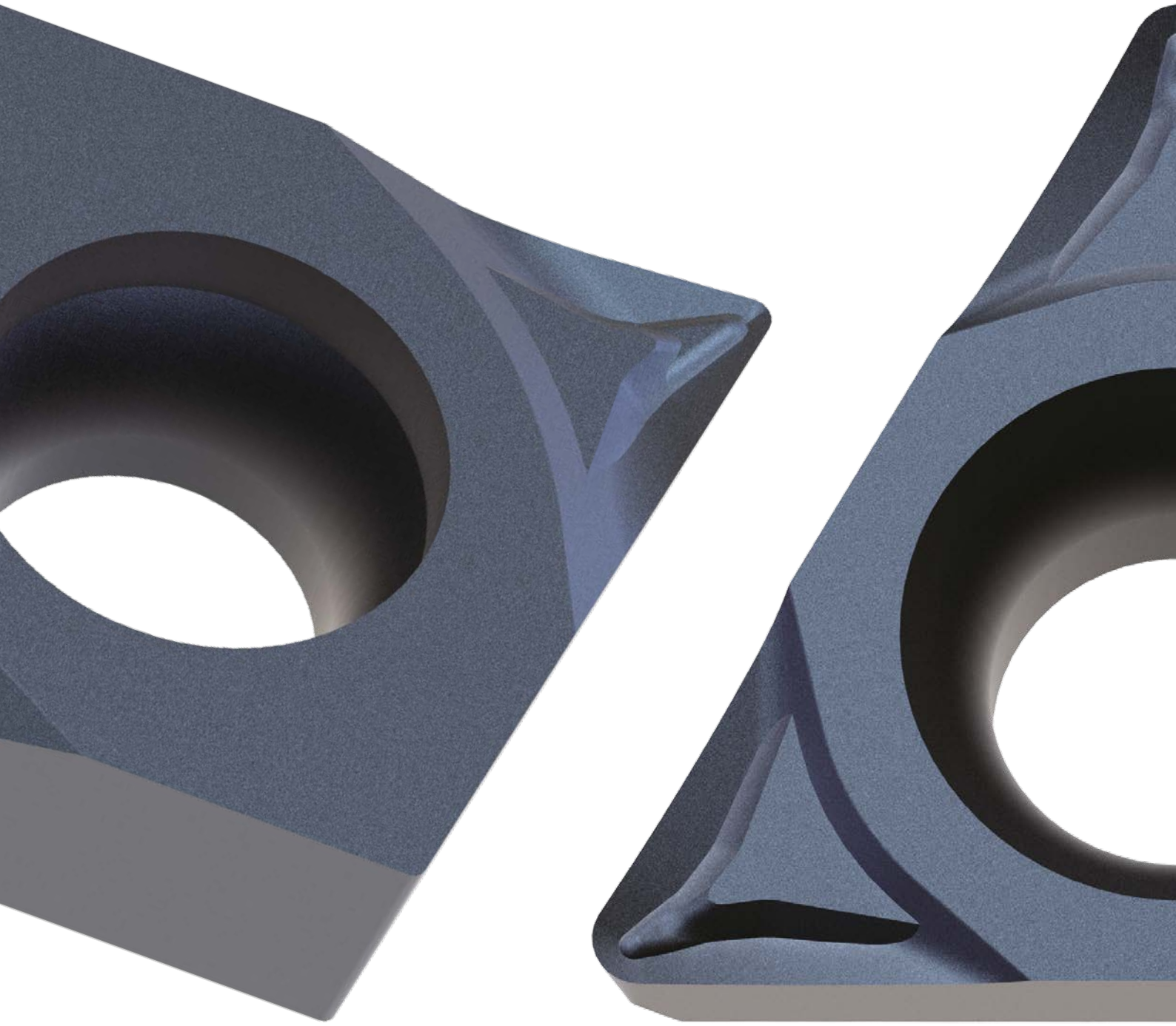
ROMPEVIRUTAS FSF / FSF-P

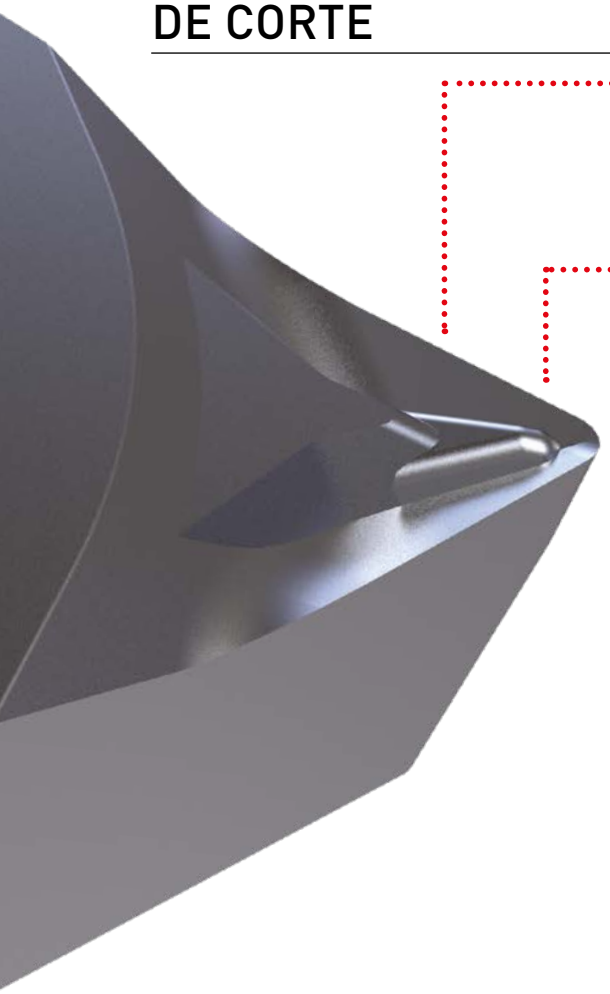
ROMPEVIRUTAS RECOMENDADO PARA PEQUEÑAS PROFUNDIDADES DE CORTE Y OPERACIONES DE ACABADO



MITSUBISHI MATERIALS

ROMPEVIRUTAS FSF / FSF-P

