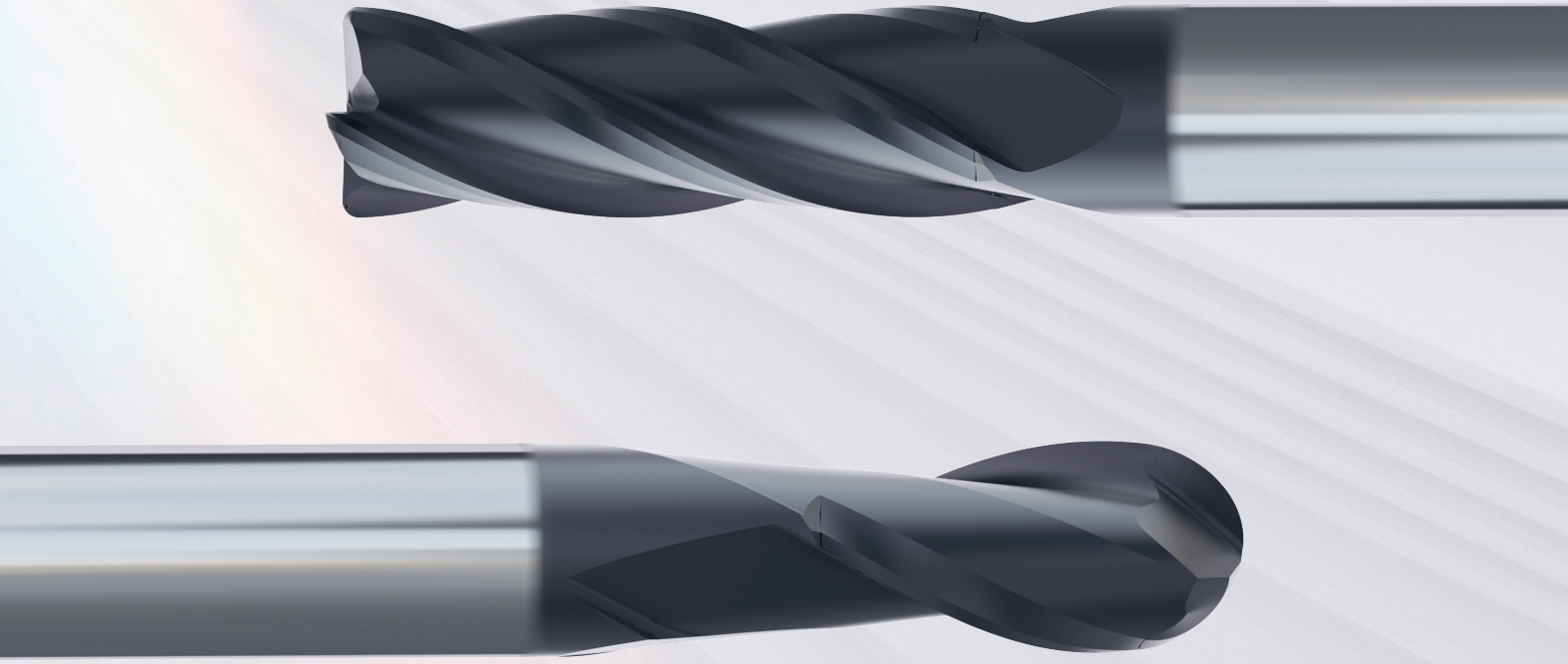
Seco

Catalog & ghid tehnic

Freze din carbură solidă 2026.1



La Seco, realizăm unelte, tehnologii și soluții pentru cele mai avansate provocări de fabricație de pe Pământ. De la înființarea noastră în Fagersta Suedia, până la compania globală de astăzi, afacerea noastră a fost întotdeauna făcută pe măsură și construită pe încredere.

Combinând uneltele de precizie de ultimă oră, de precizie, cu parteneriate personale durabile, suntem o adevărată companie de oameni care îi ajută pe partenerii noștri să descopere viitorul industriei prelucrătoare.

Suntem mândri să creăm pentru creatori, să inventăm pentru inventatori și să fim parteneri cu pionierii. Impulsionăm viitorul cu accentul pe inovație. Pe scurt - dacă există unealta potrivită pentru lucrare, o vom livra. Dacă nu, o vom crea.

Suntem mândri să punem sustenabilitatea în centrul a tot ceea ce facem, să provocăm percepțiile asupra industriei noastre, să schimbăm procesul de fabricație și să jucăm un rol mic în modelarea unui viitor mai luminos.

Made for Makers

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Prezentare generală familie de produse

Seria C



Această gamă Seco de scule din carbură solidă cuprinde freze cilindro-frontale de bază pentru operaţii de prelucrare de bază. Acesta include freze universale acoperite și neacoperite. Gama largă de produse pentru prelucrarea universală
Seria Seco C este disponibilă într-o gamă largă de geometrii de șanfrenare, cilindro-frontale și ballnose pentru degroșare și finisare la frezare laterală, frezareplană sau canelare.

SOLID²



Seco Solid² este o familie de freze din carbură solidă pentru aplicaţii de prelucrări generale, oferind flexibilitate, viteză și eficienţă a costului. Seco Solid² este disponibil în intervalul de diametre ∅1-∅32 mm și în *inci* ∅1/32 - 1 1/4.
Seco Solid² include și un grup dedicat degroșării avansate (JS564 și JS565).
Frezele JS564 și JS565 oferă o performanţă excelentă atunci când se aplică o strategie bine definită a traseului sculei cu un unghiu de contact constant combinat cu o viteză mare de așchiere și o adâncime de așchiere mare (degroșare avansată).
Pentru toate frezele din gama JS500 cu șanfren (c*45°) avem următoarele toleranţe: c = DC</=3=+0,01, 3<DC</=6=+0,02, 6<DC</=10=+0,03,
10<DC</=14=+0,04, 14<DC</=18=+0,05, 18<DC</=24=+0,06,
Consultaţi pag. 11 pentru informaţii generale despre produsele Seco Solid².

Stabilizer



Frezele cilindro-frontale Seco din seria stabilizer utilizează geometrii unice ale canelurii pentru rate extrem de agresive de îndepărtare
 a metalelor în prelucrarea de înaltă performanţă. Seco Stabilizer este disponibil într-o gamă largă de geometrii, cilindro-frontale și cu vârf rotund pentru operaţiuni de degroșare în timpul frezării laterale, canelare și degroșării avansate.

HSM/TORNADO



Aceste scule sunt caracterizate prin toleranţe dimensionale foarte strânse, lungimi mici ale muchiilor de așchiere, detalonare și miez solid pentru o stabilitate ridicată. Acest scule au fost concepute pentru a excela în procesele de frezare periferică și frezare de copiere.
Vezi pag. 11 pentru o vedere de ansamblu asupra produselor HSM/TORNADO (frezare cu viteze mari).

Prezentare generală familie de produse

HPM



Frezele din carbură optimizate sunt dedicate echipării originale a mașinilor unelte, sunt dedicate prelucrării seriilor mari cu un singur reper de prelucrat precum și acolo unde se dorește o optimizare totală pentru reducerea timpului de ciclu, reducând costul per piesă.
Vezi pag. 12 pentru o vedere de ansamblu asupra produselor HPM (prelucrări de înaltă performanţă).

HFM



Prelucrarea cu avansuri mari este prima alegere în aplicaţiile cu semifabricate subţiri și cu cavităţi adânci, profilare 3D la prelucrarea matriţelor și atunci când se prelucrează în condiţii instabile. Sculele pentru avans mare excelează la frezarea axială.
Vezi pag. 12 pentru o vedere de ansamblu asupra produselor HFM (prelucrări cu avansuri mari).

Prezentare generală familie de produse

MINI



Gama Seco de microfreze din carbură solidă cuprinde freze cilindro-frontale și freze cu vârf sferic cu diametre mici de așchiere. Sculele universale se adresează aplicaţiilor generale în semifabricate comune, în timp de sculele specializate sunt dedicate prelucrării grafitului și a oţelului călit. Toate sculele au o acoperire subţire pentru optimizarea performanţelor.
Vezi pag. 12 pentru o vedere de ansamblu asupra produselor MINI (micro prelucrări).

DIAMOND



Disponibile într-o mare varietate de geometrii și diametre, aceste scule au cel mai bun substrat posibil care permite o aderenţă perfectă a acoperirii diamant și care se pretează la o plajă largă de parametri de așchiere. Per total, aceste freze de carbură măresc semnificativ productivitatea și scad costul cu sculele deoarece necesită mai puţine schimbări a sculelor și faptului că pot produce piese foarte precise la viteze mari de avans.
Vezi pag. 12 pentru o vedere de ansamblu asupra produselor DIAMOND (acoperire diamant).

COMPOSITE



Cuprinde freze solide acoperite diamant, neacoperite și PCD cu diferit geometrii precum și freze cu muchii PCD brazate. Această familie de produse oferă scule optimizate pentru condiţii de așchiere dificile și pentru prelucrarea materialelor dificile.
Vezi pag. 12 pentru o vedere de ansamblu asupra produselor COMPOSITE (JC).

VHM



Include freze universale acoperite și neacoperite, o gamă dedicată pentru prelucrarea materialelor plastice și a aluminiului, freze conice și pentru șanfrenare. Aceste produse au o durată de viaţă ridicată și predictibilă.
Vezi pag. 13 pentru o vedere de ansamblu asupra produselor VHM (prelucrări generale).

Prezentare generală familie de produse

CERAMIC



Pentru a aşchia rapid cele mai rezistente superaliaje rezistente la căldură (HRSA) din lume, aveţi nevoie de o sculă la fel de puternică și de avansată precum materialele însele. Optimizaţi-vă procesele și prelucraţi piesele HRSA considerabil mai rapid cu aceste freze cilindro-frontale ceramice din carbură solidă.
Consultaţi pagina 13 pentru o prezentare generală grupată a produselor CERAMIC.

HSS-CO



Cobalt-oţel rapid reprezintă o calitate premium care oferă performanţe mai înalte în comparaţie cu oţelurile rapide tradiţionale. Datorită durităţii crescute, aceste freze cilindro-frontale rezistă mai mult în faţa materialelor abrazive, rezistente la căldură și exotice din ziua de astăzi.
Avantajele producţiei de înaltă calitate cu costuri reduse ale acestor freze cilindro-frontale sunt un rezultat direct al modelelor de caneluri proiectate, al acoperirilor rezistente la uzură și al caracteristicilor optimizate, precum canale de agent de răcire pentru aceste materiale dificile.
Consultaţi pagina 13 pentru o prezentare generală grupată a produselor HSS-CO.

X-Heads



Cu sistemul de frezare cu cap schimbabil Seco, schimbaţi rapid și ușor între diferite profiluri și tipuri de capete de frezare din carbură solidă pentru a optimiza toate operaţiunile de frezare, reducând în același timp costurile de fabricaţie și stocurile de scule. Capetele de frezare X-Heads se montează la o varietate de lungimi disponibile ale cozilor pentru o versatilitate și mai mare, cu o rază lungă de acţiune. Schimbarea frezei necesită doar o simplă răsucire a unei chei, iar brăzdarul ar putea rămâne în utilaj. Eliminaţi necesitatea de a reseta lungimile sculei datorită unei conexiuni sigure și fiabile care oferă precizii de schimb de până la 50 microni.
Consultaţi pagina 609 pentru o prezentare generală grupată a produselor X-Heads (capete interschimbabile).

Prezentare generală familie de produse

Familie de produse	Tehnologie	Produs	1xx	4xx	5xx	6xx	7xx	8xx	9xx
C-series	Prelucrare generală	C			■				
Solid²	Prelucrare generală	JS		■	■		■		
Stabilizer	Prelucrare de înaltă performanţă	ST			■				
HPM	Prelucrare de înaltă performanţă	JHP	■	■			■		■
HFM	Prelucrare cu avans mare	JHF	■						■
Mini	Microprelucrare	JM	■	■	■	■			■
HSM/Tornado	Prelucrare de mare viteză	JH	■	■			■		■
Ceramic	Prelucrare de înaltă performanţă	JCG					■		
Diamond	Prelucrare grafit	JD				■			
Composite	Prelucrare compozit	JC, JPD						■	
VHM	Prelucrare generală	J		■					■
HSS-E	Prelucrare generală	JCO					■		
X-Heads - Solid²	Prelucrare de înaltă performanţă	XS		■	■		■		
X-Heads - HFM	Prelucrare cu avans mare	XHF			■		■		
X-Heads - HSM/Tornado	Prelucrare de mare viteză	XH			■		■		
X-Heads - VHM	Prelucrare generală	XV			■		■		
SMG									
P1-8					■				■
P11-12					■				■
M1-3					■		■		
M4-5					■		■		
K1-7					■				■
S1-3					■		■		
S11-13					■		■		
H			■		■				
N1				■	■				
N2-3				■	■				
N11				■	■				
TS				■				■	
TP				■				■	
GR						■			
Pentru mai multe explicaţii despre SMG (grup de materiale), a se vedea pagina 802									

Rezumat

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210	C-Series	C5021	●	○	●	○	●	○	○	○	○	○	○	○			○				○
212		C5041	●	○	●	○	●	○	○	○	○	○	○	○			○				○
38		C5121	●	○	●	○	●	○	○	○	○	○	○	○			○				○
50		C5131	●	○	●	○	●	○	○	○	○	○	○	○			○				○
56		C5141	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5231	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5241	●	○	●	○	●	○	○	○	○	○	○	○			○				○
181		C5321	●	○	●	○	●	○	○	○	○	○	○	○			○				○
189		C5341	●	○	●	○	●	○	○	○	○	○	○	○			○				○
466	HPM	HP4931						●	●												
75	SOLID[2]	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
79		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
85		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
196		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
95		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
115		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
443		JS412						●	●					●			●				
446		JS413						●	●					●			●				
485		S4321						●	●					●			●				
449		S4521						●	●					●			●				
454		S4531						●	●					●			●				
463		S4651						●	●	●											
174		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
178		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
198		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
202		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
206		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
214		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
218		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
166		JS564	●	○	●	●	●	●	●	●	●	●	●								
170		JS565	●	○	●	●	●	●	●	●	●	●	●								
354		JS720			●	●					●	●									
374		JS730			●	●					●	●									
326		JS754		○	●	●					●	●									
343		JS755		○	●	●					●	●									
474	HSM/TORNADO	JH40						●		●				●							
313, 517		JH112					●						●								
507		JH120											●								
509		JH130											●								
303, 514		JH142	●	●			●						●								
520		JH150					●						●								
522		JH160	●	○									●								
481		JH410						●		●				●							
477		JH421						●		●				●			●				
483		JH440						●	●	●				●			●				
488		JH450						●	●	●				●			●				
490		JH460						●		●		●		●			●				
417		JH710									●	●									
427		JHB720			●	●		●	●	●	○	●		●			●				
429		JH721									●	●									
431		JH722									●	●									
431		JH724			●	●					●	●									
431		JH726			●	●					●	●									
421		JH730									●	●									
405		JH734	○	●	●						○	●									
407		JH736	○	●	●						○	●									
415		JH740									●	●									
409		JH744	○	●	●						○	●									
411		JH746	○	●	●						○	●									
413		JH770									●	●									
425		JH780									●	●									
419		JH790									●	●									
222		JH910	●	○	●	●	●				●	●					●				●
226, 511		JH930	●	○			●				●	●	●								
228, 311		JHB970	●	○	●	●					●	●									

● Opţiune preferată, ○ Opţiune alternativă

Rezumat

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306	Stabilizer	ST5341	●	●			●														
276		ST5541	●	●			●														
140		ST5551	●	●	●	●	●	●	●	●	●	●	●	●		●					○
501	HPM	JHP170											●								
470	Solid²	S4931						●	●												
378	HPM	JHP751									●	●									
381		JHP760			●	●															
385		JHP770										●									
392		JHP780									●										
381		JHP794			●	●															
299		JHP951	●	○			●														
293		JHP993	●	○			●														
423		JHP994									●	●									
504	HFM	JHF181	○	○			●				●	●	●								
504		SHF712																			
230		JHF980	●	○	●	●	●				●	●	○								
531	MINI	JMB112											●								
524		JME142											●								
529		JME144											●								
494		JM403/404/406						●	●												
496		JM413/416						●	●	●				●		●					
496		SMB413/414/416						●	●					●		●					
264		JMB542	●	●	●	●		○	○	○		●	○								○
267		JMB562	●	●	●	●		○	○	○		●	○								○
271		JMB563	●	●	●	●		○	○	○		●	○								○
254		JME542	●	●	●	●		○	○	○		●	○								○
257		JME562	●	●	●	●		○	○	○		●	○								○
261		JME564	●	●	●	●		○	○	○		●	○								○
261		SMB713/714/416																			
261		JME714/716									●	●									
606	MINI DIAMOND	JMB642/JMB662																			●
606		JMB662																			●
604		JME642																			●
604		SMB614/616																			●
594	DIAMOND	JD620																			●
596		JD630																			●
598		JD640																			●
600		JD660																			●
539	COMPOSITE	D8961													●		●				
542		JC845													●		●				
544		JC850													●		●				
546		JC860													●		●			●	
548		JC870													●		●			●	
554		JC871													●		●			●	
560		JC875													●		●				
564		JC876													●		●				
568		JC877													●		●				
572		JC880													●		●				
574		JC885													●		●				
576		JC898																●	●		
578		JC899																●	●		
581	PCD	JPD850													●		●				
583		JPD880													●		●				
585		JPD890													●		●				

Rezumat

Pag.	Familia	Nume	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	Honeycomb	GR
589	VHM	J28												●							
237		J36	○	●	○	○	○	○	●	●	○	○		○			○				
240		HK/HKM	●		●	●	●	●	○		●	●	●	●			●				
251		V31	●	○	●	○	●	●	●	●	●	●	●	●			●				●
234		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
587		J93F												●			●				
399	Ceramic	JCG790									●										
669	X-HEADS SOLID²	XS5021	●	●	●	●	●	○	○	○	○	○	●	●			●				○
671		XS5061	●	●	●	●	●	○	○	○	○	○	●	●			●				○
620		XSE550	●	●	●	●	●	●	●	●	●	●	●	●			●				○
637		XSB540	●	○	●	●	●	●	●	●	○	●	○	●			●				○
639		XSE720	○	●	●	●					●	●									
651		XSE450						●	●	●				●			●				
645		XSB720	○	●	●	●					●	●									
655	X-HEADS HSM/TORNADO	XHT740	○	●	●						○	●									
658	X-HEADS HFM	XHF580	●	●	●	●	●				○	○	○								
663		XHF780	○	○	●	●					●	●	○								
680	X-HEADS VHM	XVE540	●	●	●	●	●	●	●	●	○	○	○	●			●				○
685		XVE510	●	●	●	●	●	○	○	○	○	○		●			●				○
688		XVB510	●	●	●	●	●	○	○	○	○	○		●			●				○
692		XVC506/509/512	●	●	●	●	●	○	○	○	○	○		●			●				○
696		XVK310	●	●	●	●	●	●	●	●	○	○	○	●			●				○

● Opţiune preferată, ○ Opţiune alternativă

Codificări

Freze cilindro-frontale solide (noutăţi)

R	S	4321	-	100	D	2	R050	.0	Z3	C	,	AXT
1	2	3		5	6	7	8	9	10	11		12

Freze cilindro-frontale solide

R	JS	720	100	D	2	R050	.0	Z6	C	,	HXT
1	2	3	5	6	7	8	9	10	11		12

X-Heads – Capete

R	XSE	550	E10	100	D	2	R050	Z4	A	,	SIRA
1	2	3	4	5	6	7	8	10	11		12

1. Tipul de produs

BLANK = Produse standard (catalog)
R = Produs recondiţionat (complet)
RK = Produs recondiţionat (frontal)

2. Gama de produse

J = VHM
JC = Composites
JD = Diamond
JH = HSM/Tornado
JHF = HFM
JHP = HPM
JM = Mini
JS = SOLID²
JPD = PCD
JCO = HSS-Co
JCG = Ceramic
C = C-serie
ST = Stabilizer
XS* = X-Head SOLID²
XH* = X-Head HSM/Tornado
XV* = X-Head VHM
XHF = X-Head HFM

3. Geometria

O combinaţie de trei caractere precizează geometria frezei. Exemplu: 111, 950, 553, 514, etc.

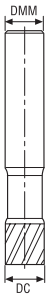
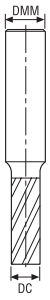
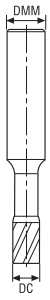
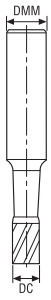
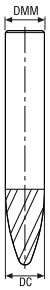
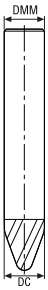
4. Dimensiunea conexiunii

Această figură indică dimensiunea conexiunii filetate între cap și adaptor
E10 = 10 mm
E12 = 12 mm
E16 = 16 mm
E20 = 20 mm
E25 = 25 mm

5. Diametru de aşchiere

Metric = cod din 3 cifre (în cazul a 4 cifre - xx,xx mm)
Imperial = punct urmat de 3 cifre
De ex.: (050 = metric, 5 mm) / (.500 = imperial, ½ inch)

6. Forma sculei

(DC = DMM)		(DC < DMM)			(DC > DMM)
					
D	E	F	G	J	P
Forma formării					
					
N		X		T	

7. Lungimea formei

O singură cifră oferă date despre lungimea frezei comparativ cu alte produse cu aceeași geometrie.

9. Tip de coadă

.0 = Cilindrică
.3 = Weldon
.5 = Whistle Notch
.9 = Safe-Lock

10. Numărul de dinţi

Acest element indică numărul de dinţi ai frezei.
Exemplu: PCEDC2= 2 dinţi, PCEDC6= 6 dinţi

11. Canale lichid de răcire

BLANK = Fără canale de răcire
A = Canale de răcire interioare
C = Fragmentator de așchii

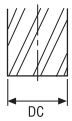
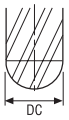
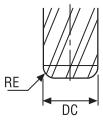
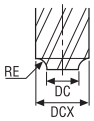
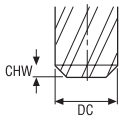
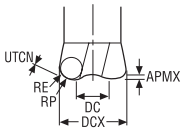
12. Calităţi

4 caractere din cod specificând acoperirea frezei.

MEGA =	MEGA	DURA =	DURA
MT =	MEGA-T	NXT =	NXT
M64 =	MEGA-64	HXT =	HXT
M64 T=	MEGA-64-T	STAX =	STAX
SIRA =	SIRON-A	TAN =	TAN
HEMI =	HEMI	M9 =	M9
DIA =	DIAMOND	AXT =	AXT

Descriere

8. Forma vârfului

Ascuţit	Cap sferic	Rază de colţ	Rază concavă	Șanfren	Avans mare
					
S	**B**	**R...**	**K...**	**C**	**H**

Mărimea razei pentru produsele cu vârf cu rază convexă sau concavă

000 = Pentru produsele metrice forma vârfului este arătată prin trei numere.
Împărţind acest număr la 100 obţineţi mărimea razei la colţ în milimetri.

.000 = Pentru produsele imperiale forma vârfului este arătată prin trei numere.
Figura indică, de fapt, mărimea razei la vârf în *inchi* (de ex. R.100 ar indica o rază de 0,1 *inchi*).

Codificări

X-Heads – Cozi

X	E10	100	E	2	-	055	-	00	.0	S
1	2	3	4	5		6		7	8	9

1. Gama de produse

X = X-Head Cozi cilindrice

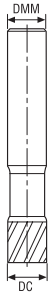
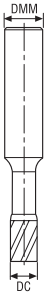
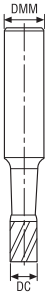
2. Dimensiunea conexiunii

Această figură indică dimensiunea conexiunii filetate între cap și adaptor
E10 = 10 mm
E12 = 12 mm
E16 = 16 mm
E20 = 20 mm
E25 = 25 mm

3. Diametru coadă

Metric = cod din 3 cifre
Imperial = punct urmat de 3 cifre
De ex.: (050 = metric, 5 mm) / (.500 = imperial, ½ inch)

4. Forma sculei

(DC = DMM)	(DC < DMM)	
		
E	**G**	**J**

5. Lungimea formei

O singură cifră oferă date despre lungimea frezei comparativ cu alte produse cu aceeași geometrie.

6. Lungime totală

Metric = cod din 3 cifre
Imperial = cod din 3 cifre cu un punct după primul
exemplu de cifră: (055 = metric, 55 mm) / (.2,50 = imperial, ½ inch)

7. Unghi conic

Indică unghiul pe jumătate al corpului.
Exemplu: (00 = 0°;0°; 05 = 5°; 10 = 10°)

8. Tip de coadă

.0 = Cilindrică
.3 = Weldon
.5 = Whistle Notch
.9 = Safe-Lock

9. Tipurilor de materiale.

Indică diferite tipuri de material disponibile pentru cozi.
S = oţel
DM = Densimat
E = carbură solidă

Cum vă pot avantaja soluţiile noastre

Soluţia individuală – scule personalizate și modificate



Dacă necesităţile sunt cu adevărat speciale, avem soluţia potrivită, cu sculele noastre individuale și personalizate – soluţii care au fost adaptate anume pentru necesităţile dvs. individuale. Acest lucru vă ca permite să duceţi productivitatea de prelucrare la un nivel cu totul nou.
Pe lângă soluţiile standard, oferta noastră include:

Scule Speciale
Sunt scule cu geometrii modificate sau scule formate pentru cerinţele specifice clientului, deoarece putem coopera deplin cu clientul și putem proiecta o sculă anume care răspunde nevoilor. Iată niște exemple:

- Scule modificate în limitele unei geometrii standard
- MEP (profilare mecanizată a muchiei)
- Pin,
- Coadă de rândunică
- Cap rotund conic
- Sculă aşchietoare condil
- Scule formate
- Butoi

Scule modificate
Seco oferă o soluţie cu livrare rapidă pentru scule standard care necesită modificare pentru a întruni cerinţe speciale de dimensiune, iar acestea pot fi:

- (complet) Rază/Faţetă/Șanfren/Concav
- reducere a diametrului exterior (reducere gât), inclusiv lungime crescută
- Acoperire (aplicaţie pentru scule neacoperite)
- Diametru de aşchiere redus
- Fragmentator de aşchii
- Adăugare Weldon / Safelock
- Canale de agent extern de răcire

Recondiţionarea scade costurile și inventarul de scule

Sculele moderne din carbură de la Seco oferă o performanţă remarcabilă când sunt folosite cele mai bune combinaţii de substraturi de carbură cu acoperire performantă, geometrie optimizată și o preparare bună a muchiei.

Indiferent cât de bună este o sculă, ca și parte a funcţiei lor, va apărea până la urmă uzura muchiei de aşchiere. Controlând această uzură și schimbând la timp scula se poate recondiţiona acea sculă, reducând astfel costul investiţiei în scule. Și utilizăm aceeași tehnologie avansată pentru a recondiţiona sculele dumneavoastră din carbură solidă pe care o folosim pentru a fabrica produse noi.

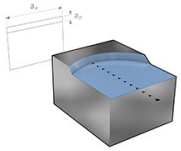
Beneficiile dvs. atunci când recondiţionaţi

- Recondiţionate la cele mai înalte standarde Seco cu geometrie, prepararea muchiei și proces de acoperire specifice Seco.
- Reduceri de costuri cu sculele prin recondiţionarea repetată a frezelor din carbură solidă.
- „Cutia de recondiţionare” uşor de utilizat și gratuită a noastră include o notă de livrare pregătită în prealabil.
- Atunci când produsele sunt gata și nota de livrare este completată, contactaţi agentul de pe zona dvs., pentru ca acesta să le poată prelua.
- Un proces rapid datorită acestor lucruri
- Fără costuri de transport pentru dvs.
- Transport și depozitare a sculelor recondiţionate în același mod ca și cele noi.
- O nouă etichetă este inclusă.
- Să lucrăm către un ecosistem mai verde și mai curat. Procesele Seco sunt certificate global cu ISO14001.
- Calitate garantată, toate procesele sunt certificate ISO9001.

Operaţiuni de bază:

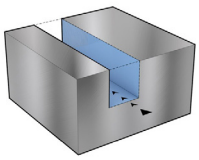
Frezare plană:

Operaţie în care freza are un angajament mai mic de 180° arc de contact.
Angajarea sculei:
a_p mic şi a_e mare.



