	332	397	40	68	1.5	
MVX5700X5F50		5	★	292	332	407	50	68	1.5	
MVX5800X2F40	58.0	2	●	123	163	228	40	68	1.4	SOX18
MVX5800X3F40		3	●	181	221	286	40	68	1.4	
MVX5800X4F40		4	●	239	279	344	40	68	1.4	
MVX5800X4F50		4	★	239	279	354	50	68	1.4	
MVX5800X5F40		5	●	297	337	402	40	68	1.4	
MVX5800X5F50		5	★	297	337	412	50	68	1.4	
MVX5900X2F40	59.0	2	●	125	165	230	40	68	1.3	SOX18
MVX5900X3F40		3	●	184	224	289	40	68	1.3	
MVX5900X4F40		4	●	243	283	348	40	68	1.3	
MVX5900X4F50		4	★	243	283	358	50	68	1.3	
MVX5900X5F40		5	●	302	342	407	40	68	1.3	
MVX5900X5F50		5	★	302	342	417	50	68	1.3	

6/7

MVX

Codice ordinazione	DC	L x DC	Disponibilità	LBX	LPR	OAL	DCON	DCSFMS	A	Inserti
MVX6000X2F40	60.0	2	●	127	167	232	40	68	1.2	SOX18
MVX6000X3F40		3	●	187	227	292	40	68	1.2	
MVX6000X4F40		4	●	247	287	352	40	68	1.2	
MVX6000X4F50		4	★	247	287	362	50	68	1.2	
MVX6000X5F40		5	●	307	347	412	40	68	1.2	
MVX6000X5F50		5	★	307	347	422	50	68	1.2	
MVX6100X2F40	61.0	2	●	129	169	234	40	68	1.1	SOX18
MVX6100X3F40		3	●	190	230	295	40	68	1.1	
MVX6100X4F40		4	●	251	291	356	40	68	1.1	
MVX6100X4F50		4	★	251	291	366	50	68	1.1	
MVX6100X5F40		5	●	312	352	417	40	68	1.1	
MVX6100X5F50		5	★	312	352	427	50	68	1.1	
MVX6200X2F40	62.0	2	●	131	171	236	40	68	1.0	SOX18
MVX6200X3F40		3	●	193	233	298	40	68	1.0	
MVX6200X4F40		4	●	255	295	360	40	68	1.0	
MVX6200X4F50		4	★	255	295	370	50	68	1.0	
MVX6200X5F40		5	●	317	357	422	40	68	1.0	
MVX6200X5F50		5	★	317	357	432	50	68	1.0	
MVX6300X2F40	63.0	2	●	133	173	238	40	68	0.8	SOX18
MVX6300X3F40		3	●	196	236	301	40	68	0.8	
MVX6300X4F40		4	●	259	299	364	40	68	0.8	
MVX6300X4F50		4	★	259	299	374	50	68	0.8	
MVX6300X5F40		5	●	322	362	427	40	68	0.8	
MVX6300X5F50		5	★	322	362	437	50	68	0.8	

7/7

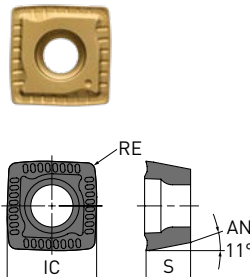
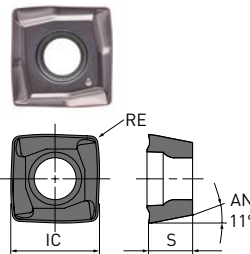
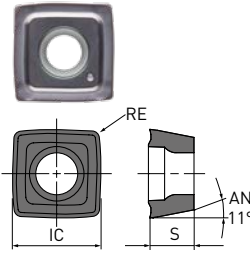
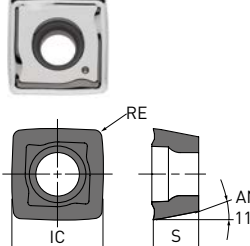
RICAMBI

Diametro punta (mm)		Coppia di bloccaggio (Nm)	Chiave
	Vite inserto		
14 – 16.5	TPS20-1	0.6	TIP06F
17 – 19.5	TPS25	1.0	TIP07F
20 – 22.5	TPS3	2.0	TIP10W
23 – 27.5	TPS351	2.5	TIP10W
28 – 33	TPS4	3.5	TIP15W
33.5 – 46	TPS43	3.5	TIP15W
47 – 63	TPS54	7.5	TIP25D