ROMPEVIRUTAS PARA PEQUEÑAS PROFUNDIDADES DE CORTE

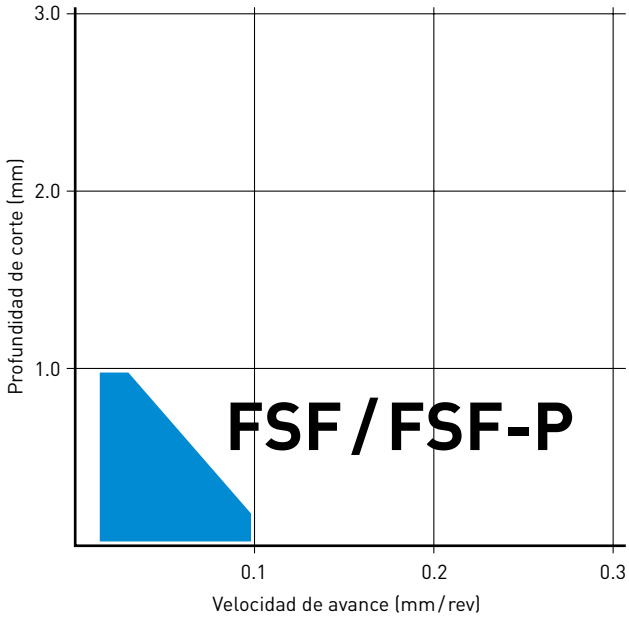


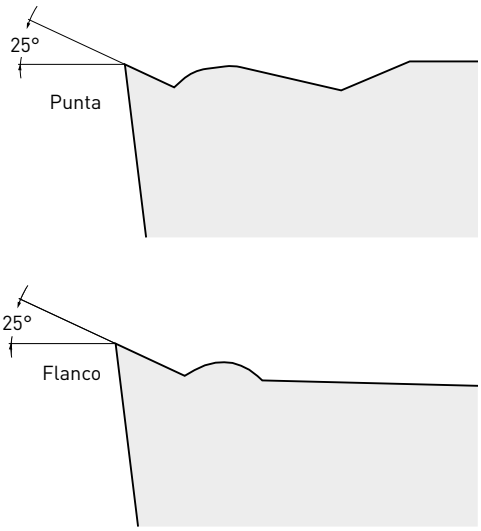
FILO DE CORTE POSITIVO
El ángulo de 25° proporciona un filo de corte positivo y un excelente acabado superficial.