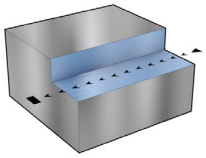
Canelare:

Operaţiune în care tot diametrul este angajat, a_e este egal cu DC şi a_p până la 2 ori DC în funcţie de strategia de prelucrare utilizată.



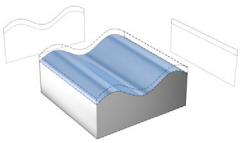
Frezare laterală:

Operaţie în care partea laterală a sculei este angajată, a_p este mare şi a_e este mică.



Frezare de copiere:

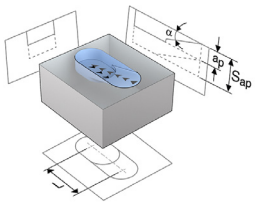
Operaţiune în care este angajată raza sculei. a_p şi a_e sunt amândouă mici.



Metode avansate de prelucrare:

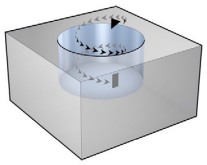
Frezare în rampă:

Deschiderea unui buzunar prin realizarea unei axe Z în unghi.



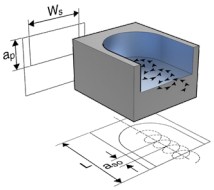
Interpolare elicoidală în rampă:

Deschiderea unui buzunar prin mișcarea circulară a sculei cu executarea unei rampe pe axa Z.



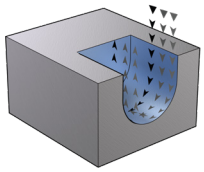
Trohoidal:

Deschiderea unui canal prin utilizarea frezării laterale, efectuând o mișcare circulară parţială pe axele X sau Y. (schimbând canelarea cu frezare laterală).



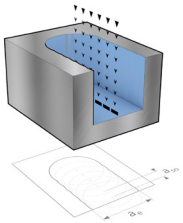
Copiere:

Prelucrarea unei forme 3D prin frezare în sensul avansului și contrar avansului urmărind profilul de prelucrat.



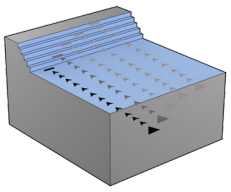
Frezare axială:

Deschiderea unui canal adânc prin utilizarea axei de găurire (Z).



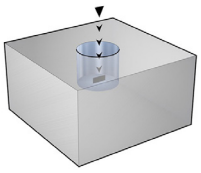
Nivelare Z:

Prelucrarea unei suprafeţe prin găurire sau frezare în rampă pe axa Z apoi deschiderea buzunarului cu mișcări pe axele X și Y.



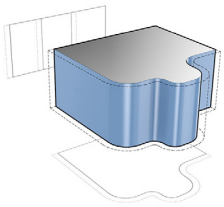
Găurire:

Efectuarea unei găuri cu mișcare în axa Z.



Degroșare avansată / Optirough

Un traseu bine definit al sculei cu un arc de contact constant pentru degroșarea formelor simple sau complexe.
Adâncimile axiale mari (a_p) și adâncimile radiale mici de așchiere (a_e) combinate cu un avans mare pe dinte (f_z) și viteze mari de așchiere (V_c) conduc la o productivitate ridicată.



Definiţii, strategii de prelucrare:

Prelucrare generală:
O strategie de prelucrare de uz general. Raţia a_e - a_p poate varia în funcţie de aplicaţie.
Caracteristicile sculei: Sculele au lungimi de aşchiere relativ mari şi diametre relativ mici. Nu sunt cerinţe mari referitor la toleranţă.
Cerinţele maşinii: Nu sunt necesare anumite cerinţe speciale pentru maşină.
Cu tehnologia de bază CNC nu sunt posibile metodele de prelucrare avansate dificile.
Se vor obţine rezultate medii ale ratei de îndepărtare a materialului Q (cm^3/min).
Aria de aplicabilitate include de obicei serii mici şi o plajă mare de materiale.

Prelucrare de înaltă performanţă:
Este o strategie de prelucrare unde pot fi atinse rate foarte mari de îndepărtare a materialului. Caracteristic acestei strategii este a_e este 1 dată DC şi a_p este 1 la 1½ ori DC în funcţie de materialul semifabricatului.
Cu HPM (Prelucrare de înaltă performanţă) se pot obţine rate foarte mari de îndepărtare a materialului prin utilizarea unor încărcări pe muchie mult mai mari decât în prelucrările generale.
Caracteristicile sculei: Fragmentatoarele de aşchii create special în canelura dinţilor, protecţia muchiei cu o faţă la 45° sau rază mică la colţ, cu spaţiu special şlefuit pentru formarea aşchiilor, cu sau fără coadă Weldon.
Cerinţele maşinii: Stabilitate crescută, necesar de putere mare, control CNC, sistem de prindere rigid.
Aria de aplicabilitate este: Operaţii pentru producţia de masă unde este foarte important raportul timp de producţie/timp de aşteptare este foarte important sau la producţia de repere unicat unde este nevoie de o rată mare de îndepărtare a materialului Q (cm^3/min.).

Prelucrare cu avansuri mari:
Este o strategie de prelucrare unde se pot atinge rate mari de avans cu angajări radiale mari (a_e) în combinaţie cu a_p mic
Cu HFM (Prelucrare cu avansuri mari) se obţine o rată mare de îndepărtare a materialului şi/sau o bună finisare a suprafeţei utilizând un avans mult mai mare decât la prelucrările generale.
Caracteristicile sculei: Dinţi frontali special dezvoltaţi, acoperiţi şi cu o lungime de aşchiere foarte mică.

Cerinţele maşinii: Stabilitate bună, CNC, posibilitate de avans mare (v_f).
Marele avantaj al tehnologiei: este foarte uşor de utilizat, prietenos, sigur şi rapid de programat în CAM. Prin utilizarea strategiei de nivelare Z este relativ uşor de programat forme complexe fără a avea experienţă avansată în programare.
Aria de aplicabilitate este: De la oţeluri uşoare la cele călite, titan şi oţeluri inoxidabile şi este foarte bună operaţie premergătoare utilizării HSM.
Se poate aplica şi la prelucrarea locaşurilor adânci.

Microprelucrare:
Este o strategie de prelucrare unde se utilizează scule cu diametre foarte mici.
Caracteristicile sculei: Diametre cuprinse intre Ø 0,1 şi 2,0 mm, lungimi mici de aşchiere şi o gamă mare de reducţii a diam. Exterioare, precizie mare, acoperire.

Cerinţele maşinii: Acurateţe mare a axului, RPM mari, CNC, stabilitate termică a arborelui.
Aria de aplicabilitate este: Producerea de cavităţi cum ar fi caneluri, găuri, buzunare şi gravuri în diferite tipuri de materiale.

Prelucrare de mare viteză:
Este o strategie de prelucrare care combină adâncimi radiale de aşchiere mici cu viteze de aşchiere şi de avans mari.
Depinzând de metoda folosită se poate obţine o rată de îndepărtare a materialului mare şi un R_a mic. Caracteristic acestei strategii sunt forţele de aşchiere mici, o cantitate mai mică de căldură acumulată în sculă şi în semifabricat, mai puţine bavuri şi o mare acurateţe dimensională a semifabricatului.

Cu HSM (Prelucrare cu viteză mare) se obţine o rată mare de îndepărtare a materialului şi/sau o bună finisare a suprafeţei utilizând viteze de aşchiere mult mai mare decât la prelucrările generale.
Caracteristicile sculei: Stabile, (diametre groase şi lungimi mici de aşchiere) spaţiu clar şi bine determinat pentru evacuarea aşchiilor, acoperire.

Cerinţele maşinii: Control CNC rapid, RPM mari, transmisie rapidă la axă.
Aria de aplicabilitate este: Industria de producere a matriţelor la operaţiile de semi-finisare şi finisare în oţeluri călite (48-62 HRC)într-un timp scurt de prelucrare.
Această tehnică poate fi de asemenea aplicată în cele mai multe materiale dacă se folosesc sculele potrivite şi metode avansate de prelucrare.

Degroşare avansată / Optirough:
Un traseu bine definit al sculei cu un arc de contact constant pentru degroşarea formelor simple sau complexe. Adâncimile axiale mari (ap) şi adâncimile radiale mici (ae) combinate cu un avans mare pe dinte (fz) şi vitezele mari de aşchiere (Vc) duc la o productivitate ridicată.

Frezarea de degroşare bazată pe CAM, sau frezarea dinamică, este o strategie care se concentrează pe arcul de contact al frezei şi pe grosimea medie a aşchiei.

Atunci când se reduce arcul de contact, cantitatea de căldură generată în timpul degroşării se reduce şi ea. Odată cu reducerea adâncimii radiale de aşchiere se reduce şi arcul de contact al frezei. Un arc de contact mai mic înseamnă mai puţină frecare şi mai puţină căldură produsă între muchia de aşchiere şi semifabricatul prelucrat. Temperatura mică de prelucrare permite mărirea vitezelor de aşchiere şi reducerea timpului de prelucrare.

Explicarea degroșări avansate

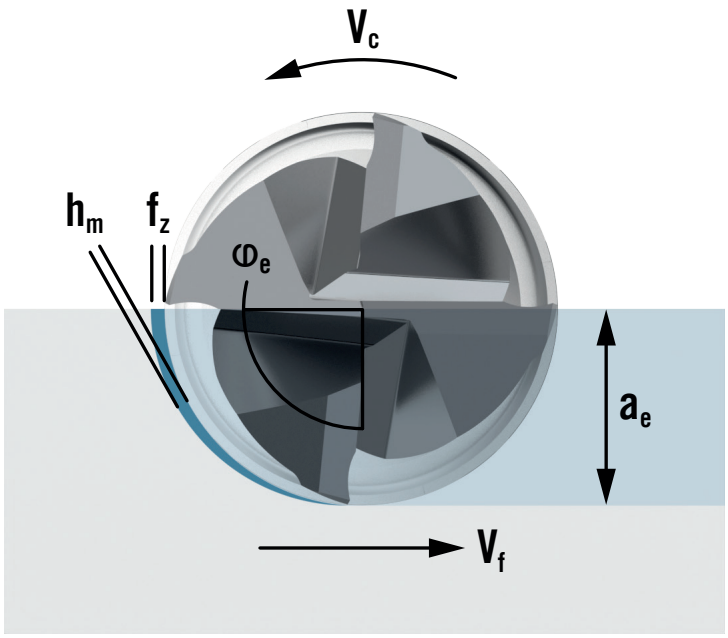
Degroșare avansată, ce înseamnă?

Pachetele CAM din ziua de astăzi oferă strategii de traseu al sculei special pentru forme de raze interioare/exterioare acolo unde modificarea arcului de contact este uzuală atunci când se folosește un traseu al sculei convenţional. Aceste pachete de programe aplică automat diferite avansuri pentru a menţine arcul de contact constant și pentru a avea aceeași grosime de aşchie.
Degroșarea bazată pe CAM, sau degroșarea avansată, se concentrează pe arcul de contact al frezei și pe încărcarea medie cu aşchii. Atunci când se reduce arcul de contact, cantitatea de căldură generată în timpul degroșării se reduce și ea. Odată cu reducerea adâncimii radiale de aşchiere se reduce și arcul de contact al frezei. Un arc de contact mai mic înseamnă mai puţină frecare și mai puţină căldură produsă între muchia de aşchiere și semifabricatul prelucrat. Temperatura mică de prelucrare permite mărirea vitezelor de aşchiere și reducerea timpului de prelucrare. De asemenea, forţa de aşchiere rezultată este mai mică, permiţând programarea de APMXS sau adâncime de aşchiere ridicată.

În degroșarea avansată, pentru menţinerea arcului de contact, pachetele CAM trebuie să adopte tehnici de prelucrare trohoidală la pătrunderea într-o rază.

La utilizarea unui traseul al sculei de degroșare optimizat și menţinerea unui arc de contact constant, raza sculei aşchietoare poate fi aceeași cu raza interioară care este aşchiată, fără riscul supraîncărcării sculei aşchietoare. Acest lucru le permite sculelor noastre de degroșare avansată (JS554-3C, JS564, JS656, JS754, JS755 și JS720) să îndepărteze mai mult material la trecerea de degroșare, reducând astfel cantitatea de material care trebuie aşchiat la trecerea de finisare; toate acestea înseamnă cicluri de prelucrare cu durate mai mici și o sculă cu durată de viaţă mai mare. De asemenea, cât timp materialul rămas este constant, scala de finisare poate genera o suprafaţă finală de o calitate mai bună și, în același timp, va avea o durată de viaţă mai mare.

Impactul arcului de contact asupra vitezei de aşchiere și avansului pe dinte



Cum vă pot avantaja produsele noastre

Atingeţi viteze revoluţionare în superaliaje cu frezele cilindro-frontale Seco Ceramic



Ceramica SiAlON, geometriile de înaltă rezistenţă și dinţii frontali ranforsaţi sunt câteva dintre caracteristicile principale ale acestor scule extrem de optimizate și permit utilizarea deplină a sculelor de prelucrare de înaltă viteză și înaltă performanţă. Sculele pot funcţiona la viteze de aşchiere de până la 1200 m/min și pot oferi o creștere semnificativă a productivităţii, în comparaţie cu soluţiile din carbură solidă standard.

Deoarece este nevoie de temperaturi ridicate, este necesară și o valoare mare de rotaţii pe minut pentru a atinge vc ridicată. De asemenea, temperaturile ridicate sunt necesare și pentru a atinge un nivel la care HRSA se înmoaie (peste 850 °C). Cu aceste scule, pot fi utilizate mai multe strategii, atât timp cât sunt maximizate aşchierea constantă și contactul constant cu piesa de prelucrat.

Scula este proiectată pentru frezare laterală, canelare, frezare cu avans mare și degroşare avansată! Toate acestea sunt posibile. Pentru a menţine temperatura de aşchiere ridicată din zona de aşchiere, agentul frigorific este aerul comprimat. Deoarece scula funcţionează la viteze ridicate, și bătaia radială este foarte importantă.

Puteţi găsi scule Seco ceramice la pag. 399 .

Simplificaţi găurirea materialelor hibride din industria aeronautică, prin geometrie 2 în 1

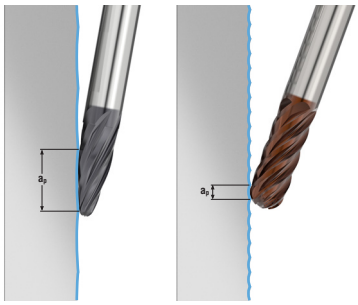


JC899 dispune de o soluţie brevetată de geometrie dublă 2 în 1, proiectată pentru prelucrarea combinaţiilor de materiale suprapuse hibride, cum ar fi CFRP-Ti și CFRP-Alu. Datorită modelului cu filet stânga și aşchiere dreapta, această sculă previne deteriorarea suprafeţei piesei de prelucrat prin delaminare, desprinderea fibrelor și urme de aşchii (acest lucru deoarece aşchiile vor fi împinse în jos prin orificiu). Prin urmare, freza de finisare STAX cu filet stânga și aşchiere dreapta JC899 asigură o finisare perfectă a suprafeţelor și previne contaminarea cu aşchii între cele 2 straturi suprapuse.

Acest lucru înseamnă că post-prelucrarea, despărţirea, curăţarea și debavurarea și resuprapunerea nu mai sunt necesare, ceea ce poate creşte eficienţa proceselor cu până la 200-300% și poate asigura o durată de viaţă a sculei cu de trei până la şase ori mai mare decât în cazul alezoarelor convenţionale.
În acelaşi timp, procesul de găurire este înlocuit prin aplicarea frezei de degroşare cu avans mare JC898. Această sculă prelucrează în rampă prin interpolare elicoidală și permite JC899 să funcţioneze în condiţii de material continuu, maximizând rezultatul de calitate și minimizând corelarea în dimensiunea orificiului și toleranţă.

Puteţi găsi Seco JC898/JC899 la paginile 576 - 578.

Utilizaţi treceri mai mari, pentru o productivitate de finisare mai rapidă



Pentru operaţiile de finisare cele mai rapide și mai fiabile, noile scule cu formă de butoi utilizează o geometrie inovatoare de „con” sau „picătură”, pentru a permite creşteri mari ale spaţiului dintre treceri. Acest lucru este posibil prin utilizarea unor sisteme CAD/CAM avansate sau noi plugin-uri create pentru utilizările acestor scule. Folosind o deplasare a utilajului pe cinci axe, profilul de aşchiere al sculei poate să rămână angajat permanent pe suprafaţa piesei la unghiul corect.
Pe lângă formele standard stil butoi, Seco mai poate oferi toate stilurile de geometrie butoi sub formă de produse personalizate, cum ar fi formele de lentilă, garantând că aveţi mereu acces la sculele ideale pentru nevoile dumneavoastră de producţie de piese.

Eliminaţi riscul din operaţiile de micro-frezare

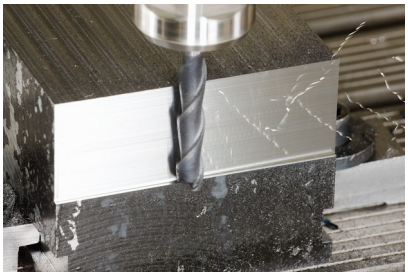


Obţineţi precizie și o calitate ridicată în finisarea suprafeţelor încă de la început când prelucraţi suprafeţe mici sau de dimensiuni micro, cu gama noastră de freze cilindro-frontale Seco din carbură solidă. Noile game Mini de la SECO asigură o durată de viaţă mai mare a sculei, stabilitate și linişte sufletească pentru operaţii de prelucrare în care, de obicei, este imposibil de văzut piesa de prelucrat și scula aşchietoare în timpul lucrului.

Geometriile produse cu precizie, bătaia radială aproape zero, acoperirile avansate și toleranţele de rază de formare liniară reală le dau sculelor din aceste game Mini o durată de viaţă și o fiabilitate incredibile. Cheia este utilizarea acestor scule în condiţii adecvate, în care avantajele pot fi maximizate. Minimizarea bătăii radiale a sculei plus port-sculei este esenţială.
De asemenea, programul CAM poate fi optimizat cu optimizorul de avans Seco, care calculează valoarea ideală a rotaţiilor pe minut și viteza de avans (vf) ideală pentru fiecare utilizare. Prin urmare, scula și configuraţia contribuie la eliminarea oricărei probleme neprevăzute în cursul operaţiilor de micro-frezare de degroșare, pre-finisare și finisare finală.

Puteţi găsi o prezentare generală a sculelor Seco Mini la pagina 12 .

Freză de finisare cu caneluri lungi JS522



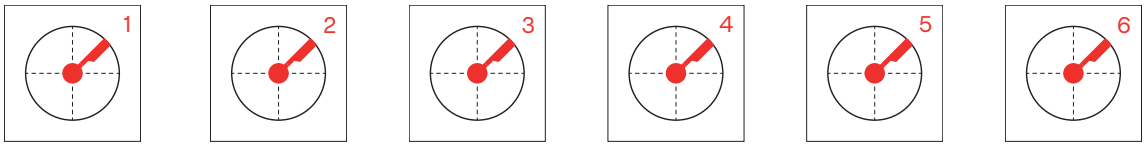
Scula de finisare cu caneluri lungi JS522 este capabilă să întrunească criteriile exigente ale industriei aeronautice în privinţa perpendicularităţii, finisajului fin al suprafeţei, ratelor ridicate de îndepărtare a metalului și frezare mai eficientă.

Cu o lungime de aşchiere de 5 x Dc, un diametru interior crescut și o conicitate uşor negativă, pentru a compensa deviaţia, JS522 este proiectat special pentru prelucrarea pragurilor înalte în operaţii de finisare cu o singură trecere. Această singură trecere economiseşte timp (până la 80%) dar, cel mai important, asigură și o calitate imediată. Această sculă este utilizată deseori în zone de producţie de masă.

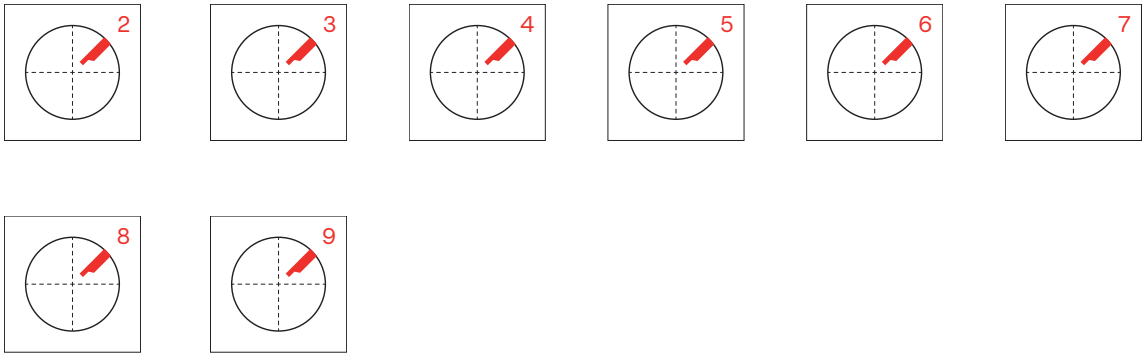
Odată ce a fost instalată și optimizată, s-a dovedit a fi principalul factor pentru economisirea costurilor în mai multe utilizări!

Puteţi găsi Seco JS522 la pag. 178.

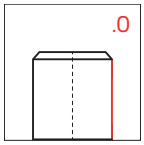
Frezare centrală PCEDC



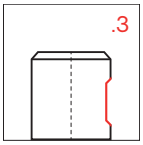
Fără frezare centrală PCEDC



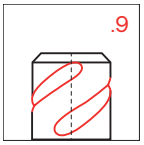
Coadă cilindrică



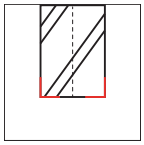
coadă Weldon



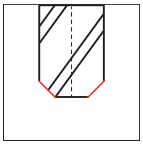
coadă Safelock



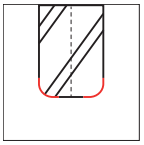
Ascuţit



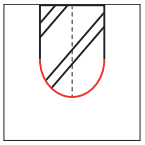
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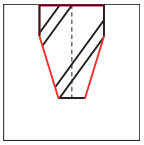
Rază la vârf



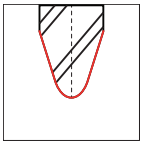
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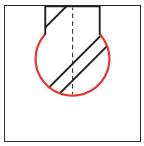
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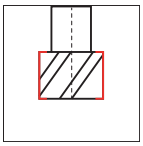
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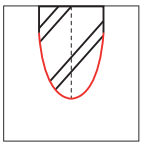
Freza 250°



Formă de T



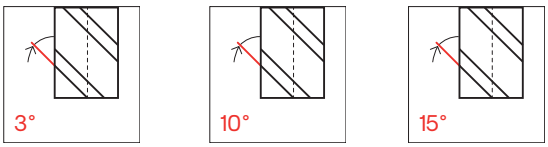
Butoi



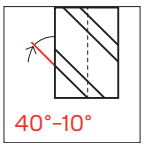
Unghiul filetului



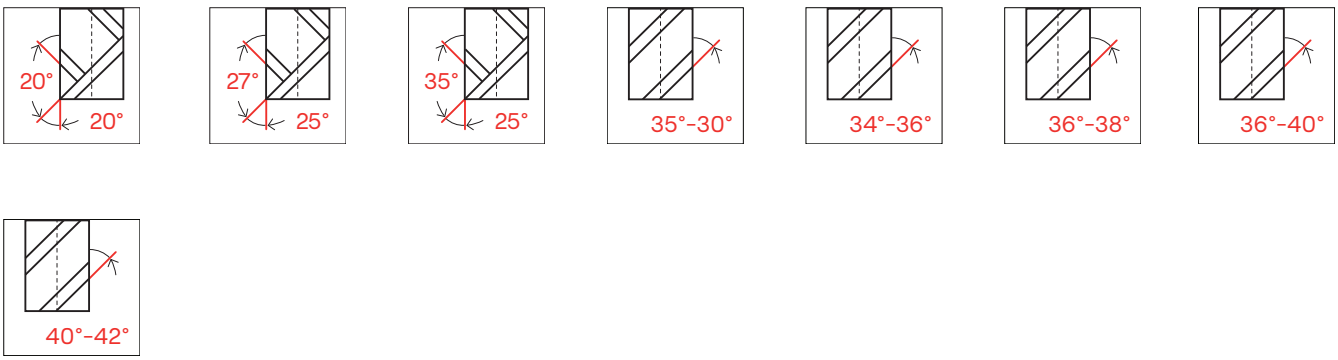
Unghiul filetului Stânga



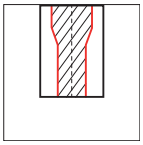
Spirală dublă pe stânga



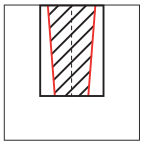
Spirală dublă



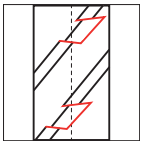
Miez dublu



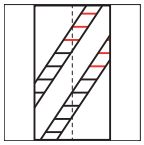
Miez conic



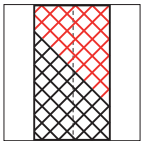
Fragmentator de



Profil de degroșare



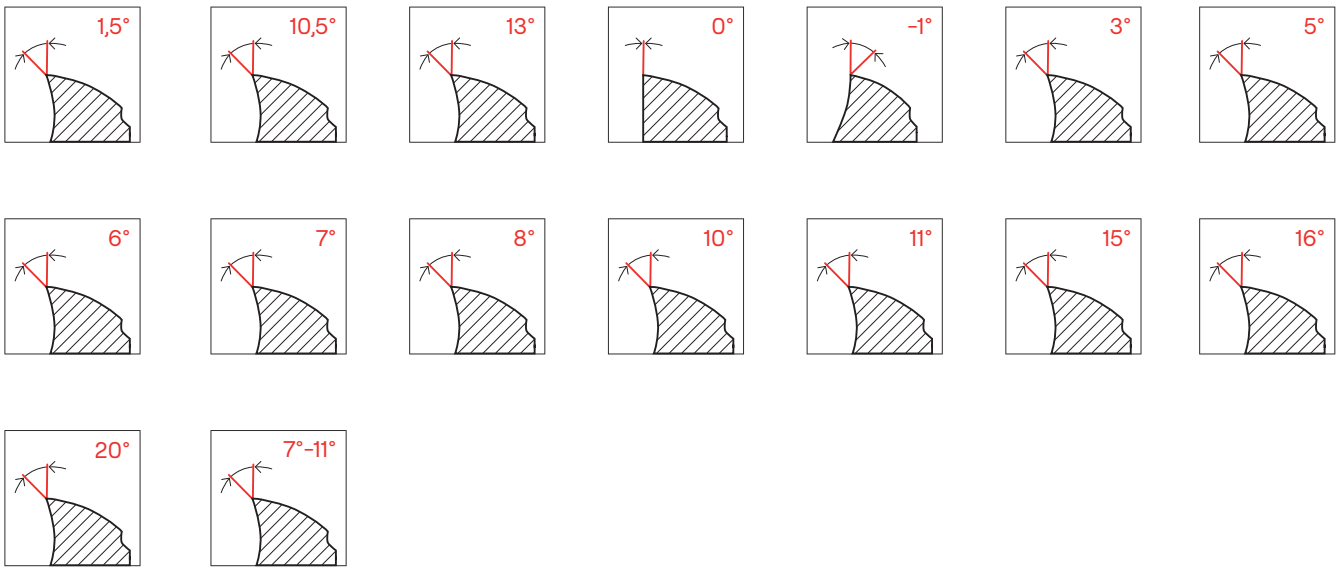
Profil router



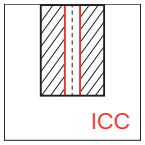
Degajare frezare Așezare unghiulară



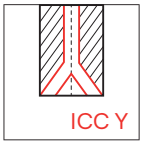
Degajare frezare Așezare radială



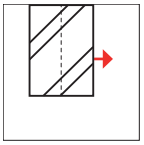
ICC drept



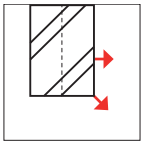
ICC și Y



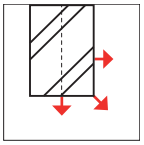
Radial



Radial / în rampă



Radial / în rampă /



Simboluri principale

DIAMOND

DIAMOND

DURA

DURA

HEMI

HEMI

HSCO

HSCO

HXT

HXT

MEGA

MEGA

MEGA-T

MEGA-T

MEGA-64

MEGA-64

MEGA-64-T

MEGA-64-T

NXT

NXT

STAX

STAX

SIRA

SIRON-A

TAN

TAN

AXT

AXT

Ceramică

CERAMIC

PCD

PCD

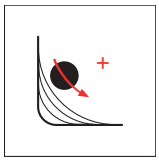
M9

M9

Reascuţire posibilă



Degroşare avansată



Atribute frezare solidă și X-Heads

Atribute	Explicaţie
AP1	Adâncimea de așchiere
APMXS	Adâncimea maximă de așchiere în direcţia laterală avansului
BHTA	Unghi de înclinaţie jumătatea corpului
ca	Unghiul de coliziune
CHW	Lăţimea șanfrenului la colţ
CSP	proprietate lichid de răcire
CZCMS	codul de dimensiune a conexiunii spre maşină
CZCWS	codul de dimensiune a conexiunii spre semifabricat
DC	Diametru
DCSFMS	Diametrul suprafeţei de contact - partea cu utilajul
DCSFWS	Diametrul suprafeţei de contact - partea cu semifabricatul
DCX	Diametrul de așchiere maxim
DMM	Diametru coadă
DN	diametru gât
FCEDC	Numărul de feţe de așchiere
CSP	proprietate lichid de răcire
L	Lungimea muchiei așchietoare
L2	Lungimea muchiei așchietoare 2
LF	Lungimea funcţională
LN	Lungimea gâtului
LN2	Lungimea gâtului 2
LSCN	Lungimea de prindere minimă
NA	Unghiul gâtului
OAL	Lungime totală
PCEDC	Numărul de muchii de așchiere periferice
PRFA/2	Unghiul profilului împărţit la doi
PRFRAD1	Raza profilului 1
PRFRAD2	Raza profilului 2
PRFRAD3	Raza profilului 3
PSIR	Unghiul de așgajare a sculei
RE	Rază la vârf
RE2	Raza la colţ 2
RP	Rază programare
SA	unghiul sferei
SIG	unghi la vârf
SW	mărimea cheii
TQ	cuplu
TQN	cuplu minim
TQX	cuplu maxim
UTCN	Grosime neașchiată