TOLLERANZE DEI FORI ESEGUITI

L x DC	Ø 14 – 33	Ø 17 – 33	Ø 33.5 – 47	Ø 48 – 63
2-3	+ 0.25 0	+ 0.25 0	+ 0.3 0	+ 0.3 0
4-5	+ 0.35 0	+ 0.35 0	+ 0.4 0	+ 0.45 0
6	+ 0.45 0	+ 0.45 0	+ 0.6 0	—

INSERTI

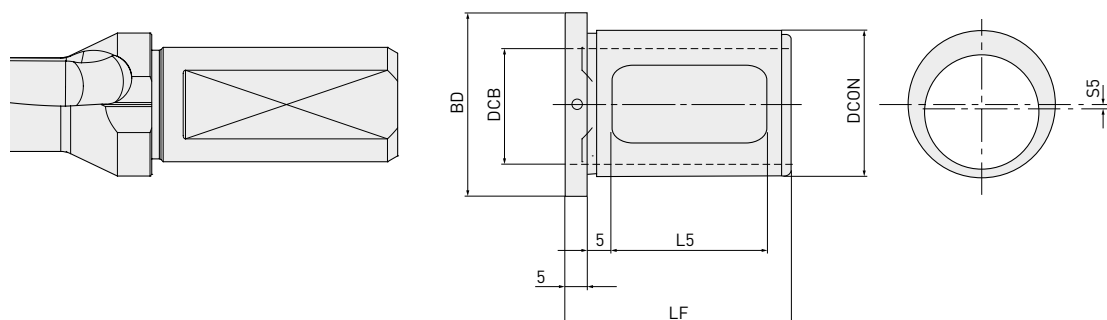
Codice ordinazione	MC5020 *	MC1020 *	VP15TF	DP8020	TF15	IC	S	RE	Diam. punta	Geometria
UM										
SOMX052704-UM	●	●	●			5.0	2.7	0.4	Ø14 – 16.5	
SOMX063005-UM	●	●	●			6.0	3.0	0.5	Ø17 – 19.5	
SOMX073505-UM	●	●	●			7.0	3.5	0.5	Ø20 – 22.5	
SOMX084005-UM	●	●	●			8.3	4.0	0.5	Ø23 – 27.5	
SOMX094506-UM	●	●	●			9.7	4.5	0.6	Ø28 – 33	
SOMX115506-UM	●	●	●			11.6	5.5	0.6	Ø33.5 – 39	
SOMX136008-UM	●	●	●			13.8	6.0	0.8	Ø40 – 46	
SOMX166508-UM	●	●	●			16.5	6.5	0.8	Ø47 – 56	
SOMX187008-UM	●	●	●			18.2	7.0	0.8	Ø57 – 63	
US										
SOMX063005-US			●			6.0	3.0	0.5	Ø17 – 19.5	
SOMX073505-US			●			7.0	3.5	0.5	Ø20 – 22.5	
SOMX084005-US			●			8.3	4.0	0.5	Ø23 – 27.5	
SOMX094506-US			●			9.7	4.5	0.6	Ø28 – 33	
SOMX115506-US			●			11.6	5.5	0.6	Ø33.5 – 39	
SOMX136008-US			●			13.8	6.0	0.8	Ø40 – 46	
SOMX166508-US			●			16.5	6.5	0.8	Ø47 – 56	
SOMX187008-US			●			18.2	7.0	0.8	Ø57 – 63	
UH										
SOMX062905-UH				●		6.0	2.9	0.5	Ø17 – 19.5	
SOMX073405-UH				●		7.0	3.4	0.5	Ø20 – 22.5	
SOMX083905-UH				●		8.3	3.9	0.5	Ø23 – 27.5	
SOMX094406-UH				●		9.7	4.4	0.6	Ø28 – 33	
SOMX115406-UH				●		11.6	5.4	0.6	Ø33.5 – 39	
SOMX135908-UH				●		13.8	5.9	0.8	Ø40 – 46	
SOMX166408-UH				●		16.5	6.4	0.8	Ø47 – 56	
SOMX186908-UH				●		18.2	6.9	0.8	Ø57 – 63	
UN										
SOGX063005-UN					●	6.0	3.0	0.5	Ø17 – 19.5	
SOGX073505-UN					●	7.0	3.5	0.5	Ø20 – 22.5	
SOGX084005-UN					●	8.3	4.0	0.5	Ø23 – 27.5	
SOGX094506-UN					●	9.7	4.5	0.6	Ø28 – 33	
SOGX115506-UN					●	11.6	5.5	0.6	Ø33.5 – 39	
SOGX136008-UN					●	13.8	6.0	0.8	Ø40 – 46	
SOGX166508-UN					●	16.5	6.5	0.8	Ø47 – 56	
SOGX187008-UN					●	18.2	7.0	0.8	Ø57 – 63	

MC1020 e MC5020 sono utilizzabili unicamente come inserti esterni.