BAJA RESISTENCIA AL CORTE
Diseño con bajo esfuerzo de corte y generosa protuberancia en el rompevirutas.

ROMPEVIRUTAS MULTIETAPA
Se adapta a las variaciones en la profundidad de corte.

RANGO DE APLICACIÓN

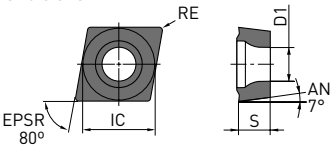




CCGT

PLACAS POSITIVAS DE 7° (CON AGUJERO)

Clase G



FSF	FSF-P

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
CCGT03S101M-FSF	F	●					3.97	1.39	0.1	2.0
CCGT03S102M-FSF	F	●					3.97	1.39	0.2	2.0
CCGT04T001M-FSF	F	●					4.76	1.79	0.1	2.4
CCGT04T002M-FSF	F	●					4.76	1.79	0.2	2.4
CCGT060201M-FSF	F	●					6.35	2.38	0.1	2.8
CCGT060202M-FSF	F	●					6.35	2.38	0.2	2.8
CCGT060204M-FSF	F	●					6.35	2.38	0.4	2.8
CCGT03S101M-FSF-P	F		●	●			3.97	1.39	0.1	2.0
CCGT03S102M-FSF-P	F		●	●			3.97	1.39	0.2	2.0
CCGT04T001M-FSF-P	F		●	●			4.76	1.79	0.1	2.4
CCGT04T002M-FSF-P	F		●	●			4.76	1.79	0.2	2.4
CCGT0602V5M-FSF-P	F		●		●		6.35	2.38	0.05	2.8
CCGT060201M-FSF-P	F		●	●	●		6.35	2.38	0.1	2.8
CCGT060202M-FSF-P	F		●	●	●		6.35	2.38	0.2	2.8
CCGT060204M-FSF-P	F		●	●	●		6.35	2.38	0.4	2.8
CCGT09T3V5M-FSF-P	F		●		●		9.525	3.97	0.05	4.4
CCGT09T301M-FSF-P	F		●	●	●		9.525	3.97	0.1	4.4
CCGT09T302M-FSF-P	F		●		●		9.525	3.97	0.2	4.4
CCGT09T304M-FSF-P	F		●		●		9.525	3.97	0.4	4.4

1/1

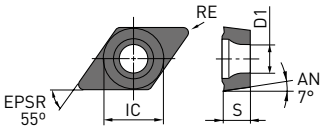
7 Vc

● : Stock Europa. ★ : Stock Japón.

DCGT

PLACAS POSITIVAS DE 7° (CON AGUJERO)

Clase G



FSF	FSF-P

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
DCGT070201M-FSF	F	●					6.35	2.38	0.1	2.8
DCGT070202M-FSF	F	●					6.35	2.38	0.2	2.8
DCGT11T301M-FSF	F	●					9.525	3.97	0.1	4.4
DCGT11T302M-FSF	F	●					9.525	3.97	0.2	4.4
DCGT0702V5M-FSF-P	F		●		●		6.35	2.38	0.05	2.8
DCGT070201M-FSF-P	F		●	●	●		6.35	2.38	0.1	2.8
DCGT070202M-FSF-P	F		●	●	●		6.35	2.38	0.2	2.8
DCGT11T3V5M-FSF-P	F		●		●		9.525	3.97	0.05	4.4
DCGT11T301M-FSF-P	F		●	●	●		9.525	3.97	0.1	4.4
DCGT11T302M-FSF-P	F		●	●	●		9.525	3.97	0.2	4.4
DCGT11T304M-FSF-P	F		●		●		9.525	3.97	0.4	4.4

1/1

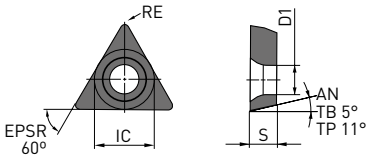
7 Vc

● : Stock Europa. ★ : Stock Japón.