Atribute Minimaster

Atribute	Explicaţie
APMXE	Adâncimea maximă de aşchiere în direcţia avansului
APMXS	Adâncimea maximă de aşchiere în direcţia laterală avansului
AZ	adâncime maximă de scufundare
BEC	unghi şanfren partea dorsală
BHTA	Unghi de înclinaţie jumătatea corpului
CCER	Raza muchiei de aşchiere curbe
Cmax	Diametrul maxim al găurii executate prin interpolare elicoidală
Cmin	Diametrul minim al găurii executate prin interpolare elicoidală
DC	Diametru de aşchiere
DCSFMS	Diametrul suprafeţei de contact - partea cu utilajul
DCSFWS	Diametrul suprafeţei de contact spre semifabricat
DCX	Diametrul de aşchiere maxim
DMM	Diametru coadă
DN	diametru gât
FCEDC	Numărul de feţe de aşchiere
FHA	unghiul canelurii elicoidale
KAPRS	Unghiul muchiei de aşchiere în direcţia laterală avansului
LE	Lungimea efectivă a muchiei aşchietoare
LF	Lungimea funcţională
LPR	lungimea de protuberanţă
OAL	Lungime totală
RA	unghiul de degajare
RE	Rază la vârf
RMPX	Unghi maxim al rampei
RP	Rază programare
RPMX	Turaţia maximă
SA	unghiul sferei
SIG	unghi la vârf
UTCN	Grosime neaşchiată
ZEFP	Numărul muchiilor aşchietoare efective periferice



UNIVERSALE

Seco oferă o gamă completă de freze cilindro-frontale din carbură solidă de înaltă performanţă pentru frezare cilindro-frontală, freze cu cap rotund și freze cilindro-frontale de finisare pentru scule cu productivitate ridicată și durată de viaţă prelungită. Această gamă acoperă produse universale și freze cilindro-frontale optimizate pentru piese de prelucrat din anumite materiale.

Produsele universale oferă flexibilitate deplină de prelucrare, la un raport preţ/performanţă excelent.

- C5121, C5131, C5141, C5231, C5241 și ST5551 pentru tip cu colţ ascuţit.
- JSE512, JSE513, JSE514, JS553, JS554, ST5551, JS564, JS565 și JS520 tip cu șanfren 45°.
- C5121, C5141, JS522, JS553, JS554, ST5551, JH910, JH930, JHF980, J36, V31, JME542, JME562 și JME564 pentru tip cu rază.
- C5021, C5041, JS506, JS509, HK, HKM și J29 pentru tip conic.
- C5321, C5341, JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 și JMB563 pentru tipul cu cap rotund.

Alegerea uneltei - Universal

									
Nume		C5121	C5131	C5141	C5231	C5241	JSE512	JSE513	JSE514
Pag.		38	50	56	73	73	75	79	85
Familia		C-Series	C-Series	C-Series	C-Series	C-Series	SOLID²	SOLID²	SOLID²
Tipul frezei									
Coada	Cilindrică	■	■	■	■	■	■	■	■
	Weldon	■		■			■	■	■
Numărul de dinţi		2	3	4	3	4	2	2	4
CSP									
	Metric	2-12	2-12	1-20			2-12	2-20	2-25
	Inch	1/32-1	1/32-1	1/64-1 1/4	1/-5/8	3/4			
Lungimi disponibile		1,2,3,4,5,6,7,8	1,2,3,4	1,2,3,4,5,6,7,8,9	2,3	3	2	2,3	2,3
Operaţiune									
									
SMG									
P1-8		●	●	●	●	●	●	●	●
P11-12		○	○	○	○	○	○	○	○
M1-3		●	●	●	●	●	●	●	●
M4-5		○	○	○	○	○	○	○	○
K1-7		●	●	●	●	●	●	●	●
S1-3		○	○	○	○	○	○	○	○
S11-13		○	○	○	○	○	○	○	○
H3 H5 H8 H11 H12 H21 H31		○	○	○	○	○	○	○	○
N1		○	○	○	○	○	○	○	○
N2-3		○	○	○	○	○	○	○	○
N11		○	○	○	○	○	○	○	○
TS1		○	○	○	○	○	○	○	○
TP1		○	○	○	○	○	○	○	○
GR		○	○	○	○	○	○	○	○

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă
*JS554 3C de asemenea disponibil. Se poate aplica în degroşarea avansată.

Alegerea uneltei - Universal

										
Nume		JS553	JS554	ST5551	JS564	JS565	JS520	JS522	C5321	C5341
Pag.		95	115	140	166	170	174	178	181	189
Familia		SOLID²	SOLID²	Stabilizer	SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series
Tipul frezei										
Coada	Cilindrică	■	■	■	■	■	■	■	■	■
	Weldon	■	■	□	■	■	□			
Numărul de dinţi		3	4	5	4	5	5,6,8	2	2	4
CSP										
	Metric	2-25	3-25	6-25	3-20	4-20	4-25	6-32	1-12	1-20
	Inch	1/8 - 1/2	1/4-1	1/4-1					1/64-1	1/64-1
Lungimi disponibile		1,2,3	1,2,3	1,2,3,4,5,6,8	2,3,4	2,3,4	2,3	4	1,2,3,4,5,6,7	1,2,3,4,5,6,7,8
Operaţiune										
										
										
SMG										
P1-8		●	●	●	●	●	●	●	●	●
P11-12		●	●	●	○	○	○	●	○	○
M1-3		●	●	●	●	●	○	●	●	●
M4-5		●	●	●	●	●	○	●	○	○
K1-7		●	●	●	●	●	●	●	●	●
S1-3		●	●	●	●	●	○	○	○	○
S11-13		●	●	●	●	●	●	●	○	○
H3 H5 H8 H11 H12 H21 H31		●	●	●	●	●	○		○	○
N1		●	●	●	●	●	●	●	○	○
N2-3		●	●	●	●	●	●	●	○	○
N11		●	●	●	●	●	●	●	○	○
TS1		●	●	●			●	●	○	○
TP1		●	●	●			●	●	○	○
GR		○	○	○			○	○	○	○

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Universal

									
Nume		JSB512	JS532	JS533	JS534	C5021	C5041	JS506	JS509
Pag.		196	198	202	206	210	212	214	218
Familia		SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series	SOLID²	SOLID²
Tipul frezei									
Coada	Cilindrică	■	■	■	■	■	■	■	■
	Weldon		□	■	■			■	■
Numărul de dinţi		2	2	3	4	2	4	3-4	3-4
CSP									
	Metric	2-12	1-20	1-20	2-20			3-12	3-12
	Inch					1/4-1/2	1/4-3/4		
Lungimi disponibile		2	1,2,3	1,2	1,2,3	1	1	2	2
Operaţiune									
									
SMG									
P1-8		●	●	●	●	●	●	●	●
P11-12		○	○	○	○	○	○	○	○
M1-3		●	●	●	●	●	●	●	●
M4-5		○	●	●	●	○	○	●	●
K1-7		●	●	●	●	●	●	●	●
S1-3		○	○	○	○	○	○	○	○
S11-13		○	●	●	●	○	○	●	●
H3 H5 H8 H11 H12 H21 H31		○				○	○	●	●
N1		○	●	●	●	○	○	●	●
N2-3		○	●	●	●	○	○	●	●
N11		○	●	●	●	○	○	●	●
TS1		○	●	●	●	○	○	●	●
TP1		○	●	●	●	○	○	●	●
GR		○	○	○	○	○	○	○	○

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Universal

					
Nume		JH910	JH930	JHB970	JHF980
Pag.		222	226, 511	228, 311	230
Familia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM
Tipul frezei					
Coada	Cilindrică	■	■	■	■
	Weldon				
Numărul de dinţi		3	5-6, 8	2	2,3,4,5
CSP					
	Metric	2-20	6-20	2-16	1-12
	Inch				
Lungimi disponibile		2,3,4	2	1,2,3	1,2,3,4
Operaţiune					
					
					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●		●	●
M4-5		●		●	●
K1-7		●	●		●
S1-3		●	●	●	●
S11-13		●	●	●	●
H3 H5 H8 H11 H12 H21 H31			●		○
N1					
N2-3					
N11					
TS1					
TP1		●			
GR		●			

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Universal

					
Nume		J29	J36	HK/HKM	V31
Pag.		234	237	240	251
Familia		VHM	VHM	VHM	VHM
Tipul frezei					
Coada	Cilindrică	■	■	■	■
	Weldon				
Numărul de dinţi		1	3	2,3,4	4
CSP					
	Metric	0,2-6	2-20	1-10	6-28
	Inch				
Lungimi disponibile		2	2	2	2
Operaţiune					
					
					
SMG					
P1-8		●	○	●	●
P11-12		●	●		○
M1-3		●	○	●	●
M4-5		●	○	●	○
K1-7		●	○	●	●
S1-3		●	○	●	●
S11-13		●	○	●	●
H3 H5 H8 H11 H12 H21 H31		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		●
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Universal

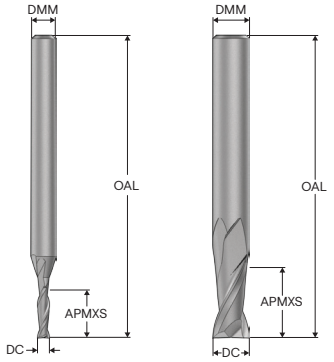
							
Nume		JME542	JME562	JME564	JMB542	JMB562	JMB563
Pag.		254	257	261	264	267	271
Familia		MINI	MINI	MINI	MINI	MINI	MINI
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon						
Numărul de dinţi		2	2	4	2	2	3
CSP							
	Metric	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Inch						
Lungimi disponibile		1,3,4,5,6	2,4,5,6,7	2,4	1,3,4,5,6	1,2,3,4,5,6	2,4
Operaţiune							
							
							
SMG							
P1-8		●	●	●	●	●	●
P11-12		●	●	●	●	●	●
M1-3		●	●	●	●	●	●
M4-5		●	●	●	●	●	●
K1-7							
S1-3							
S11-13		●	●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31							
N1		○	○	○	○	○	○
N2-3		○	○	○	○	○	○
N11		○	○	○	○	○	○
TS1							
TP1							
GR		○	○	○	○	○	○

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

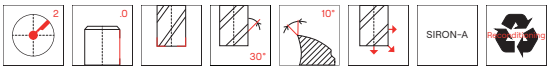
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit





– Toleranţe:
– DMM=h5
– DC= h10
– Reascuţire posibilă dacă DC este ≥ Ø10



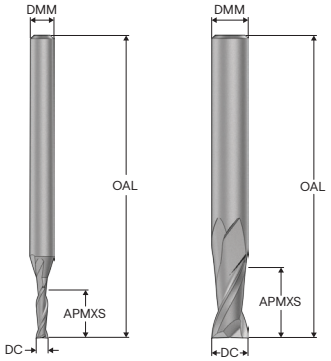
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm			
C5121-060D1S.0Z2	SIRA	10269100	1	D	6,0	6,0	9,0	57,0	2	Cylindrical	■
C5121-020F2S.0Z2	SIRA	10269091	2	F	2,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D2S.0Z2	SIRA	10269093	2	D	3,0	3,0	6,0	38,0	2	Cylindrical	■
C5121-040D2S.0Z2	SIRA	10269096	2	D	4,0	4,0	8,0	50,0	2	Cylindrical	■
C5121-050F2S.0Z2	SIRA	10269098	2	F	5,0	6,0	10,0	57,0	2	Cylindrical	■
C5121-060D2S.0Z2	SIRA	10269101	2	D	6,0	6,0	12,0	57,0	2	Cylindrical	■
C5121-080D2S.0Z2	SIRA	10269103	2	D	8,0	8,0	16,0	63,0	2	Cylindrical	■
C5121-090F2S.0Z2	SIRA	10269105	2	F	9,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-100D2S.0Z2	SIRA	10269106	2	D	10,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-120D2S.0Z2	SIRA	10269108	2	D	12,0	12,0	25,0	83,0	2	Cylindrical	■
C5121-015F3S.0Z2	SIRA	10269090	3	F	1,5	3,0	4,5	38,0	2	Cylindrical	■
C5121-020F3S.0Z2	SIRA	10269092	3	F	2,0	3,0	6,3	38,0	2	Cylindrical	■
C5121-035F3S.0Z2	SIRA	10269095	3	F	3,5	4,0	12,0	50,0	2	Cylindrical	■
C5121-050F3S.0Z2	SIRA	10269099	3	F	5,0	6,0	16,0	57,0	2	Cylindrical	■
C5121-060D3S.0Z2	SIRA	10269102	3	D	6,0	6,0	19,0	63,0	2	Cylindrical	■
C5121-080D3S.0Z2	SIRA	10269104	3	D	8,0	8,0	20,0	63,0	2	Cylindrical	■
C5121-010F4S.0Z2	SIRA	10269089	4	F	1,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D4S.0Z2	SIRA	10269094	4	D	3,0	3,0	12,0	38,0	2	Cylindrical	■
C5121-040D4S.0Z2	SIRA	10269097	4	D	4,0	4,0	14,0	50,0	2	Cylindrical	■
C5121-100D4S.0Z2	SIRA	10269107	4	D	10,0	10,0	35,0	89,0	2	Cylindrical	■
C5121-120D4S.0Z2	SIRA	10269109	4	D	12,0	12,0	50,0	100,0	2	Cylindrical	■

■ **Stoc standard.**

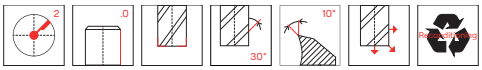
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Reascuţire posibilă dacă DC este ≥ Ø.375

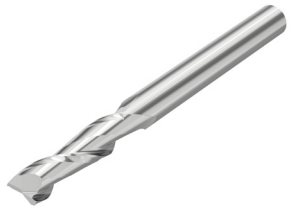


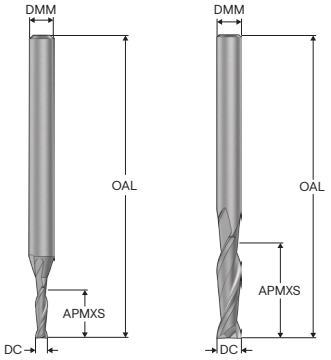
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci			
C5121-.375D1S.0Z2	10268850	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	10268858	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	10268818	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	10268820	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	10268824	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	10268828	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	10268833	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	10268835	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	10268841	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	10268846	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	10268851	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	10268856	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	10268859	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	10268864	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	10268865	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	10268869	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	10268872	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	10268873	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	10268690	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	10268819	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	10268821	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	10268823	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	10268825	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	10268827	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	10268834	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	10268836	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	10268839	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	10268840	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	10268842	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	10268845	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	10268847	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	10268852	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	10268860	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Stoc standard.**

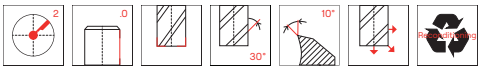
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit – Inci





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—DC ≤ Ø7/64" = ±.0005"
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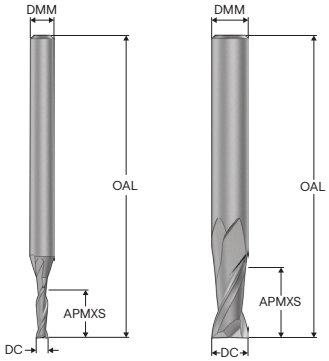
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci			
C5121-.031F4S.0Z2	10268817	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	10268822	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	10268826	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	10268829	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	10268837	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	10268843	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	10268848	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	10268853	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	10268861	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.625D4S.0Z2	10268866	4	D	0.625	0.625	2.250	5.000	2	Cylindrical	■
C5121-.750D4S.0Z2	10268870	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	10268830	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	10268854	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.438D5S.0Z2	10268857	5	D	0.438	0.438	2.000	4.000	2	Cylindrical	■
C5121-.500D5S.0Z2	10268862	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.625D5S.0Z2	10268867	5	D	0.625	0.625	3.000	6.000	2	Cylindrical	■
C5121-.750D5S.0Z2	10268871	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	10268831	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	10268838	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	10268855	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	10268844	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	10268863	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	10268832	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Stoc standard.**

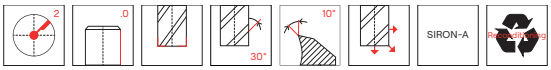
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit – Inci





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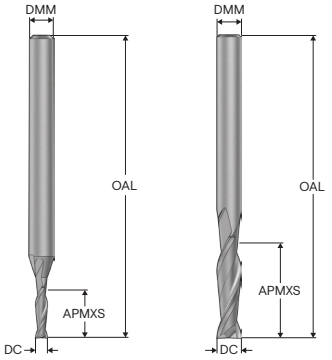
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5121-.375D1S.0Z2	SIRA	10268726	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	SIRA	10268734	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	SIRA	10268693	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	SIRA	10268695	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	SIRA	10268699	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	SIRA	10268703	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	SIRA	10268708	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	SIRA	10268710	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	SIRA	10268716	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	SIRA	10268722	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	SIRA	10268727	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	SIRA	10268732	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	SIRA	10268735	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	SIRA	10268740	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	SIRA	10268741	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	SIRA	10268745	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	SIRA	10268748	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	SIRA	10268749	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	SIRA	10268691	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	SIRA	10268694	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	SIRA	10268696	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	SIRA	10268698	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	SIRA	10268700	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	SIRA	10268702	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	SIRA	10268709	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	SIRA	10268711	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	SIRA	10268714	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	SIRA	10268715	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	SIRA	10268717	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	SIRA	10268721	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	SIRA	10268723	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.344F3S.0Z2	SIRA	10268725	3	F	0.344	0.375	1.000	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	SIRA	10268728	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	SIRA	10268736	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Stoc standard.**

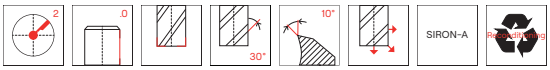
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
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—DC ≤ Ø7/64" = ±.0005"
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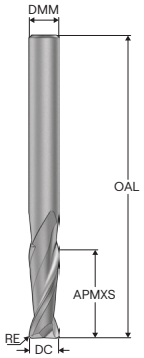
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5121-.031F4S.0Z2	SIRA	10268692	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	SIRA	10268697	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	SIRA	10268701	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	SIRA	10268704	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	SIRA	10268712	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	SIRA	10268718	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	SIRA	10268724	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	SIRA	10268729	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	SIRA	10268737	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.750D4S.0Z2	SIRA	10268746	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	SIRA	10268705	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	SIRA	10268730	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.500D5S.0Z2	SIRA	10268738	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.750D5S.0Z2	SIRA	10268747	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	SIRA	10268706	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	SIRA	10268713	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	SIRA	10268731	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	SIRA	10268719	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	SIRA	10268739	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	SIRA	10268707	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Stoc standard.**

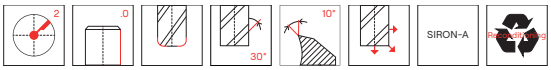
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.001"
—Reascuţire posibilă dacă DC este ≥ Ø.375



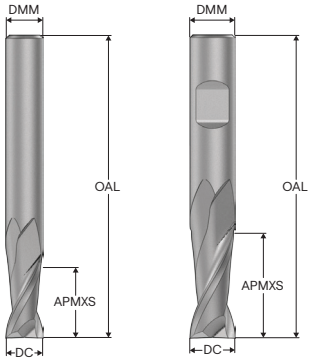
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5121-.500D2R015.0Z2	SIRA	10268755	2	D	0.500	0.500	1.000	3.000	0.015	2	Cylindrical	■
C5121-.500D2R030.0Z2	SIRA	10268756	2	D	0.500	0.500	1.000	3.000	0.030	2	Cylindrical	■
C5121-.500D2R060.0Z2	SIRA	10268757	2	D	0.500	0.500	1.000	3.000	0.060	2	Cylindrical	■
C5121-.500D2R125.0Z2	SIRA	10268758	2	D	0.500	0.500	1.000	3.000	0.125	2	Cylindrical	■
C5121-.625D2R015.0Z2	SIRA	10268759	2	D	0.625	0.625	1.250	3.500	0.015	2	Cylindrical	■
C5121-.625D2R030.0Z2	SIRA	10268760	2	D	0.625	0.625	1.250	3.500	0.030	2	Cylindrical	■
C5121-.625D2R125.0Z2	SIRA	10268762	2	D	0.625	0.625	1.250	3.500	0.125	2	Cylindrical	■
C5121-.750D2R015.0Z2	SIRA	10268763	2	D	0.750	0.750	1.500	4.000	0.015	2	Cylindrical	■
C5121-.750D2R030.0Z2	SIRA	10268764	2	D	0.750	0.750	1.500	4.000	0.030	2	Cylindrical	■
C5121-.750D2R060.0Z2	SIRA	10268765	2	D	0.750	0.750	1.500	4.000	0.060	2	Cylindrical	■
C5121-.750D2R125.0Z2	SIRA	10268766	2	D	0.750	0.750	1.500	4.000	0.125	2	Cylindrical	■
C5121-.250D3R015.0Z2	SIRA	10268750	3	D	0.250	0.250	0.750	2.500	0.015	2	Cylindrical	■
C5121-.250D3R030.0Z2	SIRA	10268751	3	D	0.250	0.250	0.750	2.500	0.030	2	Cylindrical	■
C5121-.375D3R015.0Z2	SIRA	10268752	3	D	0.375	0.375	1.000	2.500	0.015	2	Cylindrical	■
C5121-.375D3R030.0Z2	SIRA	10268753	3	D	0.375	0.375	1.000	2.500	0.030	2	Cylindrical	■

■ **Stoc standard.**

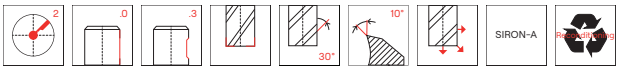
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică/Weldon – Ascuţit – Inci





– Toleranţe:
– DMM=-.0001"/-.0004"
– DC ≤ Ø7/64" = ±.0005"
– DC > Ø7/64" = +.001"/-.000"
– Toleranţă NC
– Reascuţire posibilă dacă DC este ≥ Ø.375



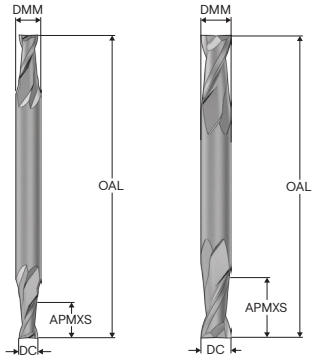
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5121-.375D2S.3Z2NC	SIRA	10269074	2	D	0.375	0.375	0.875	2.500	2	Weldon	■
C5121-.500D2S.3Z2NC	SIRA	10269075	2	D	0.500	0.500	1.000	3.000	2	Weldon	■
C5121-.625D2S.3Z2NC	SIRA	10269076	2	D	0.625	0.625	1.250	3.500	2	Weldon	■
C5121-.750D2S.3Z2NC	SIRA	10269077	2	D	0.750	0.750	1.500	4.000	2	Weldon	■
C5121-.250D3S.0Z2NC	SIRA	10269072	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2NC	SIRA	10269073	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■

■ **Stoc standard.**

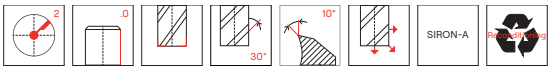
C5121

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Două capete
—Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5121-.500D1S.0Z2D	SIRA	10269088	1	D	0.500	0.500	0.625	3.000	2	Cylindrical	■
C5121-.031F2S.0Z2D	SIRA	10269078	2	F	0.031	0.125	0.063	1.500	2	Cylindrical	■
C5121-.047F2S.0Z2D	SIRA	10269079	2	F	0.047	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2D	SIRA	10269080	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.078F2S.0Z2D	SIRA	10269081	2	F	0.078	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2D	SIRA	10269082	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2D	SIRA	10269083	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.188D2S.0Z2D	SIRA	10269084	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2D	SIRA	10269085	2	D	0.250	0.250	0.500	2.500	2	Cylindrical	■
C5121-.313D2S.0Z2D	SIRA	10269086	2	D	0.313	0.313	0.500	2.500	2	Cylindrical	■
C5121-.375D2S.0Z2D	SIRA	10269087	2	D	0.375	0.375	0.563	2.500	2	Cylindrical	■

■ Stoc standard.