MANICOTTO "JUST FIT" [JFS]

PERMETTE L'INCREMENTO DEL DIAMETRO DI FORATURA



Codice ordinazione pezzo singolo	Codice ordinazione set	Disponibilità	DCB	DCON	BD	LF	L5	Incremento * [S5x2]	Tipo di attacco MVX
JFS2520-10	JFS-1	●	20	25	33	43	30	0.1	F20
JFS2520-20		●	20	25	33	43	30	0.2	F20
JFS2520-30		●	20	25	33	43	30	0.3	F20
JFS2520-40		●	20	25	33	43	30	0.4	F20
JFS2520-50		●	20	25	33	43	30	0.5	F20
JFS3225-10	JFS-2	●	25	32	40	50	34	0.1	F25
JFS3225-20		●	25	32	40	50	34	0.2	F25
JFS3225-30		●	25	32	40	50	34	0.3	F25
JFS3225-40		●	25	32	40	50	34	0.4	F25
JFS3225-50		●	25	32	40	50	34	0.5	F25
JFS4032-10	JFS-3	●	32	40	48	55	40	0.1	F32
JFS4032-20		●	32	40	48	55	40	0.2	F32
JFS4032-30		●	32	40	48	55	40	0.3	F32
JFS4032-40		●	32	40	48	55	40	0.4	F32
JFS4032-50		●	32	40	48	55	40	0.5	F32
JFS5040-10	—	★	40	50	68	65	50	0.1	F40
JFS5040-20		★	40	50	68	65	50	0.2	F40
JFS5040-30		★	40	50	68	65	50	0.3	F40
JFS5040-40		★	40	50	68	65	50	0.4	F40
JFS5040-50		★	40	50	68	65	50	0.5	F40

Incremento: dimensione del diametro di foratura.
Non adatto a codoli con Ø 50 mm.

GUIDA ALLA SELEZIONE DI UN MANICOTTO "JUST FIT"

Diametro desiderato = (Ø punta+ Incremento manicotti "just fit") + 0.1 mm

(Es.) Diametro desiderato 20.3mm (maggiorazione 0.1mm).

$$\text{Ø}20.3 = (\text{MVX2000 X } \text{F25} + \text{JFS3225-20}) + 0.1$$

↓
Punta 20mm

↓
Usando il manicotto
Just Fit incremento
di 0.2 mm.

↓
Maggiorazione

<Utensile scelto>
PUNTE: **MVX2000 X F25**
Manicotto "Just Fit" [JFS]:
JFS3225-20

La maggiorazione può variare a seconda dei parametri di taglio : la spiegazione serve solo a scopo indicativo.

ORDINAZIONE MANICOTTO JUST FIT

Metodo di ordinazione 1

La maggiorazione può variare a seconda dei parametri di taglio. Si raccomanda quindi di acquistare il set. Per passare un ordine, usare il numero di ordinazione del set. (Serie di 5 manicotti)

Metodo di ordinazione 2

È possibile ordinare il manicotto singolarmente. Per passare un ordine, usare il numero di ordinazione pezzo singolo.