TBGT, TPGH

PLACAS POSITIVAS DE 5°, 11° (CON AGUJERO)

Clase G



FSF-P	FSF	FSF-P

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
TBGT060101M-FSF-P	F		●	●	●		3.97	1.59	0.1	2.3
TBGT060102M-FSF-P	F		●		●		3.97	1.59	0.2	2.3
TPGH090201M-FSF	F	●					5.56	2.38	0.1	2.9
TPGH090202M-FSF	F	●					5.56	2.38	0.2	2.9
TPGH090204M-FSF	F	●					5.56	2.38	0.4	2.9
TPGH080201M-FSF-P	F		●	●	●		4.76	2.38	0.1	2.4
TPGH080202M-FSF-P	F		●		●		4.76	2.38	0.2	2.4
TPGH090201M-FSF-P	F		●	●	●		5.56	2.38	0.1	2.9
TPGH090202M-FSF-P	F		●	●	●		5.56	2.38	0.2	2.9
TPGH090204M-FSF-P	F		●	●	●		5.56	2.38	0.4	2.9

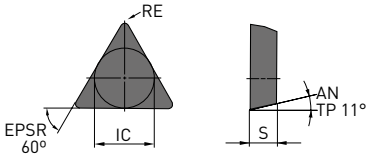
1/1

7 Vc

TPGB

PLACAS POSITIVAS DE 11° (SIN AGUJERO)

Clase G



Filo de corte resistente

Sin rompevirutas

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
TPGB110201	M					●	6.35	2.38	0.1	—
TPGB110202	M					●	6.35	2.38	0.2	—
TPGB110204	M					●	6.35	2.38	0.4	—
TPGB160304	M					●	9.525	3.18	0.4	—
TPGB160308	M					●	9.525	3.18	0.8	—
TPGB080202	M					●	4.76	2.38	0.2	—
TPGB080204	M					●	4.76	2.38	0.4	—
TPGB080208	M					●	4.76	2.38	0.8	—
TPGB090202	M					●	5.56	2.38	0.2	—
TPGB090204	M					●	5.56	2.38	0.4	—
TPGB1102V5	M					●	6.35	2.38	0.05	—
TPGN090202	–					●	5.56	2.38	0.2	—
TPGN090204	–					●	5.56	2.38	0.4	—
TPGN090208	–					●	5.56	2.38	0.8	—

1/1

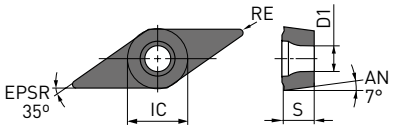
● : Stock Europa. ★ : Stock Japón.

7 Vc

VCGT, VPGT

PLACAS POSITIVAS DE 7°, 11° (CON AGUJERO)

Clase G



FSF-P	FSF-P	FS-P

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
VCGT110301M-FSF-P	F		●	●	●		6.35	3.18	0.1	2.8
VCGT110302M-FSF-P	F		●		●		6.35	3.18	0.2	2.8
VCGT110304M-FSF-P	F		●		●		6.35	3.18	0.4	2.8
VPGT110301M-FSF-P	F		●	●	●		6.35	3.18	0.1	2.9
VPGT110302M-FSF-P	F		●		●		6.35	3.18	0.2	2.9
VPGT110304M-FSF-P	F		●		●		6.35	3.18	0.4	2.9
VPGT110301M-FS-P	F		●		●		6.35	3.18	0.1	2.9
VPGT110302M-FS-P	F		●		●		6.35	3.18	0.2	2.9

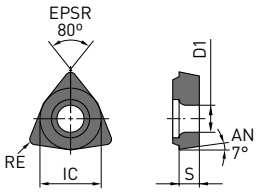
1/1

7 Vc

WCGT

PLACAS POSITIVAS DE 7° (CON AGUJERO)