Parametri de aşchiere – C5121 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0055 *0.00022*	0,0085 *0.00034*	0,011 *0.00044*	0,017 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,002 *0.000080*	0,0032 *0.00013*	0,0042 *0.00017*	0,0065 *0.00026*	0,0075 *0.00030*	0,0085 *0.00034*	0,01 *0.00040*	0,013 *0.00050*	0,017 *0.00065*	0,019 *0.00075*	0,02 *0.00080*	0,025 *0.0010*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	30 (20 — 40) *100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JH450 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,11 *0.0044*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,009 *0.00036*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,0017 *0.000065*	0,0034 *0.00013*	0,0065 *0.00026*	0,0085 *0.00034*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	30 (20 — 40) *100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – C5121 Frezare de canal

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	75 (50 — 85) *245 (170 — 270)*
P2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 —40) *100 (66 — 130)*
P3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *147 (98— 196)*
P4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	55 (40 — 65) *180 (130 —210)*
P5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 45) *115 (65— 145)*
P6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	45 (30 — 60) *145 (180 — 195)*
P7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
P8	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (15 — 35) *80 (50 — 110)*
P11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
P12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (20 — 40) *100 (65 — 130)*
M1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	42 (21 — 52) *138 (69 — 170)*
M2	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (20 — 42) *105 (65 — 138)*
M3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	30 (15 — 40) *100 (50 — 130)*
M4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (10 — 35) *72 (33 — 115)*
M5	E	1 *1.0*	0,0013 *0.000050*	0,002 *0.000080*	0,0026 *0.00010*	0,004 *0.00016*	0,0046 *0.00018*	0,005 *0.00020*	0,0065 *0.00026*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,016 *0.00065*	19 (16 — 30) *62 (52 — 100)*
K1	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	30 (20 — 45) *100 (65 — 147)*
K2	E	1 *1.0*	0,0024 *0.000095*	0,0034 *0.00013*	0,0046 *0.00018*	0,007 *0.00028*	0,008 *0.00032*	0,009 *0.00036*	0,012 *0.00048*	0,014 *0.00055*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	40 (30 — 50) *130 (100 — 165)*
K3	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (26 — 45) *105 (85 — 148)*
K4	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	22 (18 — 30) *72 (60 — 100)*
K5	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	20 (15 — 30) *65 (50 — 100)*
K6	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
K7	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (20 — 50) *115 (65 — 165)*
S1	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	25 (18 — 30) *80 (60 — 100)*
S2	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	13 (9 — 18) *62 (30 — 60)*
S3	E	1 *1.0*	0,001 *0.000040*	0,0015 *0.000060*	0,002 *0.000080*	0,003 *0.00012*	0,0036 *0.00014*	0,004 *0.00016*	0,005 *0.00020*	0,006 *0.00024*	0,008 *0.00032*	0,009 *0.00036*	0,01 *0.00040*	0,012 *0.00048*	7,0 (5 — 12) *23 (15— 39)*
S11	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	35 (25 — 40) *114 (82— 130)*
S12	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	32 (22 — 40) *105 (72 — 130)*
S13	E	1 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	10 (8— 15) *33 (26 — 50)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – C5121 Frezare de canal – Inci

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

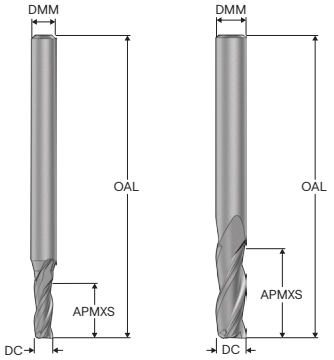
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

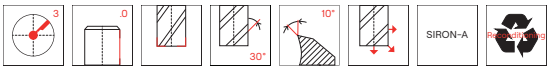
C5131

Uz general – Universale – Pătrat – 3 Caneluri – Cilindrică – Ascuţit





– Toleranţe:
– DMM=h5
– DC= h10
– Reascuţire posibilă dacă DC este ≥ Ø10



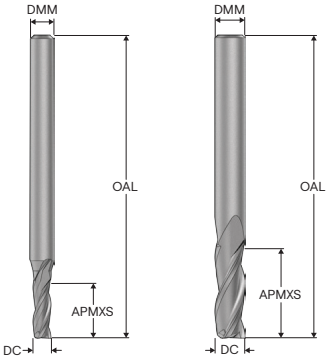
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm			
C5131-060D1S.0Z3	SIRA	10268801	1	D	6,0	6,0	9,0	57,0	3	Cylindrical	■
C5131-020F2S.0Z3	SIRA	10268792	2	F	2,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D2S.0Z3	SIRA	10268794	2	D	3,0	3,0	6,0	38,0	3	Cylindrical	■
C5131-040D2S.0Z3	SIRA	10268797	2	D	4,0	4,0	8,0	50,0	3	Cylindrical	■
C5131-050F2S.0Z3	SIRA	10268799	2	F	5,0	6,0	10,0	57,0	3	Cylindrical	■
C5131-060D2S.0Z3	SIRA	10268802	2	D	6,0	6,0	12,0	57,0	3	Cylindrical	■
C5131-080D2S.0Z3	SIRA	10268804	2	D	8,0	8,0	16,0	63,0	3	Cylindrical	■
C5131-090F2S.0Z3	SIRA	10268806	2	F	9,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-100D2S.0Z3	SIRA	10268807	2	D	10,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-120D2S.0Z3	SIRA	10268809	2	D	12,0	12,0	25,0	83,0	3	Cylindrical	■
C5131-015F3S.0Z3	SIRA	10268791	3	F	1,5	3,0	4,5	38,0	3	Cylindrical	■
C5131-020F3S.0Z3	SIRA	10268793	3	F	2,0	3,0	6,3	38,0	3	Cylindrical	■
C5131-035F3S.0Z3	SIRA	10268796	3	F	3,5	4,0	12,0	50,0	3	Cylindrical	■
C5131-050F3S.0Z3	SIRA	10268800	3	F	5,0	6,0	16,0	57,0	3	Cylindrical	■
C5131-060D3S.0Z3	SIRA	10268803	3	D	6,0	6,0	19,0	63,0	3	Cylindrical	■
C5131-080D3S.0Z3	SIRA	10268805	3	D	8,0	8,0	20,0	63,0	3	Cylindrical	■
C5131-010F4S.0Z3	SIRA	10268790	4	F	1,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D4S.0Z3	SIRA	10268795	4	D	3,0	3,0	12,0	38,0	3	Cylindrical	■
C5131-040D4S.0Z3	SIRA	10268798	4	D	4,0	4,0	14,0	50,0	3	Cylindrical	■
C5131-100D4S.0Z3	SIRA	10268808	4	D	10,0	10,0	35,0	89,0	3	Cylindrical	■
C5131-120D4S.0Z3	SIRA	10268810	4	D	12,0	12,0	50,0	100,0	3	Cylindrical	■

■ **Stoc standard.**

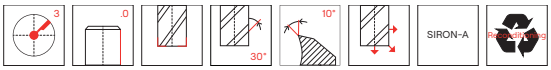
C5131

Uz general – Universale – Pătrat – 3 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5131-.047F2S.0Z3	SIRA	10268772	2	F	0.047	0.125	0.109	1.500	3	Cylindrical	■
C5131-.078F2S.0Z3	SIRA	10268774	2	F	0.078	0.125	0.188	1.500	3	Cylindrical	■
C5131-.438D2S.0Z3	SIRA	10268784	2	D	0.438	0.438	1.000	2.750	3	Cylindrical	■
C5131-.500D2S.0Z3	SIRA	10268785	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5131-.563D2S.0Z3	SIRA	10268786	2	D	0.563	0.563	1.125	3.500	3	Cylindrical	■
C5131-.625D2S.0Z3	SIRA	10268787	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5131-.750D2S.0Z3	SIRA	10268788	2	D	0.750	0.750	1.500	4.000	3	Cylindrical	■
C5131-1.000D2S.0Z3	SIRA	10268789	2	D	1.000	1.000	1.500	4.000	3	Cylindrical	■
C5131-.031F3S.0Z3	SIRA	10268771	3	F	0.031	0.125	0.078	1.500	3	Cylindrical	■
C5131-.063F3S.0Z3	SIRA	10268773	3	F	0.063	0.125	0.188	1.500	3	Cylindrical	■
C5131-.094F3S.0Z3	SIRA	10268775	3	F	0.094	0.125	0.281	1.500	3	Cylindrical	■
C5131-.109F3S.0Z3	SIRA	10268776	3	F	0.109	0.125	0.375	1.500	3	Cylindrical	■
C5131-.156F3S.0Z3	SIRA	10268778	3	F	0.156	0.188	0.500	2.000	3	Cylindrical	■
C5131-.188D3S.0Z3	SIRA	10268779	3	D	0.188	0.188	0.625	2.000	3	Cylindrical	■
C5131-.250D3S.0Z3	SIRA	10268781	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5131-.313D3S.0Z3	SIRA	10268782	3	D	0.313	0.313	0.813	2.500	3	Cylindrical	■
C5131-.375D3S.0Z3	SIRA	10268783	3	D	0.375	0.375	1.000	2.500	3	Cylindrical	■
C5131-.125D4S.0Z3	SIRA	10268777	4	D	0.125	0.125	0.500	1.500	3	Cylindrical	■

■ Stoc standard.

Parametri de aşchiere – C5131 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1 *0.10*	1,9 *1.9*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	1,9 *1.9*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	1,9 *1.9*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	1,9 *1.9*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	1,9 *1.9*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	1,9 *1.9*	0,0048 *0.00019*	0,0075 *0.00030*	0,01 *0.00040*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,044 *0.0017*	0,048 *0.0019*	0,06 *0.0024*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	1,9 *1.9*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	1,9 *1.9*	0,0055 *0.00022*	0,0085 *0.00034*	0,011 *0.00044*	0,017 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	1,9 *1.9*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	1,9 *1.9*	0,002 *0.000080*	0,0032 *0.00013*	0,0042 *0.00017*	0,0065 *0.00026*	0,0075 *0.00030*	0,0085 *0.00034*	0,01 *0.00040*	0,013 *0.00050*	0,017 *0.00065*	0,019 *0.00075*	0,02 *0.00080*	0,025 *0.0010*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	1,9 *1.9*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,05 *0.0020*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	1,9 *1.9*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	1,9 *1.9*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	30 (20 — 40) *100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – C5131 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,11 *0.0044*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,009 *0.00036*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,0017 *0.000065*	0,0034 *0.00013*	0,0065 *0.00026*	0,0085 *0.00034*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	30 (20 — 40) *100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – C5131 Frezare de canal

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*33 (26 — 50)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – C5131 Frezare de canal – Inci

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

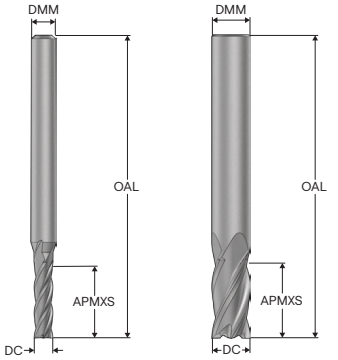
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

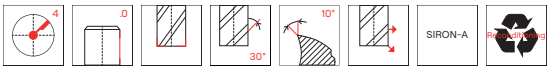
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit





– Toleranţe:
– DMM=h5
– DC= h10
– Reascuţire posibilă dacă DC este ≥ Ø10



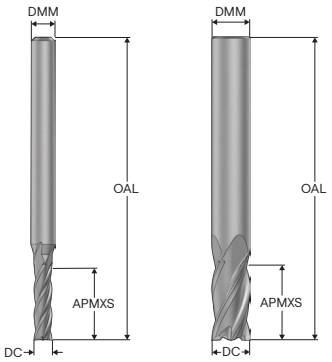
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm			
C5141-060D1S.0Z4	SIRA	10268459	1	D	6,0	6,0	9,0	57,0	4	Cylindrical	■
C5141-020F2S.0Z4	SIRA	10268450	2	F	2,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D2S.0Z4	SIRA	10268452	2	D	3,0	3,0	6,0	38,0	4	Cylindrical	■
C5141-040D2S.0Z4	SIRA	10268455	2	D	4,0	4,0	8,0	50,0	4	Cylindrical	■
C5141-050F2S.0Z4	SIRA	10268457	2	F	5,0	6,0	10,0	57,0	4	Cylindrical	■
C5141-060D2S.0Z4	SIRA	10268460	2	D	6,0	6,0	12,0	57,0	4	Cylindrical	■
C5141-080D2S.0Z4	SIRA	10268462	2	D	8,0	8,0	16,0	63,0	4	Cylindrical	■
C5141-080D3S.0Z4	SIRA	10268463	2	D	8,0	8,0	20,0	64,0	4	Cylindrical	■
C5141-090F2S.0Z4	SIRA	10268464	2	F	9,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-100D2S.0Z4	SIRA	10268465	2	D	10,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-120D2S.0Z4	SIRA	10268467	2	D	12,0	12,0	25,0	74,0	4	Cylindrical	■
C5141-160D2S.0Z4	SIRA	10268469	2	D	16,0	16,0	32,0	92,0	4	Cylindrical	■
C5141-200D2S.0Z4	SIRA	10268471	2	D	20,0	20,0	35,0	104,0	4	Cylindrical	■
C5141-015F3S.0Z4	SIRA	10268449	3	F	1,5	3,0	4,5	39,0	4	Cylindrical	■
C5141-020F3S.0Z4	SIRA	10268451	3	F	2,0	3,0	6,3	39,0	4	Cylindrical	■
C5141-035F3S.0Z4	SIRA	10268454	3	F	3,5	4,0	12,0	51,0	4	Cylindrical	■
C5141-050F3S.0Z4	SIRA	10268458	3	F	5,0	6,0	16,0	51,0	4	Cylindrical	■
C5141-060D3S.0Z4	SIRA	10268461	3	D	6,0	6,0	19,0	51,0	4	Cylindrical	■
C5141-160D3S.0Z4	SIRA	10268470	3	D	16,0	16,0	50,0	115,0	4	Cylindrical	■
C5141-200D3S.0Z4	SIRA	10268472	3	D	20,0	20,0	60,0	125,0	4	Cylindrical	■
C5141-010F4S.0Z4	SIRA	10268448	4	F	1,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D4S.0Z4	SIRA	10268453	4	D	3,0	3,0	12,0	39,0	4	Cylindrical	■
C5141-040D4S.0Z4	SIRA	10268456	4	D	4,0	4,0	14,0	51,0	4	Cylindrical	■
C5141-100D4S.0Z4	SIRA	10268466	4	D	10,0	10,0	35,0	89,0	4	Cylindrical	■
C5141-120D4S.0Z4	SIRA	10268468	4	D	12,0	12,0	50,0	100,0	4	Cylindrical	■

■ **Stoc standard.**

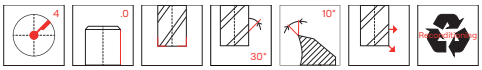
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Reascuţire posibilă dacă DC este ≥ Ø.375



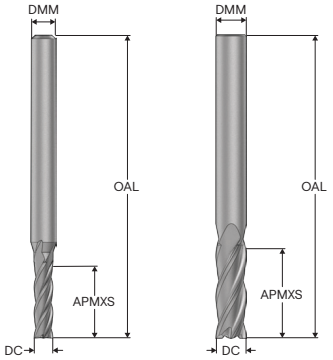
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci			
C5141-.375D1S.0Z4	10268208	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	10268220	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	10268228	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	10268236	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	10268242	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	10268249	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	10268152	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	10268155	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	10268157	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	10268161	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	10268163	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	10268168	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	10268175	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	10268178	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	10268185	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	10268188	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	10268198	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	10268209	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	10268218	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	10268221	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.500D2S.0Z4	10268229	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	10268235	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	10268237	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	10268241	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	10268243	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	10268248	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	10268250	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	10268255	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■
C5141-.031F3S.0Z4	10268153	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	10268156	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	10268158	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	10268162	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	10268164	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	10268167	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■

■ **Stoc standard.**

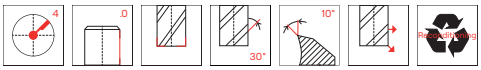
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





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—DC ≤ Ø7/64" = ±.0005"
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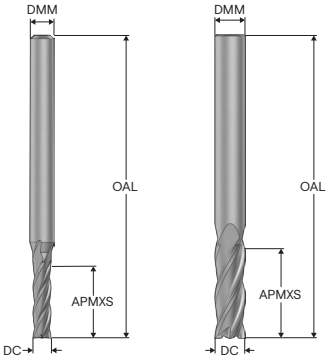
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci			
C5141-.156F3S.0Z4	10268176	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	10268179	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	10268184	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	10268186	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	10268187	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	10268189	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	10268196	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	10268199	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	10268206	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	10268210	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.438D3S.0Z4	10268222	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	10268230	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	10268238	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	10268244	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	10268251	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■
C5141-.031F4S.0Z4	10268154	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	10268159	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	10268165	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	10268169	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	10268174	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	10268177	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	10268180	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	10268190	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	10268200	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	10268211	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	10268223	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	10268231	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	10268239	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	10268245	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	10268252	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■

■ **Stoc standard.**

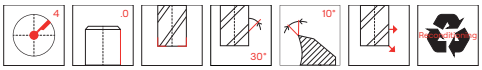
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





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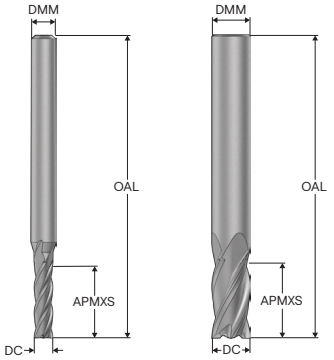
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci			
C5141-.125D5S.0Z4	10268170	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	10268181	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	10268191	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	10268201	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	10268212	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	10268224	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	10268232	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	10268240	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	10268246	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	10268253	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-.125D6S.0Z4	10268171	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	10268182	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	10268192	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	10268202	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	10268213	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	10268225	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	10268233	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	10268247	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	10268254	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■
C5141-.188D7S.0Z4	10268183	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	10268193	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	10268203	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	10268214	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	10268226	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	10268234	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	10268160	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	10268166	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	10268172	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	10268194	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	10268204	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	10268215	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	10268173	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	10268216	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Stoc standard.**

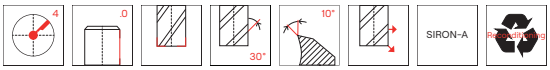
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





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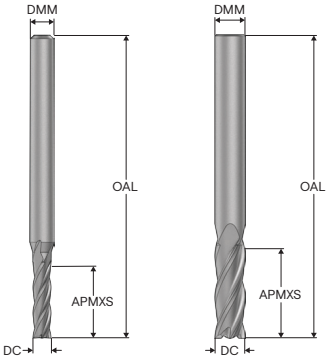
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.375D1S.0Z4	SIRA	10268312	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	SIRA	10268324	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	SIRA	10268332	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	SIRA	10268340	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	SIRA	10268346	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	SIRA	10268353	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	SIRA	10268256	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	SIRA	10268259	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	SIRA	10268261	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	SIRA	10268265	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	SIRA	10268267	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	SIRA	10268272	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	SIRA	10268279	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	SIRA	10268282	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	SIRA	10268289	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	SIRA	10268292	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	SIRA	10268302	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	SIRA	10268313	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	SIRA	10268322	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	SIRA	10268325	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.469F2S.0Z4	SIRA	10268331	2	F	0.469	0.500	1.000	3.000	4	Cylindrical	■
C5141-.500D2S.0Z4	SIRA	10268333	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	SIRA	10268339	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	SIRA	10268341	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	SIRA	10268345	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	SIRA	10268347	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	SIRA	10268352	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	SIRA	10268354	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	SIRA	10268359	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■

■ **Stoc standard.**

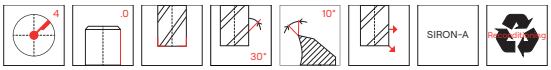
C5141

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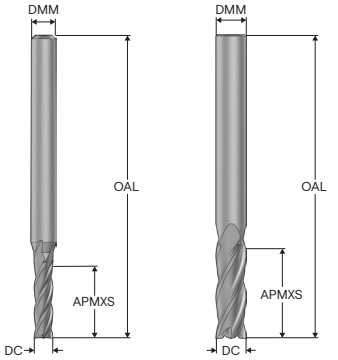
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.031F3S.0Z4	SIRA	10268257	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	SIRA	10268260	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	SIRA	10268262	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	SIRA	10268266	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	SIRA	10268268	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	SIRA	10268271	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■
C5141-.156F3S.0Z4	SIRA	10268280	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	SIRA	10268283	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	SIRA	10268288	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	SIRA	10268290	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	SIRA	10268291	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	SIRA	10268293	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.266F3S.0Z4	SIRA	10268299	3	F	0.266	0.313	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	SIRA	10268300	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.297F3S.0Z4	SIRA	10268301	3	F	0.297	0.313	0.813	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	SIRA	10268303	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.328F3S.0Z4	SIRA	10268309	3	F	0.328	0.375	1.000	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	SIRA	10268310	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.359F3S.0Z4	SIRA	10268311	3	F	0.359	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	SIRA	10268314	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.391F3S.0Z4	SIRA	10268321	3	F	0.391	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D3S.0Z4	SIRA	10268326	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	SIRA	10268334	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	SIRA	10268342	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	SIRA	10268348	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	SIRA	10268355	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■

■ **Stoc standard.**

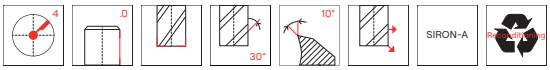
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Reascuţire posibilă dacă DC este ≥ Ø.375



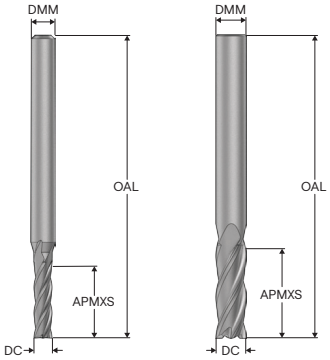
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.031F4S.0Z4	SIRA	10268258	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	SIRA	10268263	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	SIRA	10268269	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	SIRA	10268273	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	SIRA	10268278	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	SIRA	10268281	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	SIRA	10268284	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	SIRA	10268294	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	SIRA	10268304	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	SIRA	10268315	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	SIRA	10268327	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	SIRA	10268335	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	SIRA	10268343	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	SIRA	10268349	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	SIRA	10268356	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■
C5141-.125D5S.0Z4	SIRA	10268274	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	SIRA	10268285	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	SIRA	10268295	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	SIRA	10268305	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	SIRA	10268316	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	SIRA	10268328	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	SIRA	10268336	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	SIRA	10268344	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	SIRA	10268350	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	SIRA	10268357	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	SIRA	10268358	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■

■ **Stoc standard.**

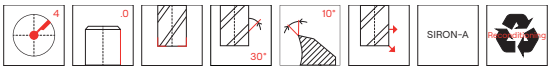
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





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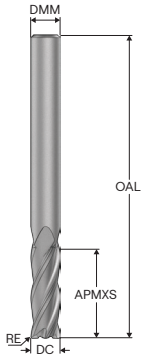
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.125D6S.0Z4	SIRA	10268275	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	SIRA	10268286	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	SIRA	10268296	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	SIRA	10268306	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	SIRA	10268317	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	SIRA	10268329	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	SIRA	10268337	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	SIRA	10268351	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-.188D7S.0Z4	SIRA	10268287	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	SIRA	10268297	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	SIRA	10268307	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	SIRA	10268318	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	SIRA	10268330	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	SIRA	10268338	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	SIRA	10268264	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	SIRA	10268270	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	SIRA	10268276	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	SIRA	10268298	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	SIRA	10268308	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	SIRA	10268319	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	SIRA	10268277	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	SIRA	10268320	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Stoc standard.**

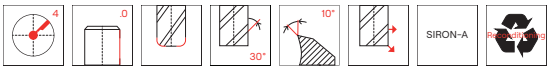
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





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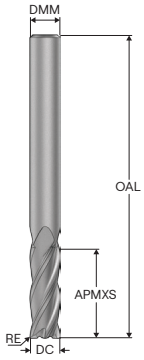
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5141-.438D2R015.0Z4	SIRA	10268379	2	D	0.438	0.438	1.000	2.750	0.015	4	Cylindrical	■
C5141-.438D2R030.0Z4	SIRA	10268380	2	D	0.438	0.438	1.000	2.750	0.030	4	Cylindrical	■
C5141-.438D2R060.0Z4	SIRA	10268381	2	D	0.438	0.438	1.000	2.750	0.060	4	Cylindrical	■
C5141-.438D2R125.0Z4	SIRA	10268382	2	D	0.438	0.438	1.000	2.750	0.125	4	Cylindrical	■
C5141-.500D2R015.0Z4	SIRA	10268383	2	D	0.500	0.500	1.000	3.000	0.015	4	Cylindrical	■
C5141-.500D2R020.0Z4	SIRA	10268384	2	D	0.500	0.500	1.000	3.000	0.020	4	Cylindrical	■
C5141-.500D2R030.0Z4	SIRA	10268385	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
C5141-.500D2R045.0Z4	SIRA	10268386	2	D	0.500	0.500	1.000	3.000	0.045	4	Cylindrical	■
C5141-.500D2R060.0Z4	SIRA	10268387	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
C5141-.500D2R090.0Z4	SIRA	10268388	2	D	0.500	0.500	1.000	3.000	0.090	4	Cylindrical	■
C5141-.500D2R125.0Z4	SIRA	10268389	2	D	0.500	0.500	1.000	3.000	0.125	4	Cylindrical	■
C5141-.625D2R015.0Z4	SIRA	10268390	2	D	0.625	0.625	1.250	3.500	0.015	4	Cylindrical	■
C5141-.625D2R030.0Z4	SIRA	10268391	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
C5141-.625D2R060.0Z4	SIRA	10268392	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
C5141-.625D2R125.0Z4	SIRA	10268393	2	D	0.625	0.625	1.250	3.500	0.125	4	Cylindrical	■
C5141-.750D2R015.0Z4	SIRA	10268394	2	D	0.750	0.750	1.500	4.000	0.015	4	Cylindrical	■
C5141-.750D2R020.0Z4	SIRA	10268395	2	D	0.750	0.750	1.500	4.000	0.020	4	Cylindrical	■
C5141-.750D2R030.0Z4	SIRA	10268396	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
C5141-.750D2R045.0Z4	SIRA	10268397	2	D	0.750	0.750	1.500	4.000	0.045	4	Cylindrical	■
C5141-.750D2R060.0Z4	SIRA	10268398	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
C5141-.750D2R090.0Z4	SIRA	10268399	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
C5141-.750D2R125.0Z4	SIRA	10268400	2	D	0.750	0.750	1.500	4.000	0.125	4	Cylindrical	■
C5141-.750D2R190.0Z4	SIRA	10268402	2	D	0.750	0.750	1.500	4.000	0.190	4	Cylindrical	■
C5141-1.000D2R030.0Z4	SIRA	10268405	2	D	1.000	1.000	1.500	4.000	0.030	4	Cylindrical	■
C5141-1.000D2R060.0Z4	SIRA	10268406	2	D	1.000	1.000	1.500	4.000	0.060	4	Cylindrical	■
C5141-1.000D2R090.0Z4	SIRA	10268407	2	D	1.000	1.000	1.500	4.000	0.090	4	Cylindrical	■
C5141-1.000D2R125.0Z4	SIRA	10268408	2	D	1.000	1.000	1.500	4.000	0.125	4	Cylindrical	■
C5141-1.000D2R190.0Z4	SIRA	10268409	2	D	1.000	1.000	1.500	4.000	0.190	4	Cylindrical	■

■ **Stoc standard.**

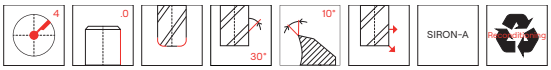
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





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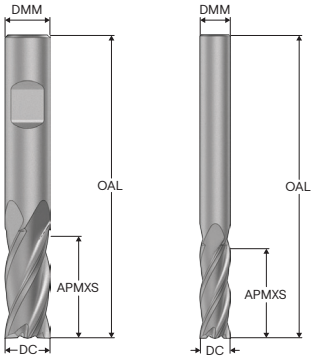
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5141-.188D3R015.0Z4	SIRA	10268363	3	D	0.188	0.188	0.625	2.000	0.015	4	Cylindrical	■
C5141-.188D3R020.0Z4	SIRA	10268364	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
C5141-.188D3R030.0Z4	SIRA	10268365	3	D	0.188	0.188	0.625	2.000	0.030	4	Cylindrical	■
C5141-.250D3R015.0Z4	SIRA	10268366	3	D	0.250	0.250	0.750	2.500	0.015	4	Cylindrical	■
C5141-.250D3R020.0Z4	SIRA	10268367	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
C5141-.250D3R030.0Z4	SIRA	10268368	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
C5141-.250D3R045.0Z4	SIRA	10268369	3	D	0.250	0.250	0.750	2.500	0.045	4	Cylindrical	■
C5141-.313D3R015.0Z4	SIRA	10268370	3	D	0.313	0.313	0.813	2.500	0.015	4	Cylindrical	■
C5141-.313D3R020.0Z4	SIRA	10268371	3	D	0.313	0.313	0.813	2.500	0.020	4	Cylindrical	■
C5141-.313D3R030.0Z4	SIRA	10268372	3	D	0.313	0.313	0.813	2.500	0.030	4	Cylindrical	■
C5141-.313D3R045.0Z4	SIRA	10268373	3	D	0.313	0.313	0.813	2.500	0.045	4	Cylindrical	■
C5141-.375D3R015.0Z4	SIRA	10268374	3	D	0.375	0.375	1.000	2.500	0.015	4	Cylindrical	■
C5141-.375D3R020.0Z4	SIRA	10268375	3	D	0.375	0.375	1.000	2.500	0.020	4	Cylindrical	■
C5141-.375D3R030.0Z4	SIRA	10268376	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
C5141-.375D3R045.0Z4	SIRA	10268377	3	D	0.375	0.375	1.000	2.500	0.045	4	Cylindrical	■
C5141-.125D4R015.0Z4	SIRA	10268360	4	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
C5141-.125D4R020.0Z4	SIRA	10268361	4	D	0.125	0.125	0.500	1.500	0.020	4	Cylindrical	■
C5141-.125D4R030.0Z4	SIRA	10268362	4	D	0.125	0.125	0.500	1.500	0.030	4	Cylindrical	■