MVX + MINI MVX

CONDIZIONI DI TAGLIO RACCOMANDATE

	Materiale da lavorare	Durezza	Vc	Rompitrucolo interno	Ø14 - Ø16.5			Ø17 - Ø19.5			
					f			f			
					LxDC=2 - 3	LxDC=4	LxDC=5	LxDC=2 - 3	LxDC=4	LxDC=5	LxDC=6
P	Acciaio dolce (C15, Ck15)	≤180HB	200 (180 - 235)	UM	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)
				UH	—	—	—	—	—	—	—
	Acciaio al carbonio, acciaio legato (Ck45, 41CrMo4)	180 - 280HB	140 (115 - 180)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.05 (0.04 - 0.06)
				UH	—	—	—	—	—	—	—
	Acciaio al carbonio, acciaio legato (100Cr6)	280 - 350HB	100 (75 - 140)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.05 (0.04 - 0.06)
				UH	—	—	—	—	—	—	—
	Leghe di acciaio per utensili (X210Cr12)	≤350HB	135 (100 - 170)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.05 (0.04 - 0.06)
				UH	—	—	—	—	—	—	—
M	Acciaio inossidabile austenitico (X5CrNi18-10, X5CrNiMo17-12-2)	≤200HB	130 (80 - 180)	US	—	—	—	0.08 (0.06 - 0.12)	0.06 (0.04 - 0.08)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)
	Acciaio inossidabile austenitico (X2CrNi18-9, X5CrNiMo17-11-2)	>200HB	130 (80 - 180)	US	—	—	—	0.08 (0.06 - 0.12)	0.06 (0.04 - 0.08)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)
	Acciaio inossidabile, ferritico e martensitico (X12Cr13, X6Cr17)	≤200HB	120 (80 - 165)	US	—	—	—	0.08 (0.06 - 0.12)	0.06 (0.04 - 0.08)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)
	Acciaio inossidabile, ferritico e martensitico (X17CrNi16-2, X30Cr13)	>200HB	120 (80 - 165)	US	—	—	—	0.08 (0.06 - 0.12)	0.06 (0.04 - 0.08)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)
K	Ghisa grigia (GG25, GG30)	Resistenza alla trazione ≤350MPa	160 (130 - 195)	UM	0.10 (0.06 - 0.14)	0.08 (0.06 - 0.10)	0.08 (0.06 - 0.10)	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)
	Ghisa sferoidale (GGG40)	Resistenza alla trazione ≤450MPa	100 (80 - 135)	UM	0.10 (0.06 - 0.14)	0.08 (0.06 - 0.10)	0.08 (0.06 - 0.10)	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)
	Ghisa sferoidale (GGG70)	Resistenza alla trazione ≤800MPa	100 (70 - 125)	UM	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)
N	Lega di alluminio (A6061, A7075)	Si<5%	200 (100 - 350)	UN	—	—	—	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Lega di alluminio (AC4B)	5%≤Si<10%	150 (100 - 200)	UN	—	—	—	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Lega di alluminio (ADC12, A390)	Si>10%	150 (100 - 200)	UN	—	—	—	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
H	Acciaio temprato (X40CrMoV51, 55NiCrMoV6)	38 - 45HRC	50 (30 - 80)	UH	—	—	—	0.08 (0.04 - 0.12)	0.06 (0.04 - 0.09)	—	—

MVX + MINI MVX CONDIZIONI DI TAGLIO RACCOMANDATE

Vc			Ø20 – Ø23.5				Ø24 – Ø29.5				Ø30 – Ø63			
			f				f				f			
			LxDC=2–3	LxDC=4	LxDC=5	LxDC=6	LxDC=2–3	LxDC=4	LxDC=5	LxDC=6	LxDC=2–3	LxDC=4	LxDC=5	LxDC=6
P	200 (180 – 235)	UM UH	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.07)	0.06 (0.04 – 0.07)	0.04 (0.04 – 0.05)	0.07 (0.04 – 0.08)	0.06 (0.04 – 0.07)	0.06 (0.04 – 0.07)	0.05 (0.04 – 0.06)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)
	140 (115 –180)	UM UH	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.11 (0.10 – 0.12)
	100 (75 – 140)	UM UH	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.11 (0.10 – 0.12)
	135 (100 – 170)	UM UH	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.10 (0.08 – 0.12)
M	130 (80 – 180)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
	130 (80 – 180)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
	120 (80 – 165)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
120 (80 – 165)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)	
	UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	
K	160 (130 – 195)	UM	0.14 (0.10 – 0.18)	0.10 (0.10 – 0.12)	0.10 (0.10 – 0.12)	0.07 (0.06 – 0.08)	0.15 (0.10 – 0.20)	0.11 (0.10 – 0.13)	0.11 (0.10 – 0.13)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
	100 (80 – 135)	UM	0.13 (0.10 – 0.16)	0.10 (0.10 – 0.11)	0.10 (0.10 – 0.11)	0.07 (0.06 – 0.08)	0.14 (0.10 – 0.18)	0.11 (0.10 – 0.12)	0.11 (0.10 – 0.12)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
	100 (70 – 125)	UM	0.13 (0.10 – 0.16)	0.10 (0.10 – 0.11)	0.10 (0.10 – 0.11)	0.07 (0.06 – 0.08)	0.14 (0.10 – 0.18)	0.11 (0.10 – 0.12)	0.11 (0.10 – 0.12)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
N	200 (100 – 350)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	150 (100 – 200)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	150 (100 – 200)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
H	50 (30 – 80)	UH	0.09 (0.06 – 0.14)	0.07 (0.06 – 0.09)	—	—	0.09 (0.06 – 0.14)	0.07 (0.06 – 0.09)	—	—	0.11 (0.06 – 0.16)	0.09 (0.06 – 0.12)	—	—
2/2														

Ridurre la velocità di taglio del 30 % quando si usa VP15TF come inserto esterno.
L/D = 3 è la profondità massima consigliata quando si usa solo refrigerante esterno.
Il passaggio di refrigerante interno è essenziale quando si fora l'acciaio inossidabile.

NOTE

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