Clase G



FSF-P

Referencia	F M	MP9025	MS7025	MS9025	VP30RT	HTI10	IC	S	RE	D1
WCGT020101M-FSF-P	F		●	●	●		3.97	1.59	0.1	2.3
WCGT020102M-FSF-P	F		●	●	●		3.97	1.59	0.2	2.3
WCGTL30201M-FSF-P	F		●	●	●		4.76	2.38	0.1	2.3
WCGTL30202M-FSF-P	F		●	●	●		4.76	2.38	0.2	2.3
WCGT040201M-FSF-P	F		●	●	●		6.35	2.38	0.1	2.8
WCGT040202M-FSF-P	F		●	●	●		6.35	2.38	0.2	2.8
WCGT06T301M-FSF-P	F			●			9.525	3.97	0.1	4.4
WCGT06T302M-FSF-P	F		●	●	●		9.525	3.97	0.2	4.4
WCGT06T304M-FSF-P	F		●		●		9.525	3.97	0.4	4.4

1/1

7 Vc

● : Stock Europa. ★ : Stock Japón.

ROMPEVIRUTAS FSF / FSF-P

CONDICIONES DE CORTE RECOMENDADAS

VELOCIDAD DE CORTE

	Materiales	Propiedades	F M	Tipo de corte	MP9025 Vc	MS7025 Vc	MS9025 Vc	VP30RT Vc	HTI10 Vc
P	Acero dulce	≤ 180 HB	F	●	—	100 – 300	—	—	—
				✣	—	—	—	155 – 190	—
	Acero al carbono, acero aleado	180–280 HB	F	●	—	40 – 130	—	—	—
				✣	—	—	—	115 – 140	—
	Acero al carbono, acero aleado	280–350 HB	F	✣	—	—	—	80 – 100	—
M	Acero inoxidable, Austenítico	≤ 200 HB	F	●	—	40 – 100	60 – 150	—	—
				✣	—	—	—	50 – 90	—
	Acero inoxidable ferrítico y martensítico	≤ 200 HB	F	●	—	40 – 100	—	—	—
			F	✣	—	—	—	50 – 90	—
	Acero inoxidable austenítico ferrítico y martensítico	>200 HB	F	✣	—	—	—	40 – 75	—
	Acero inoxidable electromagnético	230 HBW	F	●	—	40 – 160	50 – 180	—	—
	Acero inoxidable dúplex	≤ 280 HB	F	✣	—	—	—	35 – 60	—
	Acero inoxidable endurecido por precipitación	< 450 HB	F	✣	70 – 85	40 – 80	50 – 100	—	—
K	Fundición gris	≤ 350 MPa	M	◐ ✣	—	—	—	—	90 – 125
	Fundición dúctil	≤ 450 MPa	M	● ◐ ✣	—	—	—	—	70 – 100
	Fundición dúctil	≤ 800 MPa	M	● ◐ ✣	—	—	—	—	60 – 90
N	Aleaciones de aluminio	—	M	● ◐ ✣	—	—	—	—	300 – 700
S	Aleaciones termorresistentes	—	F	●	—	—	40 – 140	—	—
				✣	25 – 40	—	—	—	—

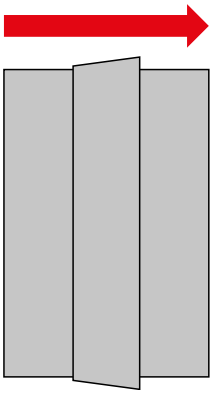
1/1

Rompevirutas	f (mm / rev)	ap (mm)
FSF, FSF-P	0.02 – 0.1	0.02 – 1.0
FS-P	0.04 – 0.2	0.2 – 0.9
Estándar	0.08 – 0.3	0.3 – 2.0
Sin rompevirutas	0.08 – 0.3	0.3 – 2.0

EJEMPLOS DE APLICACIÓN

TORNEADO EXTERIOR

Material	DIN 1.4301 (X5CrNi18-10)
Placa	DCGT11T301M-FSF-P
Calidad	MS9025
Vc (m/min)	120
f (mm/rev)	0.02
ap (mm)	0.1
Refrigeración	Corte refrigerado (aceite)
Resultado	Se reduce el desgaste en el filo de corte y la evacuación de virutas mejora Ahora es posible realizar 750 piezas en comparación con las 150 piezas de vida útil convencional de la herramienta.



Condiciones de corte: ● : Corte continuo ◐ : Corte general ✣ : Corte interrumpido
Área de corte: F: Corte de acabado M: Corte medio

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