■ **Stoc standard.**

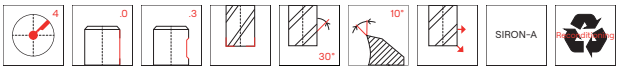
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică/Weldon – Ascuţit – Inci





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—Toleranţă NC
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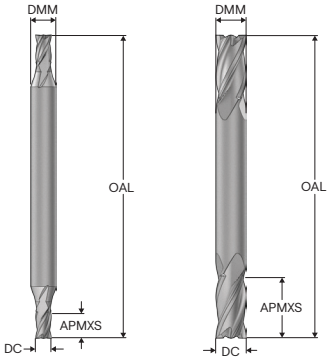
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.375D2S.3Z4NC	SIRA	10268423	2	D	0.375	0.375	0.875	2.500	4	Weldon	■
C5141-.500D2S.3Z4NC	SIRA	10268424	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
C5141-.625D2S.3Z4NC	SIRA	10268425	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
C5141-.750D2S.3Z4NC	SIRA	10268426	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
C5141-1.000D2S.3Z4NC	SIRA	10268427	2	D	1.000	1.000	1.500	4.000	4	Weldon	■
C5141-.250D3S.0Z4NC	SIRA	10268421	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4NC	SIRA	10268422	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■

■ **Stoc standard.**

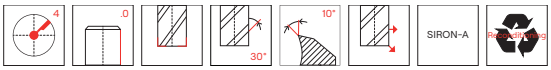
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





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—Două capete
—Reascuţire posibilă dacă DC este ≥ Ø.375



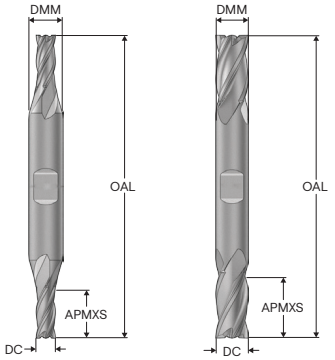
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.438D1S.0Z4D	SIRA	10268446	1	D	0.438	0.438	0.563	2.750	4	Cylindrical	■
C5141-.500D1S.0Z4D	SIRA	10268447	1	D	0.500	0.500	0.625	3.000	4	Cylindrical	■
C5141-.031F2S.0Z4D	SIRA	10268428	2	F	0.031	0.125	0.063	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4D	SIRA	10268429	2	F	0.047	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4D	SIRA	10268430	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4D	SIRA	10268431	2	F	0.078	0.125	0.125	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4D	SIRA	10268432	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.109F2S.0Z4D	SIRA	10268433	2	F	0.109	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4D	SIRA	10268434	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.141F2S.0Z4D	SIRA	10268435	2	F	0.141	0.188	0.313	2.000	4	Cylindrical	■
C5141-.156F2S.0Z4D	SIRA	10268436	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.172F2S.0Z4D	SIRA	10268437	2	F	0.172	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4D	SIRA	10268438	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.203F2S.0Z4D	SIRA	10268439	2	F	0.203	0.250	0.500	2.500	4	Cylindrical	■
C5141-.219F2S.0Z4D	SIRA	10268440	2	F	0.219	0.250	0.500	2.500	4	Cylindrical	■
C5141-.234F2S.0Z4D	SIRA	10268441	2	F	0.234	0.250	0.500	2.500	4	Cylindrical	■
C5141-.250D2S.0Z4D	SIRA	10268442	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
C5141-.281F2S.0Z4D	SIRA	10268443	2	F	0.281	0.313	0.500	2.500	4	Cylindrical	■
C5141-.313D2S.0Z4D	SIRA	10268444	2	D	0.313	0.313	0.500	2.500	4	Cylindrical	■
C5141-.375D2S.0Z4D	SIRA	10268445	2	D	0.375	0.375	0.563	2.500	4	Cylindrical	■

■ Stoc standard.

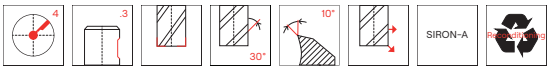
C5141

Uz general – Universale – Pătrat – 4 Caneluri – Weldon – Ascuţit – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Două capete
—Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5141-.281F2S.3Z4D	SIRA	10268415	2	F	0.281	0.375	0.688	3.500	4	Weldon	■
C5141-.313F2S.3Z4D	SIRA	10268416	2	F	0.313	0.375	0.750	3.500	4	Weldon	■
C5141-.344F2S.3Z4D	SIRA	10268417	2	F	0.344	0.375	0.750	3.500	4	Weldon	■
C5141-.375D2S.3Z4D	SIRA	10268418	2	D	0.375	0.375	0.750	3.500	4	Weldon	■
C5141-.438F2S.3Z4D	SIRA	10268419	2	F	0.438	0.500	0.875	4.000	4	Weldon	■
C5141-.500D2S.3Z4D	SIRA	10268420	2	D	0.500	0.500	1.000	4.000	4	Weldon	■
C5141-.125F3S.3Z4D	SIRA	10268410	3	F	0.125	0.375	0.375	3.063	4	Weldon	■
C5141-.156F3S.3Z4D	SIRA	10268411	3	F	0.156	0.375	0.438	3.125	4	Weldon	■
C5141-.188F3S.3Z4D	SIRA	10268412	3	F	0.188	0.375	0.500	3.250	4	Weldon	■
C5141-.219F3S.3Z4D	SIRA	10268413	3	F	0.219	0.375	0.563	3.375	4	Weldon	■
C5141-.250F3S.3Z4D	SIRA	10268414	3	F	0.250	0.375	0.625	3.375	4	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – C5141 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z													v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	150 (135 — 165)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*490 (440— 540)*
P2	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	58 (45— 70)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*190 (147 — 230)*
P3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*279 (246 — 312)*
P4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	100 (90 — 110)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*330 (295 — 360)*
P5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	68 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*223 (165 — 245)*
P6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	87 (77 — 100)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*285 (250 — 330)*
P7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
P8	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (165 — 245)*
P11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*280 (230 — 310)*
P12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	55 (45— 65)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*180 (147 — 213)*
M1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	93 (83 — 100)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*305 (270 — 360)*
M2	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	60 (50 — 70)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*200 (165 — 230)*
M3	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	55 (45 —65)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*180 (147 — 213)*
M4	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,09	45 (35 — 55)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0036*	*147 (115 — 180)*
M5	E	0,1	2	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	0,07	0,085	35 (20 — 45)
		0.10	*2.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0028*	*0.0034*	*114 (65 — 147)*
K1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	80 (70 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*260 (230 — 290)*
K2	E	0,1	2	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	0,09	0,11	87 (75 — 100)
		0.10	*2.0*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*285 (245 — 330)*
K3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
K4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 65)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 213)*
K5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	45 (30 — 55)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*147 (100 — 180)*
K6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (65 — 85)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (210 — 280)*
K7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (60 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (200 — 290)*
S1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 60)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*82 (50 — 115)*
S3	E	0,1	2	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	0,034	0,042	11 (7,5 — 16)
		0.10	*2.0*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*35 (25 — 52)*
S11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	110 (95— 120)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*360 (311 — 390)*
S12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	77 (60 — 90)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*250 (190 — 290)*
S13	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	30 (20 — 40)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – C5141 Frezare laterală – Inci

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	150 (135 — 165)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*490 (440— 540)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	58 (45— 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*190 (147 — 230)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*279 (246 — 312)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	100 (90 — 110)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*330 (295 — 360)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	68 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*223 (165 — 245)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	87 (77 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*285 (250 — 330)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (165 — 245)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*280 (230 — 310)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45— 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	93 (83 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*305 (270 — 360)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	60 (50 — 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*200 (165 — 230)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45 —65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (35 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (115 — 180)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	0,042	35 (20 — 45)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*114 (65 — 147)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	80 (70 — 90)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*260 (230 — 290)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	87 (75 — 100)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*285 (245 — 330)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 213)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (30 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (100 — 180)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (65 — 85)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (210 — 280)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (200 — 290)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 200)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	25 (15 — 35)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*82 (50 — 115)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	11 (7,5 — 16)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*35 (25 — 52)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	110 (95— 120)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*360 (311 — 390)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (190 — 290)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – C5141 Frezare de canal

SMG		a_p/DC	f_z														v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	0,02	0,026	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*33 (26 — 50)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – C5141 Frezare de canal – Inci

SMG		a_e/DC	a_p/DC	f_z														v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	75 (50 — 85)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*245 (170 — 270)*
P2	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 —40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (66 — 130)*
P3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*147 (98— 196)*
P4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	55 (40 — 65)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*180 (130 —210)*
P5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65— 145)*
P6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*145 (180 — 195)*
P7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
P8	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (50 — 110)*
P11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 — 42)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (65 — 138)*
P12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	30 (20 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*100 (65 — 130)*
M1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	42 (21 — 52)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*138 (69 — 170)*
M2	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	32 (20 — 42)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*105 (65 — 138)*
M3	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,13	30 (15 — 40)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0050*	*100 (50 — 130)*
M4	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,09	0,1	0,11	22 (10 — 35)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*72 (33 — 115)*
M5	E	0,1	2	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,04	0,055	0,07	0,08	0,11	0,14	19 (16 — 30)
		0.10	*2.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0016*	*0.0022*	*0.0028*	*0.0032*	*0.0044*	*0.0055*	*62 (52 — 100)*
K1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	30 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (65 — 147)*
K2	E	0,1	2	0,0044	0,009	0,018	0,022	0,026	0,032	0,036	0,044	0,055	0,07	0,09	0,11	0,14	0,18	40 (30 — 50)
		0.10	*2.0*	*0.00017*	*0.00036*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0014*	*0.0017*	*0.0022*	*0.0028*	*0.0036*	*0.0044*	*0.0055*	*0.0070*	*130 (100 — 165)*
K3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (26 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (85 — 148)*
K4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	22 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*72 (60 — 100)*
K5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	20 (15 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*65 (50 — 100)*
K6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
K7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
S1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (60 — 100)*
S2	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	13 (9 — 18)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*62 (30 — 60)*
S3	E	0,1	2	0,0017	0,0034	0,0065	0,0085	0,01	0,012	0,013	0,017	0,02	0,026	0,034	0,04	0,055	0,065	7,0 (5 — 12)
		0.10	*2.0*	*0.000065*	*0.00013*	*0.00026*	*0.00034*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0016*	*0.0022*	*0.0026*	*23 (15— 39)*
S11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (25 — 40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*114 (82— 130)*
S12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	32 (22 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*105 (72 — 130)*
S13	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	10 (8— 15)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*33 (26 — 50)*

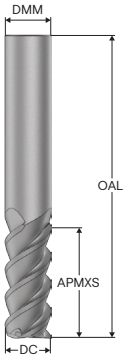
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

C5231/C5241

Uz general – Universale – Șanfren – 3-4 Caneluri – Cilindrică – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
C5231-.375D2S.0Z3	SIRA	10268591	2	D	0.375	0.375	0.875	2.500	3	Cylindrical	■
C5231-.500D2S.0Z3	SIRA	10268592	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5231-.625D2S.0Z3	SIRA	10268593	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5231-.250D3S.0Z3	SIRA	10268590	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5241-.750D3S.0Z4	SIRA	10268594	3	D	0.750	0.750	1.500	4.000	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – C5231-C5241 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/4	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0575 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0045*	0,13 *0.005*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,035 *0.0014*	0,05 *0.002*	0,069 *0.0028*	0,088 *0.0035*	0,1 *0.004*	0,14 *0.0055*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,045 *0.0018*	0,069 *0.0028*	0,063 *0.0035*	0,11 *0.0045*	0,14 *0.0055*	0,18 *0.0069*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,016 *0.00063*	0,025 *0.001*	0,033 *0.0013*	0,043 *0.0016*	0,05 *0.002*	0,069 *0.0028*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	30 (20 — 40) *100 (65 — 130)*

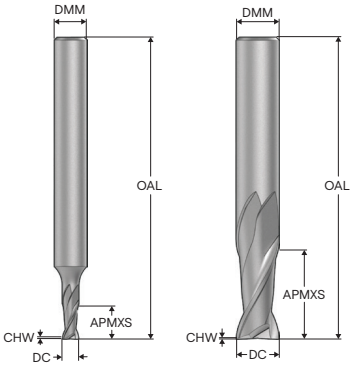
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

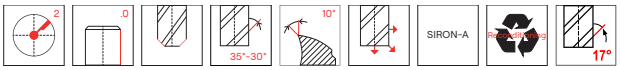
JSE512

Uz general – Universale – Pătrat – 2 Caneluri – Cilindrică – şanfren





—Toleranţe:
—DMM=h5
—DC=e8
—Reascuţire posibilă dacă DC este ≥ Ø10



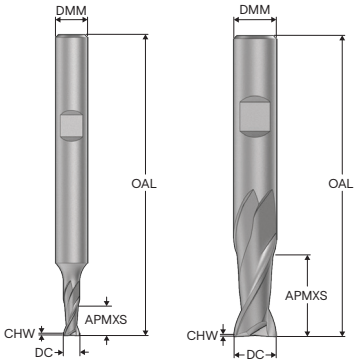
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	Cylindrical	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	Cylindrical	■
JSE512030D2C.0Z2	SIRA	10052987	2	D	3,0	3,0	6,0	50,0	0,03	2	Cylindrical	■
JSE512030F2C.0Z2	SIRA	10052991	2	F	3,0	6,0	6,0	57,0	0,03	2	Cylindrical	■
JSE512040D2C.0Z2	SIRA	10052988	2	D	4,0	4,0	8,0	50,0	0,04	2	Cylindrical	■
JSE512040F2C.0Z2	SIRA	10052992	2	F	4,0	6,0	8,0	57,0	0,04	2	Cylindrical	■
JSE512050D2C.0Z2	SIRA	10052989	2	D	5,0	5,0	10,0	50,0	0,05	2	Cylindrical	■
JSE512060D2C.0Z2	SIRA	10052993	2	D	6,0	6,0	12,0	57,0	0,06	2	Cylindrical	■
JSE512080D2C.0Z2	SIRA	10052994	2	D	8,0	8,0	16,0	63,0	0,08	2	Cylindrical	■
JSE512100D2C.0Z2	SIRA	10052995	2	D	10,0	10,0	20,0	72,0	0,1	2	Cylindrical	■
JSE512120D2C.0Z2	SIRA	10052996	2	D	12,0	12,0	24,0	83,0	0,12	2	Cylindrical	■

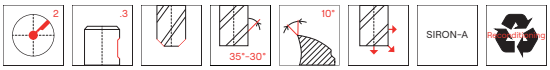
■ **Stoc standard.**

JSE512

Uz general – Universale – Pătrat – 2 Caneluri – Weldon – şanfren







—Toleranţe:
—DMM=h5
—DC=e8
—Reascuţire posibilă dacă DC este ≥ Ø10

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	Weldon	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	Weldon	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	Weldon	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	Weldon	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	Weldon	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	Weldon	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JSE512 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P2	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P3	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P4	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P5	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P6	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P7	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P8	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P11	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
P12	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M1	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M2	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M3	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M4	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M5	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
K1	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K2	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K3	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K4	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K5	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K7	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	500 (380 — 630) *1650 (1300 — 2000)*
N11	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	365 (250 — 480) *1200 (830 — 1500)*
S11	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S12	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S13	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JSE512 Frezare de canal

SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P3	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P5	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P6	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P7	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K2	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K3	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K4	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K5	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K6	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K7	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
N1	E/M/A	0.40 *0,40*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	400 (300 — 500) *1300 (990 — 1600)*
N11	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	300 (200 — 390) *980 (660 — 1200)*
S11	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*

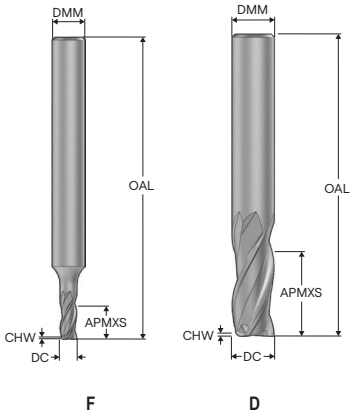
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

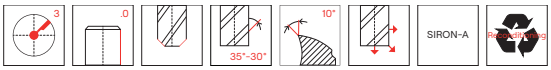
JSE513

Uz general – Universale – Pătrat – 3 Caneluri – Cilindrică – şanfren





—Toleranţe:
—DMM=h5
—DC=e8
—Reascuţire posibilă dacă DC este ≥ Ø10



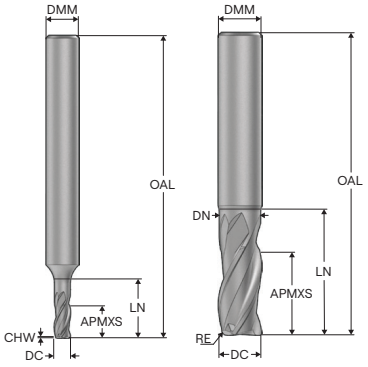
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	Cylindrical	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	Cylindrical	■
JSE513030D2C.0Z3	SIRA	10052998	2	D	3,0	3,0	6,0	50,0	0,03	3	Cylindrical	■
JSE513030F2C.0Z3	SIRA	10053002	2	F	3,0	6,0	6,0	57,0	0,03	3	Cylindrical	■
JSE513040D2C.0Z3	SIRA	10052999	2	D	4,0	4,0	8,0	50,0	0,04	3	Cylindrical	■
JSE513040F2C.0Z3	SIRA	10053003	2	F	4,0	6,0	8,0	57,0	0,04	3	Cylindrical	■
JSE513050F2C.0Z3	SIRA	10053004	2	F	5,0	6,0	10,0	57,0	0,05	3	Cylindrical	■
JSE513060D2C.0Z3	SIRA	10053005	2	D	6,0	6,0	12,0	57,0	0,06	3	Cylindrical	■
JSE513070F2C.0Z3	SIRA	10053006	2	F	7,0	8,0	14,0	63,0	0,07	3	Cylindrical	■
JSE513080D2C.0Z3	SIRA	10053007	2	D	8,0	8,0	16,0	63,0	0,08	3	Cylindrical	■
JSE513090F2C.0Z3	SIRA	10053008	2	F	9,0	10,0	18,0	72,0	0,09	3	Cylindrical	■
JSE513100D2C.0Z3	SIRA	10053009	2	D	10,0	10,0	20,0	72,0	0,1	3	Cylindrical	■
JSE513110F2C.0Z3	SIRA	10053010	2	F	11,0	12,0	22,0	83,0	0,11	3	Cylindrical	■
JSE513120D2C.0Z3	SIRA	10053011	2	D	12,0	12,0	24,0	83,0	0,12	3	Cylindrical	■
JSE513140D2C.0Z3	SIRA	10053012	2	D	14,0	14,0	28,0	80,0	0,14	3	Cylindrical	■
JSE513160D2C.0Z3	SIRA	10053013	2	D	16,0	16,0	32,0	92,0	0,16	3	Cylindrical	■
JSE513180D2C.0Z3	SIRA	10053014	2	D	18,0	18,0	35,0	100,0	0,18	3	Cylindrical	■
JSE513200D2C.0Z3	SIRA	10053015	2	D	20,0	20,0	35,0	104,0	0,2	3	Cylindrical	■
JSE513030F3C.0Z3	SIRA	10053038	3	F	3,0	6,0	10,0	57,0	0,03	3	Cylindrical	■
JSE513040F3C.0Z3	SIRA	10053039	3	F	4,0	6,0	14,0	57,0	0,04	3	Cylindrical	■
JSE513050F3C.0Z3	SIRA	10053040	3	F	5,0	6,0	18,0	57,0	0,05	3	Cylindrical	■
JSE513060D3C.0Z3	SIRA	10053046	3	D	6,0	6,0	20,0	63,0	0,06	3	Cylindrical	■
JSE513080D3C.0Z3	SIRA	10053047	3	D	8,0	8,0	28,0	80,0	0,08	3	Cylindrical	■
JSE513100D3C.0Z3	SIRA	10053048	3	D	10,0	10,0	35,0	89,0	0,1	3	Cylindrical	■
JSE513120D3C.0Z3	SIRA	10053049	3	D	12,0	12,0	42,0	100,0	0,12	3	Cylindrical	■
JSE513160D3C.0Z3	SIRA	10053050	3	D	16,0	16,0	50,0	115,0	0,16	3	Cylindrical	■
JSE513200D3C.0Z3	SIRA	10053052	3	D	20,0	20,0	60,0	125,0	0,2	3	Cylindrical	■
JSE513030F4C.0Z3	SIRA	10201454	4	F	3,0	6,0	15,0	57,0	0,03	3	Cylindrical	■
JSE513040F4C.0Z3	SIRA	10201455	4	F	4,0	6,0	20,0	63,0	0,04	3	Cylindrical	■
JSE513050F4C.0Z3	SIRA	10201456	4	F	5,0	6,0	25,0	75,0	0,05	3	Cylindrical	■
JSE513060D4C.0Z3	SIRA	10201457	4	D	6,0	6,0	30,0	75,0	0,06	3	Cylindrical	■
JSE513080D4C.0Z3	SIRA	10201458	4	D	8,0	8,0	40,0	87,0	0,08	3	Cylindrical	■
JSE513100D4C.0Z3	SIRA	10201459	4	D	10,0	10,0	50,0	104,0	0,1	3	Cylindrical	■
JSE513120D4C.0Z3	SIRA	10201460	4	D	12,0	12,0	60,0	125,0	0,12	3	Cylindrical	■
JSE513160D4C.0Z3	SIRA	10201461	4	D	16,0	16,0	80,0	150,0	0,16	3	Cylindrical	■
JSE513200D4C.0Z3	SIRA	10201462	4	D	20,0	20,0	100,0	170,0	0,2	3	Cylindrical	■

■ **Stoc standard.**

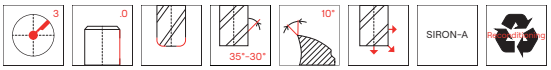
JSE513

Uz general – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





G E



– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,05 mm
– Reascuţire posibilă dacă DC este ≥ Ø10

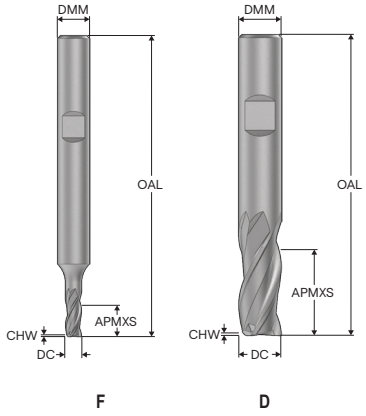
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	Cylindrical	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	Cylindrical	■
JSE513050G2R050.0Z3	SIRA	10053025	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	Cylindrical	■
JSE513060E2R050.0Z3	SIRA	10053026	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	Cylindrical	■
JSE513060E2R100.0Z3	SIRA	10053032	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	Cylindrical	■
JSE513080E2R050.0Z3	SIRA	10053027	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Cylindrical	■
JSE513080E2R100.0Z3	SIRA	10053033	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Cylindrical	■
JSE513100E2R050.0Z3	SIRA	10053028	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	Cylindrical	■
JSE513100E2R100.0Z3	SIRA	10053034	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	Cylindrical	■
JSE513120E2R050.0Z3	SIRA	10053029	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	Cylindrical	■
JSE513120E2R100.0Z3	SIRA	10053035	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	Cylindrical	■
JSE513160E2R050.0Z3	SIRA	10053030	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	Cylindrical	■
JSE513200E2R050.0Z3	SIRA	10053031	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	Cylindrical	■

■ **Stoc standard.**

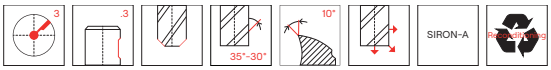
JSE513

Uz general – Universale – Pătrat – 3 Caneluri – Weldon – șanfren





—Toleranțe:
—DMM=h5
—DC=e8
—Reascuțire posibilă dacă DC este ≥ Ø10



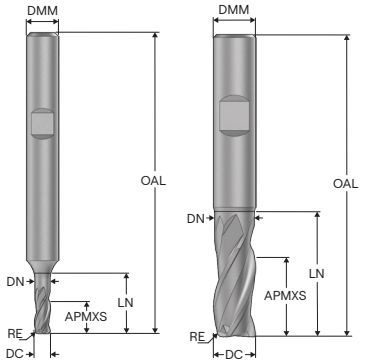
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	Weldon	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	Weldon	■
JSE513030F2C.3Z3	SIRA	10053122	2	F	3,0	6,0	6,0	57,0	0,03	3	Weldon	■
JSE513040F2C.3Z3	SIRA	10053123	2	F	4,0	6,0	8,0	57,0	0,04	3	Weldon	■
JSE513050F2C.3Z3	SIRA	10053124	2	F	5,0	6,0	10,0	57,0	0,05	3	Weldon	■
JSE513060D2C.3Z3	SIRA	10053125	2	D	6,0	6,0	12,0	57,0	0,06	3	Weldon	■
JSE513070F2C.3Z3	SIRA	10053126	2	F	7,0	8,0	14,0	63,0	0,07	3	Weldon	■
JSE513080D2C.3Z3	SIRA	10053127	2	D	8,0	8,0	16,0	63,0	0,08	3	Weldon	■
JSE513090F2C.3Z3	SIRA	10053128	2	F	9,0	10,0	18,0	72,0	0,09	3	Weldon	■
JSE513100D2C.3Z3	SIRA	10053129	2	D	10,0	10,0	20,0	72,0	0,1	3	Weldon	■
JSE513110F2C.3Z3	SIRA	10053130	2	F	11,0	12,0	22,0	83,0	0,11	3	Weldon	■
JSE513120D2C.3Z3	SIRA	10053131	2	D	12,0	12,0	24,0	83,0	0,12	3	Weldon	■
JSE513140D2C.3Z3	SIRA	10053132	2	D	14,0	14,0	28,0	80,0	0,14	3	Weldon	■
JSE513160D2C.3Z3	SIRA	10053133	2	D	16,0	16,0	32,0	92,0	0,16	3	Weldon	■
JSE513180D2C.3Z3	SIRA	10053258	2	D	18,0	18,0	35,0	100,0	0,18	3	Weldon	■
JSE513200D2C.3Z3	SIRA	10053259	2	D	20,0	20,0	35,0	104,0	0,2	3	Weldon	■
JSE513030F3C.3Z3	SIRA	10053275	3	F	3,0	6,0	10,0	57,0	0,03	3	Weldon	■
JSE513040F3C.3Z3	SIRA	10053276	3	F	4,0	6,0	14,0	57,0	0,04	3	Weldon	■
JSE513050F3C.3Z3	SIRA	10053277	3	F	5,0	6,0	18,0	57,0	0,05	3	Weldon	■
JSE513060D3C.3Z3	SIRA	10053283	3	D	6,0	6,0	20,0	63,0	0,06	3	Weldon	■
JSE513080D3C.3Z3	SIRA	10053284	3	D	8,0	8,0	28,0	80,0	0,08	3	Weldon	■
JSE513100D3C.3Z3	SIRA	10053285	3	D	10,0	10,0	35,0	89,0	0,1	3	Weldon	■
JSE513120D3C.3Z3	SIRA	10053286	3	D	12,0	12,0	42,0	100,0	0,12	3	Weldon	■
JSE513160D3C.3Z3	SIRA	10053287	3	D	16,0	16,0	50,0	115,0	0,16	3	Weldon	■
JSE513200D3C.3Z3	SIRA	10053288	3	D	20,0	20,0	60,0	125,0	0,2	3	Weldon	■
JSE513030F4C.3Z3	SIRA	10201463	4	F	3,0	6,0	15,0	57,0	0,03	3	Weldon	□
JSE513040F4C.3Z3	SIRA	10201464	4	F	4,0	6,0	20,0	63,0	0,04	3	Weldon	□
JSE513050F4C.3Z3	SIRA	10201465	4	F	5,0	6,0	25,0	75,0	0,05	3	Weldon	□
JSE513060D4C.3Z3	SIRA	10201466	4	D	6,0	6,0	30,0	75,0	0,06	3	Weldon	□
JSE513080D4C.3Z3	SIRA	10201467	4	D	8,0	8,0	40,0	87,0	0,08	3	Weldon	□
JSE513100D4C.3Z3	SIRA	10201468	4	D	10,0	10,0	50,0	104,0	0,1	3	Weldon	□
JSE513120D4C.3Z3	SIRA	10201469	4	D	12,0	12,0	60,0	125,0	0,12	3	Weldon	□
JSE513160D4C.3Z3	SIRA	10201470	4	D	16,0	16,0	80,0	150,0	0,16	3	Weldon	□
JSE513200D4C.3Z3	SIRA	10201471	4	D	20,0	20,0	100,0	170,0	0,2	3	Weldon	□

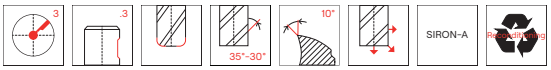
■ **Stoc standard.**

JSE513

Uz general – Universale – Pătrat – 3 Caneluri – Weldon – Rază la vârf







—Toleranţe:
—DMM=h5
—DC=e8
—RE= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø10

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JSE513030G2R050.3Z3	SIRA	10053260	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	Weldon	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	Weldon	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	Weldon	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	Weldon	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	Weldon	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	Weldon	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	Weldon	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	Weldon	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	Weldon	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	Weldon	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – JSE513 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P2	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P3	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P4	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P5	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P6	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P7	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P8	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P11	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
P12	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (64 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (210 — 390)*
M1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M2	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M3	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M4	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M5	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
K1	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K2	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K3	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K4	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K5	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K6	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K7	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
N1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	510 (390 — 630)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1675 (1300 — 2000)*
N11	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	385 (260 — 510)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1275 (860 — 1600)*
S11	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S12	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S13	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JSE513 Frezare de canal

SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P2	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P3	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P4	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P5	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P6	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P7	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P8	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P11	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (51 — 100)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
P12	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M1	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M2	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M3	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M4	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M5	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
K1	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K2	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K3	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K4	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K5	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K6	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K7	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
N1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	400 (310 — 500)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*1300 (1100 — 1600)*
N11	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	300 (200 — 400)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*980 (660 — 1300)*
S11	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S12	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S13	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*

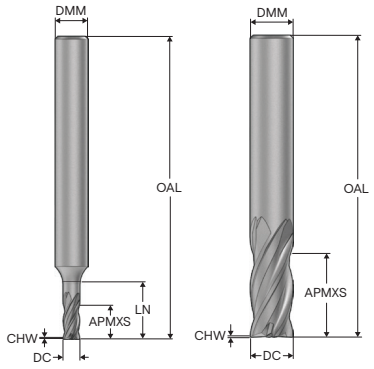
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

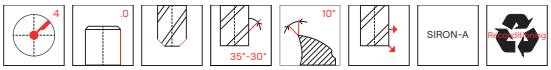
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – şanfren







—Toleranţe:
—DMM=h5
—DC=e8
—Reascuţire posibilă dacă DC este ≥ Ø10

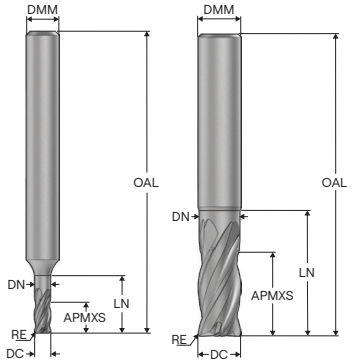
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	Cylindrical	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	Cylindrical	■
JSE514030D2C.0Z4	SIRA	10053054	2	D	3,0	3,0	6,0	50,0	0,03	4	Cylindrical	■
JSE514030F2C.0Z4	SIRA	10053058	2	F	3,0	6,0	6,0	57,0	0,03	4	Cylindrical	■
JSE514040D2C.0Z4	SIRA	10053055	2	D	4,0	4,0	8,0	50,0	0,04	4	Cylindrical	■
JSE514040F2C.0Z4	SIRA	10053059	2	F	4,0	6,0	8,0	57,0	0,04	4	Cylindrical	■
JSE514050D2C.0Z4	SIRA	10053056	2	D	5,0	5,0	10,0	50,0	0,05	4	Cylindrical	■
JSE514050F2C.0Z4	SIRA	10053060	2	F	5,0	6,0	10,0	57,0	0,05	4	Cylindrical	■
JSE514060D2C.0Z4	SIRA	10053061	2	D	6,0	6,0	12,0	57,0	0,06	4	Cylindrical	■
JSE514080D2C.0Z4	SIRA	10053062	2	D	8,0	8,0	16,0	63,0	0,08	4	Cylindrical	■
JSE514100D2C.0Z4	SIRA	10053063	2	D	10,0	10,0	20,0	72,0	0,1	4	Cylindrical	■
JSE514120D2C.0Z4	SIRA	10053064	2	D	12,0	12,0	24,0	83,0	0,12	4	Cylindrical	■
JSE514160D2C.0Z4	SIRA	10053067	2	D	16,0	16,0	32,0	92,0	0,16	4	Cylindrical	■
JSE514180D2C.0Z4	SIRA	10053068	2	D	18,0	18,0	35,0	100,0	0,18	4	Cylindrical	■
JSE514200D2C.0Z4	SIRA	10053069	2	D	20,0	20,0	35,0	104,0	0,2	4	Cylindrical	■
JSE514250D2C.0Z4	SIRA	10053070	2	D	25,0	25,0	40,0	125,0	0,25	4	Cylindrical	■
JSE514030F3C.0Z4	SIRA	10053090	3	F	3,0	6,0	10,0	57,0	0,03	4	Cylindrical	■
JSE514040F3C.0Z4	SIRA	10053091	3	F	4,0	6,0	14,0	57,0	0,04	4	Cylindrical	■
JSE514050F3C.0Z4	SIRA	10053092	3	F	5,0	6,0	18,0	57,0	0,05	4	Cylindrical	■
JSE514060D3C.0Z4	SIRA	10053093	3	D	6,0	6,0	20,0	63,0	0,06	4	Cylindrical	■
JSE514080D3C.0Z4	SIRA	10053094	3	D	8,0	8,0	28,0	80,0	0,08	4	Cylindrical	■
JSE514100D3C.0Z4	SIRA	10053095	3	D	10,0	10,0	35,0	89,0	0,1	4	Cylindrical	■
JSE514120D3C.0Z4	SIRA	10053096	3	D	12,0	12,0	42,0	100,0	0,12	4	Cylindrical	■
JSE514160D3C.0Z4	SIRA	10053097	3	D	16,0	16,0	50,0	115,0	0,16	4	Cylindrical	■
JSE514200D3C.0Z4	SIRA	10053098	3	D	20,0	20,0	60,0	125,0	0,2	4	Cylindrical	■
JSE514030F4C.0Z4	SIRA	10201472	4	F	3,0	6,0	15,0	57,0	0,03	4	Cylindrical	■
JSE514040F4C.0Z4	SIRA	10201473	4	F	4,0	6,0	20,0	63,0	0,04	4	Cylindrical	■
JSE514050F4C.0Z4	SIRA	10201474	4	F	5,0	6,0	25,0	75,0	0,05	4	Cylindrical	■
JSE514060D4C.0Z4	SIRA	10201475	4	D	6,0	6,0	30,0	75,0	0,06	4	Cylindrical	■
JSE514080D4C.0Z4	SIRA	10201476	4	D	8,0	8,0	40,0	87,0	0,08	4	Cylindrical	■
JSE514100D4C.0Z4	SIRA	10201477	4	D	10,0	10,0	50,0	104,0	0,1	4	Cylindrical	■
JSE514120D4C.0Z4	SIRA	10201478	4	D	12,0	12,0	60,0	125,0	0,12	4	Cylindrical	■
JSE514160D4C.0Z4	SIRA	10201479	4	D	16,0	16,0	80,0	150,0	0,16	4	Cylindrical	■
JSE514200D4C.0Z4	SIRA	10201480	4	D	20,0	20,0	100,0	170,0	0,2	4	Cylindrical	■

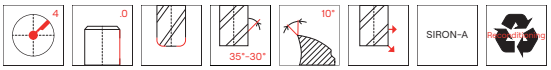
■ **Stoc standard.**

JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf







- Toleranţe:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Reascuţire posibilă dacă DC este ≥ Ø10

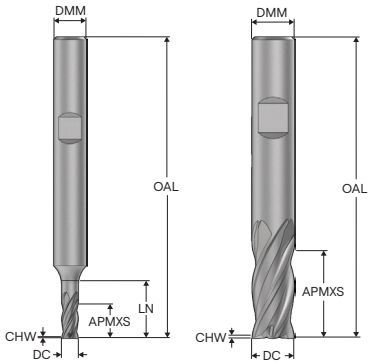
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Cylindrical	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	Cylindrical	■
JSE514050G2R050.0Z4	SIRA	10053073	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	Cylindrical	■
JSE514060E2R050.0Z4	SIRA	10053074	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Cylindrical	■
JSE514060E2R100.0Z4	SIRA	10053081	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Cylindrical	■
JSE514080E2R050.0Z4	SIRA	10053075	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Cylindrical	■
JSE514080E2R100.0Z4	SIRA	10053082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Cylindrical	■
JSE514100E2R050.0Z4	SIRA	10053076	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Cylindrical	■
JSE514100E2R100.0Z4	SIRA	10053083	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Cylindrical	■
JSE514120E2R050.0Z4	SIRA	10053077	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Cylindrical	■
JSE514120E2R100.0Z4	SIRA	10053084	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Cylindrical	■
JSE514160E2R050.0Z4	SIRA	10053078	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Cylindrical	■
JSE514160E2R100.0Z4	SIRA	10053087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Cylindrical	■
JSE514200E2R050.0Z4	SIRA	10053079	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	Cylindrical	■
JSE514200E2R100.0Z4	SIRA	10053088	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	Cylindrical	■
JSE514250E2R050.0Z4	SIRA	10053080	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	Cylindrical	■

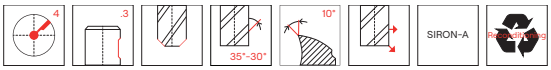
■ **Stoc standard.**

JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Weldon – șanfren







—Toleranțe:
—DMM=h5
—DC=e8
—Reascuțire posibilă dacă DC este ≥ Ø10

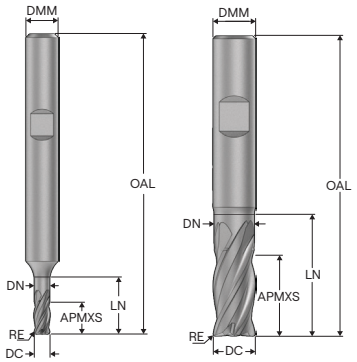
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	Weldon	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	Weldon	■
JSE514040F2C.3Z4	SIRA	10053291	2	F	4,0	6,0	8,0	57,0	0,04	4	Weldon	■
JSE514050F2C.3Z4	SIRA	10053292	2	F	5,0	6,0	10,0	57,0	0,05	4	Weldon	■
JSE514060D2C.3Z4	SIRA	10053293	2	D	6,0	6,0	12,0	57,0	0,06	4	Weldon	■
JSE514080D2C.3Z4	SIRA	10053294	2	D	8,0	8,0	16,0	63,0	0,08	4	Weldon	■
JSE514100D2C.3Z4	SIRA	10053295	2	D	10,0	10,0	20,0	72,0	0,1	4	Weldon	■
JSE514120D2C.3Z4	SIRA	10053296	2	D	12,0	12,0	24,0	83,0	0,12	4	Weldon	■
JSE514160D2C.3Z4	SIRA	10053297	2	D	16,0	16,0	32,0	92,0	0,16	4	Weldon	■
JSE514180D2C.3Z4	SIRA	10053298	2	D	18,0	18,0	35,0	100,0	0,18	4	Weldon	■
JSE514200D2C.3Z4	SIRA	10053299	2	D	20,0	20,0	35,0	104,0	0,2	4	Weldon	■
JSE514250D2C.3Z4	SIRA	10053300	2	D	25,0	25,0	40,0	125,0	0,25	4	Weldon	■
JSE514030F3C.3Z4	SIRA	10053321	3	F	3,0	6,0	10,0	57,0	0,03	4	Weldon	■
JSE514040F3C.3Z4	SIRA	10053322	3	F	4,0	6,0	14,0	57,0	0,04	4	Weldon	■
JSE514050F3C.3Z4	SIRA	10053323	3	F	5,0	6,0	18,0	57,0	0,05	4	Weldon	■
JSE514060D3C.3Z4	SIRA	10053324	3	D	6,0	6,0	20,0	63,0	0,06	4	Weldon	■
JSE514080D3C.3Z4	SIRA	10053325	3	D	8,0	8,0	28,0	80,0	0,08	4	Weldon	■
JSE514100D3C.3Z4	SIRA	10053326	3	D	10,0	10,0	35,0	89,0	0,1	4	Weldon	■
JSE514120D3C.3Z4	SIRA	10053327	3	D	12,0	12,0	42,0	100,0	0,12	4	Weldon	■
JSE514160D3C.3Z4	SIRA	10053328	3	D	16,0	16,0	50,0	115,0	0,16	4	Weldon	■
JSE514200D3C.3Z4	SIRA	10053329	3	D	20,0	20,0	60,0	125,0	0,2	4	Weldon	■
JSE514030F4C.3Z4	SIRA	10201481	4	F	3,0	6,0	15,0	57,0	0,03	4	Weldon	□
JSE514040F4C.3Z4	SIRA	10201482	4	F	4,0	6,0	20,0	63,0	0,04	4	Weldon	□
JSE514050F4C.3Z4	SIRA	10201483	4	F	5,0	6,0	25,0	75,0	0,05	4	Weldon	□
JSE514060D4C.3Z4	SIRA	10201484	4	D	6,0	6,0	30,0	75,0	0,06	4	Weldon	□
JSE514080D4C.3Z4	SIRA	10201485	4	D	8,0	8,0	40,0	87,0	0,08	4	Weldon	□
JSE514100D4C.3Z4	SIRA	10201486	4	D	10,0	10,0	50,0	104,0	0,1	4	Weldon	□
JSE514120D4C.3Z4	SIRA	10201487	4	D	12,0	12,0	60,0	125,0	0,12	4	Weldon	□
JSE514160D4C.3Z4	SIRA	10201488	4	D	16,0	16,0	80,0	150,0	0,16	4	Weldon	□
JSE514200D4C.3Z4	SIRA	10201489	4	D	20,0	20,0	100,0	170,0	0,2	4	Weldon	□

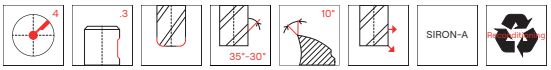
■ **Stoc standard.**

JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Weldon – Rază la vârf







- Toleranţe:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Reascuţire posibilă dacă DC este ≥ Ø10

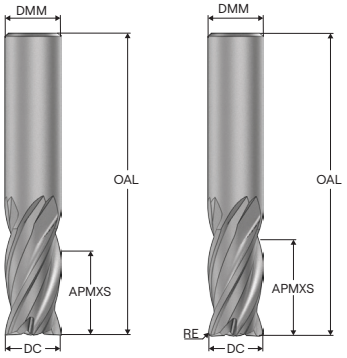
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Weldon	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	Weldon	■
JSE514050G2R050.3Z4	SIRA	10053306	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	Weldon	■
JSE514060E2R050.3Z4	SIRA	10053307	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Weldon	■
JSE514060E2R100.3Z4	SIRA	10053314	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Weldon	■
JSE514080E2R050.3Z4	SIRA	10053308	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Weldon	■
JSE514080E2R100.3Z4	SIRA	10053315	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Weldon	■
JSE514100E2R050.3Z4	SIRA	10053309	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Weldon	■
JSE514100E2R100.3Z4	SIRA	10053316	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Weldon	■
JSE514120E2R050.3Z4	SIRA	10053310	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Weldon	■
JSE514120E2R100.3Z4	SIRA	10053317	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Weldon	■
JSE514160E2R050.3Z4	SIRA	10053311	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Weldon	■
JSE514160E2R100.3Z4	SIRA	10053318	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Weldon	■
JSE514200E2R050.3Z4	SIRA	10053312	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	Weldon	■
JSE514200E2R100.3Z4	SIRA	10053319	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	Weldon	■
JSE514250E2R050.3Z4	SIRA	10053313	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	Weldon	■

■ **Stoc standard.**

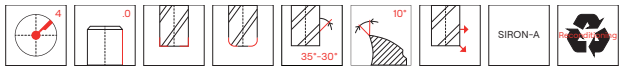
JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf sau ascuţit – Inci





—Toleranţe:
—DMM=h5
—DC=e8
—RE= ±.002 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.375



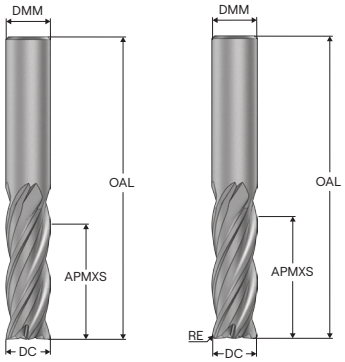
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
JSE514.250D1S.0Z4	SIRA	10201805	1	D	0.250	0.250	0.375	2.000	–	4	Cylindrical	■
JSE514.250D1R030.0Z4	SIRA	10201812	1	D	0.250	0.250	0.375	2.000	0.030	4	Cylindrical	■
JSE514.375D1S.0Z4	SIRA	10201806	1	D	0.375	0.375	0.500	2.000	–	4	Cylindrical	■
JSE514.375D1R030.0Z4	SIRA	10201813	1	D	0.375	0.375	0.500	2.000	0.030	4	Cylindrical	■
JSE514.500D1S.0Z4	SIRA	10201807	1	D	0.500	0.500	0.625	2.500	–	4	Cylindrical	■
JSE514.500D1R030.0Z4	SIRA	10201814	1	D	0.500	0.500	0.625	2.500	0.030	4	Cylindrical	■
JSE514.500D1R060.0Z4	SIRA	10201815	1	D	0.500	0.500	0.625	2.500	0.060	4	Cylindrical	■
JSE514.625D1S.0Z4	SIRA	10201808	1	D	0.625	0.625	0.750	3.000	–	4	Cylindrical	■
JSE514.625D1R030.0Z4	SIRA	10201816	1	D	0.625	0.625	0.750	3.000	0.030	4	Cylindrical	■
JSE514.625D1R060.0Z4	SIRA	10201817	1	D	0.625	0.625	0.750	3.000	0.060	4	Cylindrical	■
JSE514.750D1S.0Z4	SIRA	10201809	1	D	0.750	0.750	0.875	3.000	–	4	Cylindrical	■
JSE514.750D1R030.0Z4	SIRA	10201818	1	D	0.750	0.750	0.875	3.000	0.030	4	Cylindrical	■
JSE514.750D1R060.0Z4	SIRA	10201819	1	D	0.750	0.750	0.875	3.000	0.060	4	Cylindrical	■
JSE514.125D2S.0Z4	SIRA	10201803	2	D	0.125	0.125	0.250	1.500	–	4	Cylindrical	■
JSE514.125D2R015.0Z4	SIRA	10201810	2	D	0.125	0.125	0.250	1.500	0.015	4	Cylindrical	■
JSE514.188D2S.0Z4	SIRA	10201804	2	D	0.188	0.188	0.375	2.000	–	4	Cylindrical	■
JSE514.188D2R020.0Z4	SIRA	10201811	2	D	0.188	0.188	0.375	2.000	0.020	4	Cylindrical	■
JSE514.250D2S.0Z4	SIRA	10201822	2	D	0.250	0.250	0.500	2.000	–	4	Cylindrical	■
JSE514.250D2R030.0Z4	SIRA	10201829	2	D	0.250	0.250	0.500	2.000	0.030	4	Cylindrical	■
JSE514.375D2S.0Z4	SIRA	10201823	2	D	0.375	0.375	0.625	2.000	–	4	Cylindrical	■
JSE514.375D2R030.0Z4	SIRA	10201830	2	D	0.375	0.375	0.625	2.000	0.030	4	Cylindrical	■
JSE514.500D2S.0Z4	SIRA	10201824	2	D	0.500	0.500	1.000	3.000	–	4	Cylindrical	■
JSE514.500D2R030.0Z4	SIRA	10201831	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
JSE514.500D2R060.0Z4	SIRA	10201832	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
JSE514.625D2S.0Z4	SIRA	10201825	2	D	0.625	0.625	1.250	3.500	–	4	Cylindrical	■
JSE514.625D2R030.0Z4	SIRA	10201833	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
JSE514.625D2R060.0Z4	SIRA	10201834	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
JSE514.750D2S.0Z4	SIRA	10201826	2	D	0.750	0.750	1.500	4.000	–	4	Cylindrical	■
JSE514.750D2R030.0Z4	SIRA	10201835	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
JSE514.750D2R060.0Z4	SIRA	10201836	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■

■ **Stoc standard.**

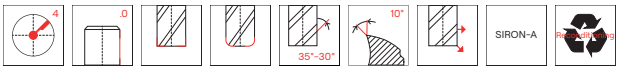
JSE514

Uz general – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf sau ascuţit – Inci





- Toleranţe:
- DMM=h5
- DC=e8
- RE= ±.002 Inci
- Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
JSE514.125D3S.0Z4	SIRA	10201820	3	D	0.125	0.125	0.500	1.500	–	4	Cylindrical	■
JSE514.125D3R015.0Z4	SIRA	10201827	3	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
JSE514.188D3S.0Z4	SIRA	10201821	3	D	0.188	0.188	0.625	2.000	–	4	Cylindrical	■
JSE514.188D3R020.0Z4	SIRA	10201828	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
JSE514.250D3S.0Z4	SIRA	10201837	3	D	0.250	0.250	0.750	2.500	–	4	Cylindrical	■
JSE514.250D3R030.0Z4	SIRA	10201842	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
JSE514.375D3S.0Z4	SIRA	10201838	3	D	0.375	0.375	1.000	2.500	–	4	Cylindrical	■
JSE514.375D3R030.0Z4	SIRA	10201843	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
JSE514.500D3S.0Z4	SIRA	10201839	3	D	0.500	0.500	2.000	4.000	–	4	Cylindrical	■
JSE514.500D3R030.0Z4	SIRA	10201844	3	D	0.500	0.500	2.000	4.000	0.030	4	Cylindrical	■
JSE514.500D3R060.0Z4	SIRA	10201845	3	D	0.500	0.500	2.000	4.000	0.060	4	Cylindrical	■
JSE514.625D3S.0Z4	SIRA	10201840	3	D	0.625	0.625	2.250	5.000	–	4	Cylindrical	■
JSE514.625D3R030.0Z4	SIRA	10201846	3	D	0.625	0.625	2.250	5.000	0.030	4	Cylindrical	■
JSE514.625D3R060.0Z4	SIRA	10201847	3	D	0.625	0.625	2.250	5.000	0.060	4	Cylindrical	■
JSE514.750D3S.0Z4	SIRA	10201841	3	D	0.750	0.750	2.250	5.000	–	4	Cylindrical	■
JSE514.750D3R030.0Z4	SIRA	10201848	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
JSE514.750D3R060.0Z4	SIRA	10201849	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JSE514 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	160 (67 — 190) *520 (220 — 620)*
P3	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P4	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P5	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P6	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P7	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P8	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P11	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
P12	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M2	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M3	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M4	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M5	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
K1	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K2	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K3	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K4	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K5	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K6	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K7	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
N1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S12	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S13	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JSE514 Frezare de canal

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P2	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P3	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P4	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P5	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P6	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P7	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P8	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P11	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (51 — 100)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
P12	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M2	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M3	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M4	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M5	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
K1	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K2	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K3	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K4	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K5	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K6	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K7	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
N1	E/M/A	0.30	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	400 (300 — 500)
		0,30	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*1300 (990 — 1600)*
N11	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	300 (200 — 390)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*980 (660 — 1200)*
S11	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S12	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S13	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS514 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/8	3/16	1.4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,022 *0.00085*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	160 (67 — 200) *520 (220 — 650)*
P3	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P4	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P5	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P6	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P7	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P8	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P11	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
P12	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M2	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M3	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M4	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M5	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
K1	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K2	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K3	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K4	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K5	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K6	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K7	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
N1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S12	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S13	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS514 Frezare de canal – Inci

SMG		a_p/DC	f_z							v_c
			1/8	3/16	1/4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P3	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P5	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P6	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P7	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P11	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M1	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M2	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M3	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M4	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M5	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
K1	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K2	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K3	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K4	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K5	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K6	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K7	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
N1	E/M/A	0,30 *0.30*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	400 (310 — 500) *1300 (1100 — 1600)*
N11	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	300 (210 — 400) *980 (690 — 1300)*
S11	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S12	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S13	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*

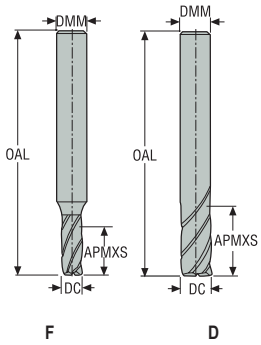
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Ascuţit





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6



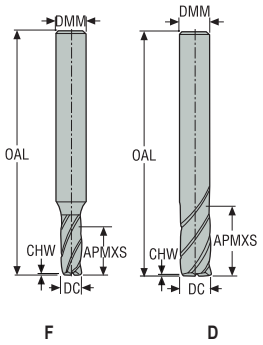
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	Cylindrical	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	Cylindrical	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	Cylindrical	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	6,0	12,0	55,0	3	Cylindrical	■
553060SZ3.0-SIRON-A	02733914	2	D	6,0	6,0	14,0	55,0	3	Cylindrical	■
553080SZ3.0-SIRON-A	02733918	2	D	8,0	8,0	18,0	60,0	3	Cylindrical	■
553100SZ3.0-SIRON-A	02733922	2	D	10,0	10,0	22,0	70,0	3	Cylindrical	■

■ **Stoc standard.**

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Şanfren





- Toleranţe:
- DMM= h5
- DC= e7
- Reascuţire posibilă dacă DC este ≥ Ø6



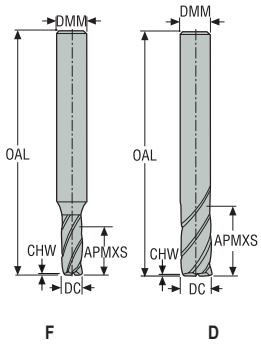
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	Cylindrical	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	Cylindrical	■
JS553040F1C.0Z3-SIRA	10041468	1	F	4,0	6,0	6,0	40,0	0,045	3	Cylindrical	■
JS553045F1C.0Z3-SIRA	10041469	1	F	4,5	6,0	6,0	40,0	0,045	3	Cylindrical	■
JS553050F1C.0Z3-SIRA	10041470	1	F	5,0	6,0	7,0	40,0	0,055	3	Cylindrical	■
JS553055F1C.0Z3-SIRA	10041472	1	F	5,5	6,0	8,0	40,0	0,055	3	Cylindrical	■
JS553060D1C.0Z3-SIRA	10041473	1	D	6,0	6,0	8,0	40,0	0,075	3	Cylindrical	■
JS553080D1C.0Z3-SIRA	10041474	1	D	8,0	8,0	11,0	50,0	0,1	3	Cylindrical	■
JS553100D1C.0Z3-SIRA	10041475	1	D	10,0	10,0	13,0	57,0	0,125	3	Cylindrical	■
JS553120D1C.0Z3-SIRA	10041476	1	D	12,0	12,0	15,0	65,0	0,15	3	Cylindrical	■
553020Z3.0-SIRON-A	02679241	2	F	2,0	6,0	5,0	50,0	0,025	3	Cylindrical	■
553025Z3.0-SIRON-A	02679352	2	F	2,5	6,0	7,0	50,0	0,025	3	Cylindrical	■
553030Z3.0-SIRON-A	02679353	2	F	3,0	6,0	7,0	50,0	0,035	3	Cylindrical	■
553035Z3.0-SIRON-A	02679359	2	F	3,5	6,0	9,0	55,0	0,035	3	Cylindrical	■
553040Z3.0-SIRON-A	02679360	2	F	4,0	6,0	10,0	55,0	0,045	3	Cylindrical	■
553045Z3.0-SIRON-A	02679361	2	F	4,5	6,0	12,0	55,0	0,045	3	Cylindrical	■
553050Z3.0-SIRON-A	02679364	2	F	5,0	6,0	12,0	55,0	0,055	3	Cylindrical	■
553055Z3.0-SIRON-A	02679365	2	F	5,5	6,0	14,0	55,0	0,055	3	Cylindrical	■
553060Z3.0-SIRON-A	02679368	2	D	6,0	6,0	14,0	55,0	0,075	3	Cylindrical	■
553075Z3.0-SIRON-A	02733916	2	F	7,5	8,0	18,0	60,0	0,1	3	Cylindrical	■
553080Z3.0-SIRON-A	02679371	2	D	8,0	8,0	18,0	60,0	0,1	3	Cylindrical	■
553095Z3.0-SIRON-A	02733920	2	F	9,5	10,0	22,0	70,0	0,125	3	Cylindrical	■
553100Z3.0-SIRON-A	02679374	2	D	10,0	10,0	22,0	70,0	0,125	3	Cylindrical	■
553115Z3.0-SIRON-A	02733925	2	F	11,5	12,0	26,0	80,0	0,15	3	Cylindrical	■
553120Z3.0-SIRON-A	02679380	2	D	12,0	12,0	26,0	80,0	0,15	3	Cylindrical	■
553140Z3.0-SIRON-A	02733932	2	D	14,0	14,0	30,0	85,0	0,175	3	Cylindrical	■
553160Z3.0-SIRON-A	02679384	2	D	16,0	16,0	34,0	90,0	0,2	3	Cylindrical	■
553200Z3.0-SIRON-A	02679389	2	D	20,0	20,0	42,0	110,0	0,25	3	Cylindrical	■
553250Z3.0-SIRON-A	02679393	2	D	25,0	25,0	52,0	125,0	0,3	3	Cylindrical	■

■ **Stoc standard.**

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Şanfren





—Toleranţe:
—DMM= h5
—DC= e7
—Reascuţire posibilă dacă DC este ≥ Ø6



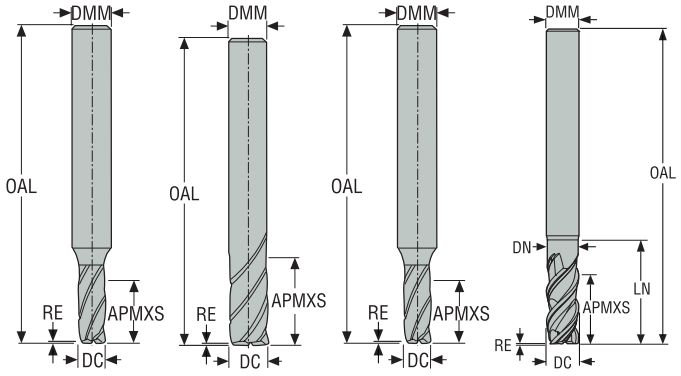
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	Cylindrical	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	Cylindrical	■
553L040Z3.0-SIRON-A	02733972	3	F	4,0	6,0	14,0	60,0	0,045	3	Cylindrical	■
553L050Z3.0-SIRON-A	02733974	3	F	5,0	6,0	18,0	60,0	0,055	3	Cylindrical	■
553L060Z3.0-SIRON-A	02733982	3	D	6,0	6,0	20,0	65,0	0,075	3	Cylindrical	■
553L080Z3.0-SIRON-A	02733986	3	D	8,0	8,0	28,0	70,0	0,1	3	Cylindrical	■
553L100Z3.0-SIRON-A	02733992	3	D	10,0	10,0	35,0	85,0	0,125	3	Cylindrical	■
553L120Z3.0-SIRON-A	02733994	3	D	12,0	12,0	40,0	95,0	0,15	3	Cylindrical	■
553L160Z3.0-SIRON-A	02733996	3	D	16,0	16,0	50,0	110,0	0,2	3	Cylindrical	■
553L200Z3.0-SIRON-A	02733998	3	D	20,0	20,0	60,0	125,0	0,25	3	Cylindrical	■
553L250Z3.0-SIRON-A	02734000	3	D	25,0	25,0	75,0	150,0	0,3	3	Cylindrical	■

■ **Stoc standard.**

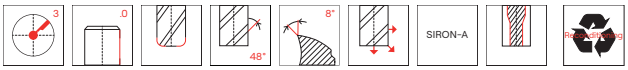
JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





F



- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

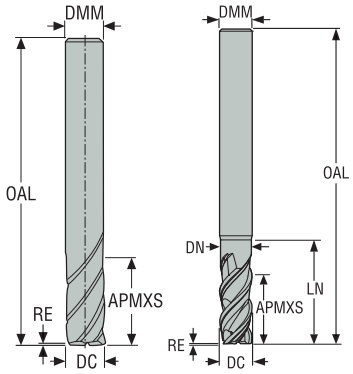
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS553020F1R020.0Z3-SIRA	10194458	1	F	2,0	6,0	3,0	40,0	–	–	0,2	3	Cylindrical	■
JS553030F1R020.0Z3-SIRA	10194459	1	F	3,0	6,0	4,0	40,0	–	–	0,2	3	Cylindrical	■
JS553040F1R020.0Z3-SIRA	10194460	1	F	4,0	6,0	6,0	40,0	–	–	0,2	3	Cylindrical	■
JS553050F1R020.0Z3-SIRA	10194461	1	F	5,0	6,0	7,0	40,0	–	–	0,2	3	Cylindrical	■
JS553060D1R020.0Z3-SIRA	10194462	1	D	6,0	6,0	8,0	40,0	–	–	0,2	3	Cylindrical	■
JS553060D1R050.0Z3-SIRA	10194463	1	D	6,0	6,0	8,0	40,0	–	–	0,5	3	Cylindrical	■
JS553080D1R050.0Z3-SIRA	10194464	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	Cylindrical	■
JS553100D1R050.0Z3-SIRA	10194465	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	Cylindrical	■
JS553100D1R100.0Z3-SIRA	10194466	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	Cylindrical	■
JS553120D1R050.0Z3-SIRA	10194467	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	Cylindrical	■
JS553120D1R100.0Z3-SIRA	10194468	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	Cylindrical	■
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	Cylindrical	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	–	–	0,15	3	Cylindrical	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	Cylindrical	■
553040R020Z3.0-SIRON-A	02733911	2	F	4,0	6,0	10,0	55,0	–	–	0,2	3	Cylindrical	■
JS553040G2R050.0Z3-SIRA	02881685	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	Cylindrical	■
553050R020Z3.0-SIRON-A	02687282	2	F	5,0	6,0	12,0	55,0	–	–	0,2	3	Cylindrical	■
JS553050G2R050.0Z3-SIRA	02881686	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	Cylindrical	■
553060R020Z3.0-SIRON-A	02679369	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	Cylindrical	■
JS553060E2R050.0Z3-SIRA	02881687	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	Cylindrical	■
JS553060E2R100.0Z3-SIRA	02881688	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	Cylindrical	■
553080R050Z3.0-SIRON-A	02679372	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	Cylindrical	■
553100R050Z3.0-SIRON-A	02679375	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	Cylindrical	■
553100R100Z3.0-SIRON-A	02679376	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	Cylindrical	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	Cylindrical	■
553100R250Z3.0-SIRON-A	02810365	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	Cylindrical	■
553100R310Z3.0-SIRON-A	02810366	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	Cylindrical	■
553120R050Z3.0-SIRON-A	02679381	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	Cylindrical	■
553120R100Z3.0-SIRON-A	02679382	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	Cylindrical	■
553120R200Z3.0-SIRON-A	02810367	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	Cylindrical	■
553120R250Z3.0-SIRON-A	02810368	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	Cylindrical	■
553120R310Z3.0-SIRON-A	02810369	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	Cylindrical	■

■ **Stoc standard.**

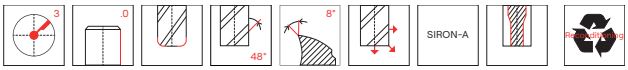
JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă



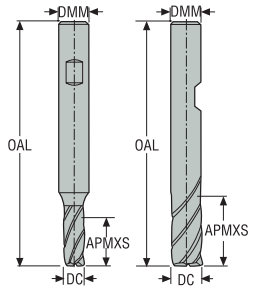
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Cylindrical	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	Cylindrical	■
553160R200Z3.0-SIRON-A	02810370	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	Cylindrical	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	Cylindrical	■
553160R310Z3.0-SIRON-A	02810372	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	Cylindrical	■
553160R400Z3.0-SIRON-A	02810373	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	Cylindrical	■
553200R050Z3.0-SIRON-A	02679390	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	Cylindrical	■
553200R100Z3.0-SIRON-A	02679391	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	Cylindrical	■
JS553200E2R200.0Z3-SIRA	02881689	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	Cylindrical	■
553250R050Z3.0-SIRON-A	02679395	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	Cylindrical	■
553250R100Z3.0-SIRON-A	02679396	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	Cylindrical	■

■ **Stoc standard.**

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Ascuţit





– Toleranţe:
– DMM=h5
– DC=e7
– Reascuţire posibilă dacă DC este ≥ Ø6



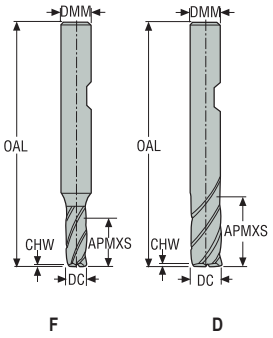
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	Weldon	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	Weldon	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0	6,0	10,0	55,0	3	Weldon	■
553050SZ3.0-SIRON-AW	02733945	2	F	5,0	6,0	12,0	55,0	3	Weldon	■
553060SZ3.0-SIRON-AW	02733946	2	D	6,0	6,0	14,0	55,0	3	Weldon	■
553080SZ3.0-SIRON-AW	02733950	2	D	8,0	8,0	18,0	60,0	3	Weldon	■
553100SZ3.0-SIRON-AW	02733952	2	D	10,0	10,0	22,0	70,0	3	Weldon	■

■ **Stoc standard.**

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Şanfren





—Toleranţe:
—DMM= h5
—DC= e7
—Reascuţire posibilă dacă DC este ≥ Ø6



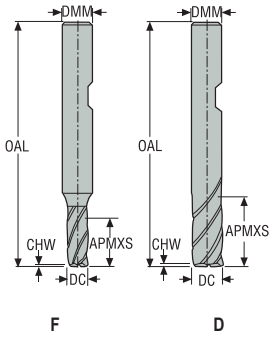
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	Weldon	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	Weldon	■
JS553040F1C.3Z3-SIRA	10041479	1	F	4,0	6,0	6,0	40,0	0,045	3	Weldon	■
JS553045F1C.3Z3-SIRA	10041480	1	F	4,5	6,0	6,0	40,0	0,045	3	Weldon	■
JS553050F1C.3Z3-SIRA	10041481	1	F	5,0	6,0	7,0	40,0	0,055	3	Weldon	■
JS553055F1C.3Z3-SIRA	10041482	1	F	5,5	6,0	8,0	40,0	0,055	3	Weldon	■
JS553060D1C.3Z3-SIRA	10041483	1	D	6,0	6,0	8,0	40,0	0,075	3	Weldon	■
JS553080D1C.3Z3-SIRA	10041484	1	D	8,0	8,0	11,0	50,0	0,1	3	Weldon	□
JS553100D1C.3Z3-SIRA	10041485	1	D	10,0	10,0	13,0	57,0	0,125	3	Weldon	□
JS553120D1C.3Z3-SIRA	10041486	1	D	12,0	12,0	15,0	65,0	0,15	3	Weldon	□
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	Weldon	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	Weldon	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	Weldon	■
553035Z3.0-SIRON-AW	02700357	2	F	3,5	6,0	9,0	55,0	0,035	3	Weldon	■
553040Z3.0-SIRON-AW	02700358	2	F	4,0	6,0	10,0	55,0	0,045	3	Weldon	■
553045Z3.0-SIRON-AW	02700359	2	F	4,5	6,0	12,0	55,0	0,045	3	Weldon	□
553050Z3.0-SIRON-AW	02700360	2	F	5,0	6,0	12,0	55,0	0,055	3	Weldon	■
553055Z3.0-SIRON-AW	02700361	2	F	5,5	6,0	14,0	55,0	0,055	3	Weldon	□
553060Z3.3-SIRON-A	02679367	2	D	6,0	6,0	14,0	55,0	0,075	3	Weldon	■
553075Z3.3-SIRON-A	02733915	2	F	7,5	8,0	18,0	60,0	0,1	3	Weldon	■
553080Z3.3-SIRON-A	02679370	2	D	8,0	8,0	18,0	60,0	0,1	3	Weldon	■
553095Z3.3-SIRON-A	02733919	2	F	9,5	10,0	22,0	70,0	0,125	3	Weldon	■
553100Z3.3-SIRON-A	02679373	2	D	10,0	10,0	22,0	70,0	0,125	3	Weldon	■
553115Z3.3-SIRON-A	02733923	2	F	11,5	12,0	26,0	80,0	0,15	3	Weldon	■
553120Z3.3-SIRON-A	02679379	2	D	12,0	12,0	26,0	80,0	0,15	3	Weldon	■
553140Z3.3-SIRON-A	02733929	2	D	14,0	14,0	30,0	85,0	0,175	3	Weldon	■
553160Z3.3-SIRON-A	02679383	2	D	16,0	16,0	34,0	90,0	0,2	3	Weldon	■
553200Z3.3-SIRON-A	02679388	2	D	20,0	20,0	42,0	110,0	0,25	3	Weldon	■
553250Z3.3-SIRON-A	02679392	2	D	25,0	25,0	52,0	125,0	0,3	3	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Şanfren





– Toleranţe:
– DMM= h5
– DC= e7
– Reascuţire posibilă dacă DC este ≥ Ø6



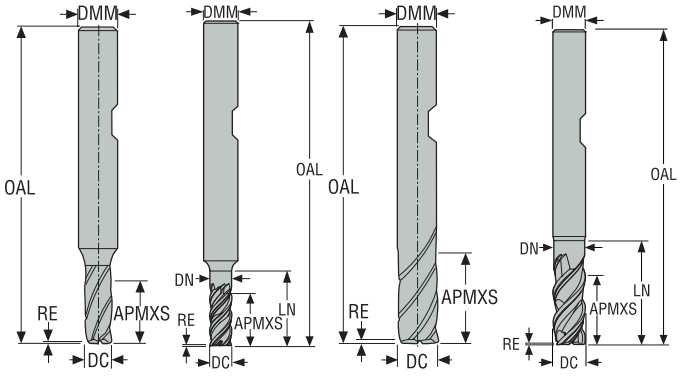
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	Weldon	■
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	Weldon	■
553L040Z3.0-SIRON-AW	02734007	3	F	4,0	6,0	14,0	60,0	0,045	3	Weldon	■
553L050Z3.0-SIRON-AW	02734008	3	F	5,0	6,0	18,0	60,0	0,055	3	Weldon	□
553L060Z3.3-SIRON-A	02733980	3	D	6,0	6,0	20,0	65,0	0,075	3	Weldon	■
553L080Z3.3-SIRON-A	02733984	3	D	8,0	8,0	28,0	70,0	0,1	3	Weldon	■
553L100Z3.3-SIRON-A	02733988	3	D	10,0	10,0	35,0	85,0	0,125	3	Weldon	■
553L120Z3.3-SIRON-A	02733993	3	D	12,0	12,0	40,0	95,0	0,15	3	Weldon	■
553L160Z3.3-SIRON-A	02733995	3	D	16,0	16,0	50,0	110,0	0,2	3	Weldon	■
553L200Z3.3-SIRON-A	02733997	3	D	20,0	20,0	60,0	125,0	0,25	3	Weldon	■
553L250Z3.3-SIRON-A	02733999	3	D	25,0	25,0	75,0	150,0	0,3	3	Weldon	■

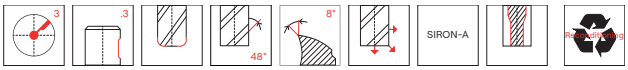
■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Rază la vârf







—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

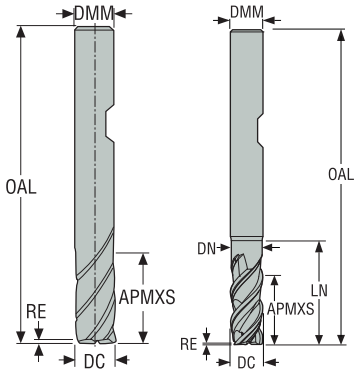
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS553080D1R050.3Z3-SIRA	10194469	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	Weldon	□
JS553100D1R050.3Z3-SIRA	10194470	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	Weldon	□
JS553100D1R100.3Z3-SIRA	10194471	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	Weldon	□
JS553120D1R050.3Z3-SIRA	10194472	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	Weldon	□
JS553120D1R100.3Z3-SIRA	10194474	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	Weldon	□
JS553020G2R050.3Z3-SIRA	02881690	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	Weldon	□
553030R015Z3.0-SIRON-AW	02733941	2	F	3,0	6,0	7,0	50,0	–	–	0,15	3	Weldon	□
JS553030G2R050.3Z3-SIRA	02881691	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	Weldon	■
553040R020Z3.0-SIRON-AW	02733944	2	F	4,0	6,0	10,0	55,0	–	–	0,2	3	Weldon	□
JS553040G2R050.3Z3-SIRA	02881692	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	Weldon	□
553050R020Z3.0-SIRON-AW	02703763	2	F	5,0	6,0	12,0	55,0	–	–	0,2	3	Weldon	□
JS553050G2R050.3Z3-SIRA	02881693	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	Weldon	□
553060R020Z3.0-SIRON-AW	02700364	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	Weldon	■
JS553060E2R050.3Z3-SIRA	02881694	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	Weldon	□
JS553060E2R100.3Z3-SIRA	02881695	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	Weldon	■
553080R050Z3.0-SIRON-AW	02700366	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	Weldon	■
553100R050Z3.0-SIRON-AW	02700369	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	Weldon	□
553100R100Z3.0-SIRON-AW	02700371	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	Weldon	□
553100R200Z3.3-SIRON-A	02810422	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	Weldon	□
553100R250Z3.3-SIRON-A	02810423	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	Weldon	□
553100R310Z3.3-SIRON-A	02810424	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	Weldon	□
553120R050Z3.0-SIRON-AW	02700373	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	Weldon	■
553120R100Z3.0-SIRON-AW	02700374	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	Weldon	□
553120R200Z3.3-SIRON-A	02810425	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	Weldon	□
553120R250Z3.3-SIRON-A	02810426	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	Weldon	□
553120R310Z3.3-SIRON-A	02810427	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

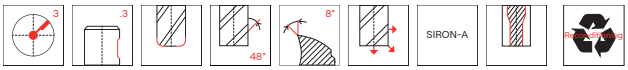
JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Rază la vârf





– Toleranţe:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Reascuţire posibilă



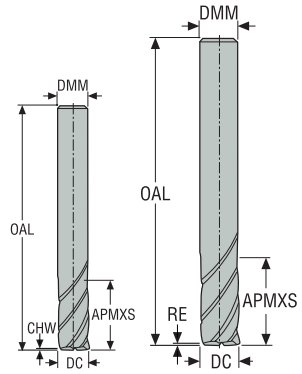
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Weldon	□
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	Weldon	□
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	Weldon	□
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	Weldon	□
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	Weldon	□
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	Weldon	□
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	Weldon	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	Weldon	□
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	Weldon	□
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	Weldon	□
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

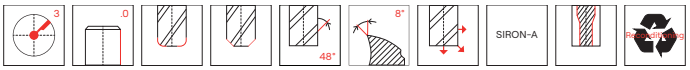
JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Cilindrică – Raza la colţ sau șanfrenul – Inci





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø.375



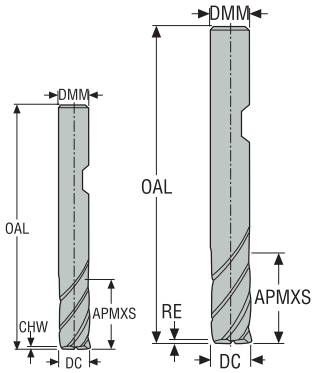
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci	inci			
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	Cylindrical	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	Cylindrical	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	0.250	0.500	2.500	0.003	–	3	Cylindrical	■
5530250R015Z3.0-SIRON-A	02712689	2	D	0.250	0.250	0.500	2.500	–	0.015	3	Cylindrical	■
5530312Z3.0-SIRON-A	02712690	2	D	0.313	0.313	0.625	2.500	0.004	–	3	Cylindrical	■
5530312R015Z3.0-SIRON-A	02712693	2	D	0.313	0.313	0.625	2.500	–	0.015	3	Cylindrical	■
5530375Z3.0-SIRON-A	02712694	2	D	0.375	0.375	0.750	3.000	0.005	–	3	Cylindrical	■
5530375R015Z3.0-SIRON-A	02712695	2	D	0.375	0.375	0.750	3.000	–	0.015	3	Cylindrical	■
5530375R030Z3.0-SIRON-A	02712696	2	D	0.375	0.375	0.750	3.000	–	0.030	3	Cylindrical	■
5530500Z3.0-SIRON-A	02712699	2	D	0.500	0.500	1.000	3.500	0.006	–	3	Cylindrical	■
5530500R015Z3.0-SIRON-A	02712701	2	D	0.500	0.500	1.000	3.500	–	0.015	3	Cylindrical	■
5530500R030Z3.0-SIRON-A	02712703	2	D	0.500	0.500	1.000	3.500	–	0.030	3	Cylindrical	■

■ **Stoc standard.**

JS553

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Weldon – Raza la colţ sau şanfrenul – Inci





—Toleranţe:
—DMM=h5
—DC=e7



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci	inci			
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	Weldon	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	Weldon	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – JS553 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS553 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS553 Frezare de canal

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	195 (170 — 220)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	190 (170 — 210)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	165 (140 — 180)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	155 (140 — 170)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	130 (120 — 140)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M1	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	95 (85 — 100)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*310 (280 — 320)*
M2	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M3	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.095	48 (39 — 58)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0038*	*155 (130 — 190)*
M4	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	36 (30 — 43)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*120 (99 — 140)*
M5	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	30 (25 — 36)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*100 (83 — 110)*
K1	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	145 (140 — 170)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*475 (460 — 550)*
K2	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	125 (120 — 150)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*410 (400 — 490)*
K3	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	110 (110 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*360 (370 — 390)*
K4	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	105 (96 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*345 (320 — 390)*
K5	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	135 (120 — 150)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	200 (180 — 230)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 750)*
K7	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	175 (150 — 190)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS553 Frezare de canal

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H11	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 98) *260 (220 — 320)*
H12	M/A/D	1.0 *1,0*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	490 (400 — 580) *1600 (1400 — 1900)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS553 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	195 (170 — 220) *640 (560 — 720)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS553 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	580 (470 — 690) *1900 (1600 — 2200)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS553 Frezare de canal – Inci

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 58) *155 (130 — 190)*
M4	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	36 (30 — 43) *120 (99 — 140)*
M5	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	145 (140 — 170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	125 (120 — 150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	110 (110 — 120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	105 (96 — 120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	200 (180 — 230) *660 (600 — 750)*
K7	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	175 (150 — 190) *570 (500 — 620)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS553 Frezare de canal – Inci

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H31	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	49 (39 — 58) *160 (130 — 190)*
TS1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	490 (400 — 580) *1600 (1400 — 1900)*

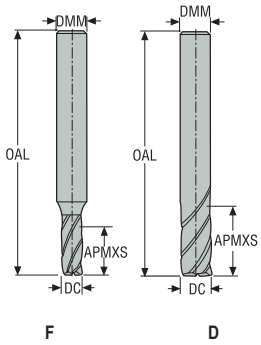
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

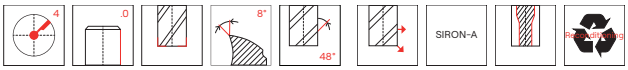
JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Ascuţit





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6



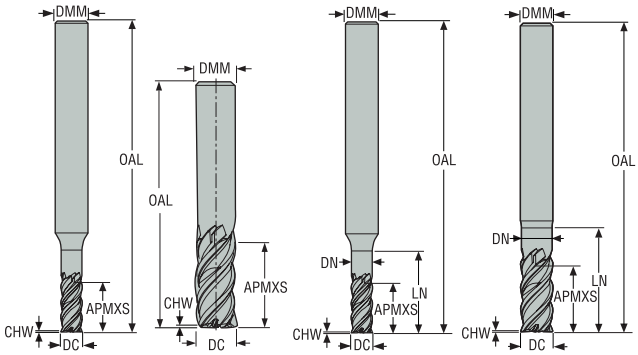
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	Cylindrical	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	Cylindrical	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	Cylindrical	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0	6,0	14,0	55,0	4	Cylindrical	■
554080SZ4.0-SIRON-A	02733815	2	D	8,0	8,0	18,0	60,0	4	Cylindrical	■
554100SZ4.0-SIRON-A	02733816	2	D	10,0	10,0	22,0	70,0	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Şanfren





– Toleranţe:
– DMM=h5
– DC=e7
– Reascuţire posibilă dacă DC este ≥ Ø6



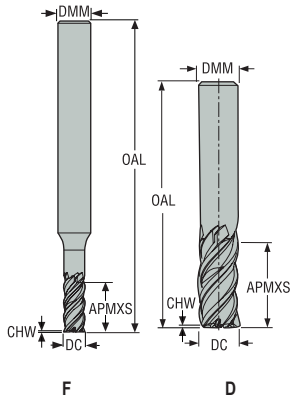
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030F1C.0Z4-SIRA	10194615	1	F	3,0	6,0	4,0	40,0	–	–	0,035	4	Cylindrical	■
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Cylindrical	■
JS554050F1C.0Z4-SIRA	10194616	1	F	5,0	6,0	7,0	40,0	–	–	0,055	4	Cylindrical	■
JS554060D1C.0Z4-SIRA	10041455	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	Cylindrical	■
JS554080D1C.0Z4-SIRA	10041456	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	Cylindrical	■
JS554100D1C.0Z4-SIRA	10041457	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	Cylindrical	■
JS554120D1C.0Z4-SIRA	10041458	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	Cylindrical	■
JS554160D1C.0Z4-SIRA	10041459	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	Cylindrical	■
554030Z4.0-SIRON-A	02733455	2	F	3,0	6,0	7,0	50,0	–	–	0,035	4	Cylindrical	■
JS554030G2C.0Z4-SIRA	03029956	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	Cylindrical	■
554040Z4.0-SIRON-A	02733459	2	F	4,0	6,0	10,0	55,0	–	–	0,045	4	Cylindrical	■
JS554040G2C.0Z4-SIRA	03029957	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	Cylindrical	■
554050Z4.0-SIRON-A	02733813	2	F	5,0	6,0	12,0	55,0	–	–	0,055	4	Cylindrical	■
JS554050G2C.0Z4-SIRA	03029958	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	Cylindrical	■
554060Z4.0-SIRON-A	02679503	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	Cylindrical	■
JS554060E2C.0Z4-SIRA	03029959	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	Cylindrical	■
554080Z4.0-SIRON-A	02679512	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	Cylindrical	■
JS554080E2C.0Z4-SIRA	03029961	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	Cylindrical	■
554100Z4.0-SIRON-A	02679537	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	Cylindrical	■
JS554100E2C.0Z4-SIRA	03029963	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
554120Z4.0-SIRON-A	02679548	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	Cylindrical	■
JS554120E2C.0Z4-SIRA	03029966	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
554160Z4.0-SIRON-A	02679560	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	Cylindrical	■
JS554160E2C.0Z4-SIRA	03029970	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	Cylindrical	■
554200Z4.0-SIRON-A	02679566	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	Cylindrical	■
JS554200E2C.0Z4-SIRA	03029972	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	Cylindrical	■
554250Z4.0-SIRON-A	02679573	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Şanfren





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6



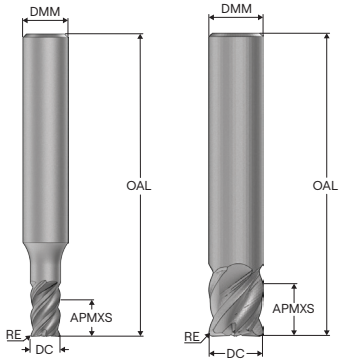
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	0,035	4	Cylindrical	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	0,045	4	Cylindrical	■
554L050Z4.0-SIRON-A	02733825	3	F	5,0	6,0	20,0	65,0	0,055	4	Cylindrical	■
554L060Z4.0-SIRON-A	02733828	3	D	6,0	6,0	23,0	65,0	0,075	4	Cylindrical	■
554L080Z4.0-SIRON-A	02733830	3	D	8,0	8,0	32,0	75,0	0,1	4	Cylindrical	■
554L100Z4.0-SIRON-A	02733832	3	D	10,0	10,0	40,0	85,0	0,125	4	Cylindrical	■
554L120Z4.0-SIRON-A	02733834	3	D	12,0	12,0	45,0	100,0	0,15	4	Cylindrical	■
554L160Z4.0-SIRON-A	02733836	3	D	16,0	16,0	55,0	115,0	0,2	4	Cylindrical	■
554L200Z4.0-SIRON-A	02733838	3	D	20,0	20,0	65,0	125,0	0,25	4	Cylindrical	■
554L250Z4.0-SIRON-A	02733841	3	D	25,0	25,0	85,0	150,0	0,3	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





F D



– Toleranţe:
– DMM= h5
– DC= e7
– RE= ±0,02 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

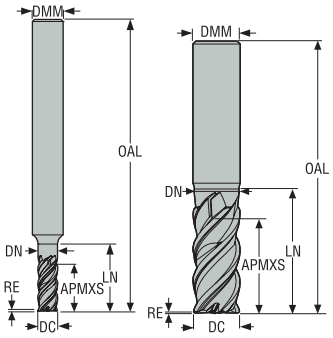
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS554030F1R020.0Z4-SIRA	10194617	1	F	3,0	6,0	4,0	40,0	0,2	4	Cylindrical	■
JS554040F1R020.0Z4-SIRA	10194618	1	F	4,0	6,0	6,0	40,0	0,2	4	Cylindrical	■
JS554050F1R020.0Z4-SIRA	10194619	1	F	5,0	6,0	7,0	40,0	0,2	4	Cylindrical	■
JS554060D1R020.0Z4-SIRA	10194620	1	D	6,0	6,0	8,0	40,0	0,2	4	Cylindrical	■
JS554060D1R050.0Z4-SIRA	10194621	1	D	6,0	6,0	8,0	40,0	0,5	4	Cylindrical	■
JS554080D1R050.0Z4-SIRA	10194622	1	D	8,0	8,0	11,0	50,0	0,5	4	Cylindrical	■
JS554100D1R050.0Z4-SIRA	10194623	1	D	10,0	10,0	13,0	57,0	0,5	4	Cylindrical	■
JS554100D1R100.0Z4-SIRA	10194624	1	D	10,0	10,0	13,0	57,0	1,0	4	Cylindrical	■
JS554120D1R050.0Z4-SIRA	10194625	1	D	12,0	12,0	15,0	65,0	0,5	4	Cylindrical	■
JS554120D1R100.0Z4-SIRA	10194626	1	D	12,0	12,0	15,0	65,0	1,0	4	Cylindrical	■
JS554160D1R050.0Z4-SIRA	10194627	1	D	16,0	16,0	19,0	75,0	0,5	4	Cylindrical	■
JS554160D1R100.0Z4-SIRA	10194628	1	D	16,0	16,0	19,0	75,0	1,0	4	Cylindrical	■
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	Cylindrical	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	Cylindrical	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	Cylindrical	■
554100R100Z4.0-SIRON-A	02679544	2	D	10,0	10,0	22,0	70,0	1,0	4	Cylindrical	■
554120R050Z4.0-SIRON-A	02679552	2	D	12,0	12,0	26,0	80,0	0,5	4	Cylindrical	■
554120R100Z4.0-SIRON-A	02679557	2	D	12,0	12,0	26,0	80,0	1,0	4	Cylindrical	■
554160R050Z4.0-SIRON-A	02679562	2	D	16,0	16,0	34,0	90,0	0,5	4	Cylindrical	■
554160R100Z4.0-SIRON-A	02679564	2	D	16,0	16,0	34,0	90,0	1,0	4	Cylindrical	■
554160R200Z4.0-SIRON-A	02810437	2	D	16,0	16,0	34,0	90,0	2,0	4	Cylindrical	■
554160R310Z4.0-SIRON-A	02810439	2	D	16,0	16,0	34,0	90,0	3,1	4	Cylindrical	■
554160R400Z4.0-SIRON-A	02810441	2	D	16,0	16,0	34,0	90,0	4,0	4	Cylindrical	■
554200R050Z4.0-SIRON-A	02679568	2	D	20,0	20,0	42,0	100,0	0,5	4	Cylindrical	■
554200R100Z4.0-SIRON-A	02679571	2	D	20,0	20,0	42,0	100,0	1,0	4	Cylindrical	■
554200R250Z4.0-SIRON-A	02810443	2	D	20,0	20,0	42,0	100,0	2,5	4	Cylindrical	■
554200R310Z4.0-SIRON-A	02810445	2	D	20,0	20,0	42,0	100,0	3,1	4	Cylindrical	■
554200R400Z4.0-SIRON-A	02810447	2	D	20,0	20,0	42,0	100,0	4,0	4	Cylindrical	■
554250R050Z4.0-SIRON-A	02679575	2	D	25,0	25,0	52,0	125,0	0,5	4	Cylindrical	■
554250R100Z4.0-SIRON-A	02679577	2	D	25,0	25,0	52,0	125,0	1,0	4	Cylindrical	■
554250R310Z4.0-SIRON-A	02810449	2	D	25,0	25,0	52,0	125,0	3,1	4	Cylindrical	■
554250R400Z4.0-SIRON-A	02810452	2	D	25,0	25,0	52,0	125,0	4,0	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



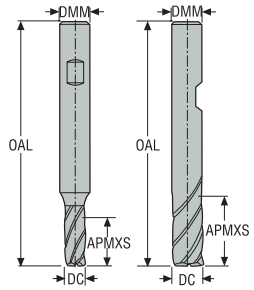
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Cylindrical	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	Cylindrical	■
JS554050G2R020.0Z4-SIRA	02881699	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	Cylindrical	■
JS554060E2R020.0Z4-SIRA	03029960	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	Cylindrical	■
JS554060E2R050.0Z4-SIRA	02881700	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	Cylindrical	■
JS554060E2R100.0Z4-SIRA	03029948	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	Cylindrical	■
JS554080E2R050.0Z4-SIRA	03029962	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	Cylindrical	■
JS554080E2R100.0Z4-SIRA	02881701	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	Cylindrical	■
JS554100E2R050.0Z4-SIRA	03029964	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	Cylindrical	■
JS554100E2R100.0Z4-SIRA	03029965	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	Cylindrical	■
JS554100E2R200.0Z4-SIRA	02881702	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	Cylindrical	■
JS554100E2R250.0Z4-SIRA	03029949	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	Cylindrical	■
JS554120E2R050.0Z4-SIRA	03029968	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	Cylindrical	■
JS554120E2R100.0Z4-SIRA	03029969	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	Cylindrical	■
JS554120E2R200.0Z4-SIRA	02881703	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	Cylindrical	■
JS554120E2R250.0Z4-SIRA	02881704	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	Cylindrical	■
JS554120E2R300.0Z4-SIRA	03029950	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	Cylindrical	■
JS554160E2R050.0Z4-SIRA	03029971	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	Cylindrical	■
JS554160E2R600.0Z4-SIRA	03093685	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	Cylindrical	■
JS554200E2R200.0Z4-SIRA	02881705	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	Cylindrical	■
JS554200E2R600.0Z4-SIRA	03029951	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	Cylindrical	■
JS554250E2R600.0Z4-SIRA	03093686	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Ascuţit





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6



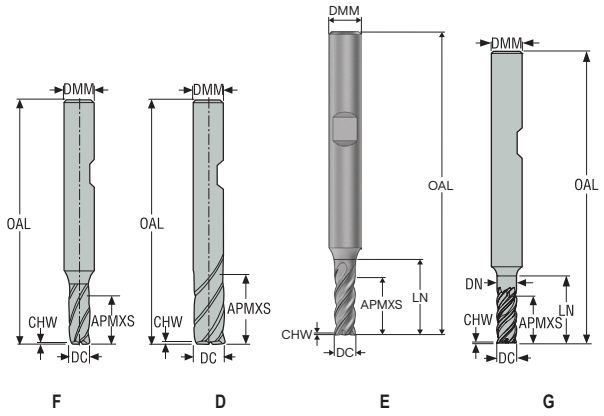
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	Weldon	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	Weldon	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	Weldon	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0	6,0	14,0	55,0	4	Weldon	☐
554080SZ4.0-SIRON-AW	02733849	2	D	8,0	8,0	18,0	60,0	4	Weldon	☐
554100SZ4.0-SIRON-AW	02733850	2	D	10,0	10,0	22,0	70,0	4	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Şanfren







—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6

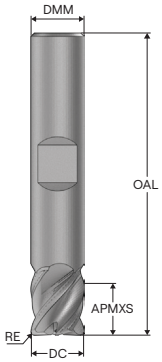
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Weldon	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	Weldon	■
JS554080D1C.3Z4-SIRA	10041462	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	Weldon	□
JS554100D1C.3Z4-SIRA	10041463	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	Weldon	□
JS554120D1C.3Z4-SIRA	10041464	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	Weldon	□
JS554160D1C.3Z4-SIRA	10041465	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	Weldon	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	–	–	0,035	4	Weldon	■
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	Weldon	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	–	–	0,045	4	Weldon	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	Weldon	■
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	–	–	0,055	4	Weldon	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	Weldon	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	Weldon	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	Weldon	■
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	Weldon	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	Weldon	■
JS554100E2C.3Z4-SIRA	03029980	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	Weldon	■
554100Z4.3-SIRON-A	02679535	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	Weldon	■
JS554120E2C.3Z4-SIRA	03029983	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	Weldon	■
554120Z4.3-SIRON-A	02679547	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	Weldon	■
JS554160E2C.3Z4-SIRA	03029986	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	Weldon	■
554160Z4.3-SIRON-A	02679559	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	Weldon	■
JS554200E2C.3Z4-SIRA	03029988	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	Weldon	■
554200Z4.3-SIRON-A	02679565	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	Weldon	■
554250Z4.3-SIRON-A	02679572	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	Weldon	■
554L030Z4.3-SIRON-A	02733817	3	F	3,0	6,0	12,0	55,0	–	–	0,035	4	Weldon	■
554L040Z4.3-SIRON-A	02733820	3	F	4,0	6,0	16,0	60,0	–	–	0,045	4	Weldon	■
554L050Z4.3-SIRON-A	02733824	3	F	5,0	6,0	20,0	65,0	–	–	0,055	4	Weldon	■
554L060Z4.3-SIRON-A	02733827	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	Weldon	■
554L080Z4.3-SIRON-A	02733829	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	Weldon	■
554L100Z4.3-SIRON-A	02733831	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	Weldon	■
554L120Z4.3-SIRON-A	02733833	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	Weldon	■
554L160Z4.3-SIRON-A	02733835	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	Weldon	■
554L200Z4.3-SIRON-A	02733837	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	Weldon	■
554L250Z4.3-SIRON-A	02733839	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă

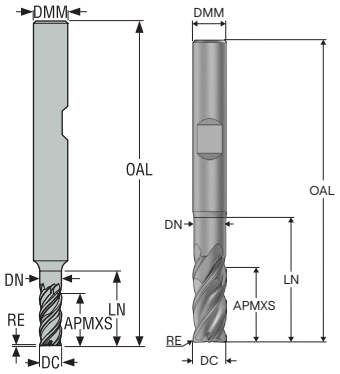
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS554080D1R050.3Z4-SIRA	10194629	1	D	8,0	8,0	11,0	50,0	0,5	4	Weldon	□
JS554100D1R050.3Z4-SIRA	10194630	1	D	10,0	10,0	13,0	57,0	0,5	4	Weldon	□
JS554100D1R100.3Z4-SIRA	10194631	1	D	10,0	10,0	13,0	57,0	1,0	4	Weldon	□
JS554120D1R050.3Z4-SIRA	10194632	1	D	12,0	12,0	15,0	65,0	0,5	4	Weldon	□
JS554120D1R100.3Z4-SIRA	10194633	1	D	12,0	12,0	15,0	65,0	1,0	4	Weldon	□
JS554160D1R050.3Z4-SIRA	10194634	1	D	16,0	16,0	19,0	75,0	0,5	4	Weldon	□
JS554160D1R100.3Z4-SIRA	10194635	1	D	16,0	16,0	19,0	75,0	1,0	4	Weldon	□
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	Weldon	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	Weldon	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	Weldon	■
554100R100Z4.3-SIRON-A	02679542	2	D	10,0	10,0	22,0	70,0	1,0	4	Weldon	■
554120R050Z4.3-SIRON-A	02679549	2	D	12,0	12,0	26,0	80,0	0,5	4	Weldon	■
554120R100Z4.3-SIRON-A	02679554	2	D	12,0	12,0	26,0	80,0	1,0	4	Weldon	■
554160R050Z4.3-SIRON-A	02679561	2	D	16,0	16,0	34,0	90,0	0,5	4	Weldon	■
554160R100Z4.3-SIRON-A	02679563	2	D	16,0	16,0	34,0	90,0	1,0	4	Weldon	■
554160R200Z4.3-SIRON-A	02810436	2	D	16,0	16,0	34,0	90,0	2,0	4	Weldon	■
554160R310Z4.3-SIRON-A	02810438	2	D	16,0	16,0	34,0	90,0	3,1	4	Weldon	■
554160R400Z4.3-SIRON-A	02810440	2	D	16,0	16,0	34,0	90,0	4,0	4	Weldon	■
554200R050Z4.3-SIRON-A	02679567	2	D	20,0	20,0	42,0	100,0	0,5	4	Weldon	■
554200R100Z4.3-SIRON-A	02679570	2	D	20,0	20,0	42,0	100,0	1,0	4	Weldon	■
554200R250Z4.3-SIRON-A	02810442	2	D	20,0	20,0	42,0	100,0	2,5	4	Weldon	■
554200R310Z4.3-SIRON-A	02810444	2	D	20,0	20,0	42,0	100,0	3,1	4	Weldon	■
554200R400Z4.3-SIRON-A	02810446	2	D	20,0	20,0	42,0	100,0	4,0	4	Weldon	■
554250R050Z4.3-SIRON-A	02679574	2	D	25,0	25,0	52,0	125,0	0,5	4	Weldon	■
554250R100Z4.3-SIRON-A	02679576	2	D	25,0	25,0	52,0	125,0	1,0	4	Weldon	■
554250R310Z4.3-SIRON-A	02810448	2	D	25,0	25,0	52,0	125,0	3,1	4	Weldon	■
554250R400Z4.3-SIRON-A	02810451	2	D	25,0	25,0	52,0	125,0	4,0	4	Weldon	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Rază la vârf





—Toleranţe:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



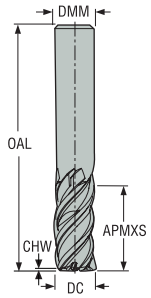
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Weldon	□
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	Weldon	■
JS554050G2R020.3Z4-SIRA	02881708	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	Weldon	□
JS554060E2R020.3Z4-SIRA	03029977	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	Weldon	■
JS554060E2R050.3Z4-SIRA	02881709	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	Weldon	□
JS554060E2R100.3Z4-SIRA	03029952	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	Weldon	□
JS554080E2R050.3Z4-SIRA	03029979	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	Weldon	□
JS554080E2R100.3Z4-SIRA	02881710	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	Weldon	□
JS554100E2R050.3Z4-SIRA	03029981	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	Weldon	■
JS554100E2R100.3Z4-SIRA	03029982	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	Weldon	□
JS554100E2R200.3Z4-SIRA	02881711	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	Weldon	■
JS554100E2R250.3Z4-SIRA	03029953	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	Weldon	□
JS554120E2R050.3Z4-SIRA	03029984	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	Weldon	■
JS554120E2R100.3Z4-SIRA	03029985	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	Weldon	□
JS554120E2R200.3Z4-SIRA	02881712	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	Weldon	□
JS554120E2R250.3Z4-SIRA	02881713	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	Weldon	□
JS554120E2R300.3Z4-SIRA	03029954	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	Weldon	□
JS554160E2R050.3Z4-SIRA	03029987	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	Weldon	■
JS554160E2R600.3Z4-SIRA	03093687	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	Weldon	□
JS554200E2R200.3Z4-SIRA	02881714	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	Weldon	□
JS554200E2R600.3Z4-SIRA	03029955	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	Weldon	□
JS554250E2R600.3Z4-SIRA	03093688	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Şanfren – Inci





D

– Toleranţe:
– DMM=h5
– DC=e7
– Reascuţire posibilă dacă DC este ≥ Ø.375



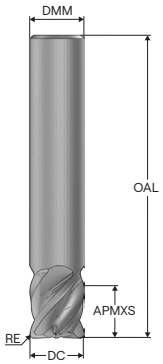
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	Cylindrical	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	Cylindrical	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	3.000	0.005	4	Cylindrical	■
5540500Z4.0-SIRON-A	02711611	2	D	0.500	0.500	1.000	3.500	0.006	4	Cylindrical	■
5540625Z4.0-SIRON-A	02711626	2	D	0.625	0.625	1.250	3.750	0.008	4	Cylindrical	■
5540750Z4.0-SIRON-A	02711643	2	D	0.750	0.750	1.500	4.000	0.010	4	Cylindrical	■
5541000Z4.0-SIRON-A	02711660	2	D	1.000	1.000	2.000	5.000	0.012	4	Cylindrical	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





D

—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±.0008 *inch*
—Reascuţire posibilă dacă DC este ≥ Ø.375



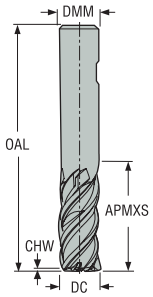
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	Cylindrical	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500	0.015	4	Cylindrical	■
5540375R015Z4.0-SIRON-A	02711588	2	D	0.375	0.375	0.750	3.000	0.015	4	Cylindrical	■
5540375R030Z4.0-SIRON-A	02711589	2	D	0.375	0.375	0.750	3.000	0.030	4	Cylindrical	■
5540500R015Z4.0-SIRON-A	02711614	2	D	0.500	0.500	1.000	3.500	0.015	4	Cylindrical	■
5540500R030Z4.0-SIRON-A	02711616	2	D	0.500	0.500	1.000	3.500	0.030	4	Cylindrical	■
5540500R125Z4.0-SIRON-A	02842370	2	D	0.500	0.500	1.000	3.500	0.125	4	Cylindrical	■
5540625R015Z4.0-SIRON-A	02711629	2	D	0.625	0.625	1.250	3.750	0.015	4	Cylindrical	■
5540625R030Z4.0-SIRON-A	02711631	2	D	0.625	0.625	1.250	3.750	0.030	4	Cylindrical	■
5540625R125Z4.0-SIRON-A	02842371	2	D	0.625	0.625	1.250	3.750	0.125	4	Cylindrical	■
5540750R030Z4.0-SIRON-A	02711647	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
5540750R060Z4.0-SIRON-A	02711655	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■

■ Stoc standard.

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Şanfren – Inci





D

—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă



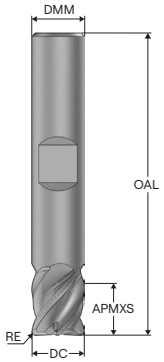
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	Weldon	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	Weldon	■

■ **Stoc standard.**

JS554

Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Weldon – Rază la vârf – Inci





D

- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±.0008 *inch*
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	Weldon	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	Weldon	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	Weldon	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	Weldon	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS554 Degroşare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS554 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
N1	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H11	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	95 (75 — 110) *310 (250 — 360)*
H12	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	90 (73 — 100) *295 (240 — 320)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS554 Frezare de canal

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	175 (150 — 190) *570 (500 — 620)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS554 Frezare de canal

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
N1	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H11	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 97) *260 (220 — 310)*
H12	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (60 — 89) *245 (200 — 290)*
H21	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
TS1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS554 Degroşare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS554 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	38 (32 — 44) *125 (110 — 140)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.15 *0,0060*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.080 *0,0032*	0.095 *0,0038*	60 (48 — 71) *195 (160 — 230)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS554 Frezare de canal – Inci

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	175 (150 — 190) *570 (500 — 620)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS554 Frezare de canal – Inci

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H21	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
H31	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 57) *155 (130 — 180)*
TS1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

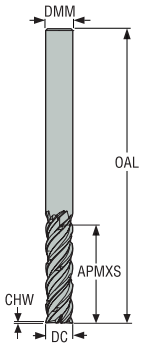
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JS554-3C

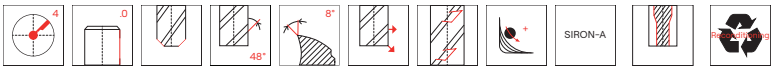
Degroşare avansată – Universale – Pătrat – 4 Caneluri – Cilindrică – Şanfren





D

—Toleranţe:
—DMM= h5
—DC= e7
—Reascuţire posibilă



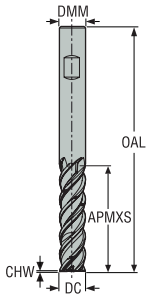
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	Cylindrical	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	Cylindrical	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	85,0	0,125	4	Cylindrical	■
JS554120D3C.0Z4C-SIRA	02810481	3	D	■	12,0	12,0	45,0	100,0	0,15	4	Cylindrical	■
JS554160D3C.0Z4C-SIRA	02810483	3	D	■	16,0	16,0	55,0	115,0	0,2	4	Cylindrical	■
JS554200D3C.0Z4C-SIRA	02810485	3	D	■	20,0	20,0	65,0	125,0	0,25	4	Cylindrical	■
JS554250D3C.0Z4C-SIRA	02810486	3	D	■	25,0	25,0	85,0	150,0	0,3	4	Cylindrical	■

■ **Stoc standard.**

JS554-3C

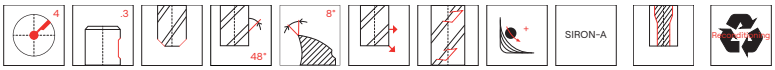
Degroșare avansată – Universale – Pătrat – 4 Caneluri – Weldon – Șanfren





D

—Toleranțe:
—DMM= h5
—DC= e7
—Reascuțire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS554060D3C.3Z4C-SIRA	02810474	3	D	■	6,0	6,0	23,0	65,0	0,075	4	Weldon	■
JS554080D3C.3Z4C-SIRA	02810476	3	D	■	8,0	8,0	32,0	75,0	0,1	4	Weldon	■
JS554100D3C.3Z4C-SIRA	02810478	3	D	■	10,0	10,0	40,0	85,0	0,125	4	Weldon	■
JS554120D3C.3Z4C-SIRA	02810480	3	D	■	12,0	12,0	45,0	100,0	0,15	4	Weldon	■
JS554160D3C.3Z4C-SIRA	02810482	3	D	■	16,0	16,0	55,0	115,0	0,2	4	Weldon	■
JS554200D3C.3Z4C-SIRA	02810484	3	D	■	20,0	20,0	65,0	125,0	0,25	4	Weldon	■
JS554250D3C.3Z4C-SIRA	02810487	3	D	■	25,0	25,0	85,0	150,0	0,3	4	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JS554-3C Degroşare avansată

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	350 (320 — 380) *1150 (1100 — 1200)*
P2	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
P3	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	295 (270 — 320) *970 (890 — 1000)*
P4	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	260 (240 — 280) *850 (790 — 910)*
P5	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (230 — 270) *820 (760 — 880)*
P6	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	280 (260 — 300) *920 (860 — 980)*
P7	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	265 (240 — 290) *870 (790 — 950)*
P8	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	250 (230 — 270) *820 (760 — 880)*
P11	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	245 (230 — 270) *800 (760 — 880)*
P12	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (140 — 160) *490 (460 — 520)*
M1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	180 (160 — 210) *590 (530 — 680)*
M2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (130 — 170) *490 (430 — 550)*
M3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	100 (90 — 100) *330 (300 — 320)*
M4	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	75 (70 — 85) *245 (230 — 270)*
M5	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	65 (59 — 71) *215 (200 — 230)*
K1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
K2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
K3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	255 (240 — 280) *840 (790 — 910)*
K4	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (220 — 260) *800 (730 — 850)*
K5	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140 — 160) *490 (460 — 520)*
K6	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (200 — 230) *710 (660 — 750)*
K7	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (180 — 200) *620 (600 — 650)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS554-3C Degroșare avansată

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	480 (420 — 540) *1575 (1400 — 1700)*
N3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	320 (280 — 360) *1050 (920 — 1100)*
N11	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	375 (330 — 420) *1225 (1100 — 1300)*
S1	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	50 (40 — 60) *165 (140 — 190)*
S2	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	25 (20 — 29) *80 (66 — 95)*
S11	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	195 (130 — 220) *640 (430 — 720)*
S12	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (100 — 160) *490 (330 — 520)*
S13	E	0.100 *0,100*	3.6 *3,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	120 (80 — 130) *395 (270 — 420)*
H5	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	200 (190 — 220) *660 (630 — 720)*
H8	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*
H11	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	255 (240 — 280) *840 (790 — 910)*
H12	M/A/D	0.100 *0,100*	3.6 *3,6*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	205 (190 — 220) *670 (630 — 720)*
H21	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*

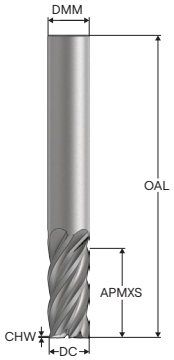
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Şanfren





– Toleranţe:
– DMM=h5
– DC=e7
– Reascuţire posibilă



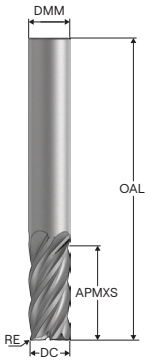
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5551-060D2C.0Z5	SIRA	10303332	2	D	6,0	6,0	14,0	58,0	0,075	5	Cylindrical	■
ST5551-080D2C.0Z5	SIRA	10303333	2	D	8,0	8,0	18,0	64,0	0,1	5	Cylindrical	■
ST5551-100D2C.0Z5	SIRA	10303334	2	D	10,0	10,0	22,0	73,0	0,125	5	Cylindrical	■
ST5551-120D2C.0Z5	SIRA	10303335	2	D	12,0	12,0	26,0	84,0	0,15	5	Cylindrical	■
ST5551-160D2C.0Z5	SIRA	10303336	2	D	16,0	16,0	34,0	95,0	0,2	5	Cylindrical	■
ST5551-200D2C.0Z5	SIRA	10303337	2	D	20,0	20,0	42,0	109,0	0,25	5	Cylindrical	■
ST5551-250D2C.0Z5	SIRA	10303338	2	D	25,0	25,0	52,0	125,0	0,3	5	Cylindrical	■
ST5551-060D3C.0Z5	SIRA	10303339	3	D	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
ST5551-080D3C.0Z5	SIRA	10303340	3	D	8,0	8,0	32,0	73,0	0,1	5	Cylindrical	■
ST5551-100D3C.0Z5	SIRA	10303341	3	D	10,0	10,0	40,0	85,0	0,125	5	Cylindrical	■
ST5551-120D3C.0Z5	SIRA	10303342	3	D	12,0	12,0	45,0	100,0	0,15	5	Cylindrical	■
ST5551-160D3C.0Z5	SIRA	10303343	3	D	16,0	16,0	55,0	115,0	0,2	5	Cylindrical	■
ST5551-200D3C.0Z5	SIRA	10303344	3	D	20,0	20,0	65,0	125,0	0,25	5	Cylindrical	■
ST5551-250D3C.0Z5	SIRA	10303345	3	D	25,0	25,0	85,0	155,0	0,3	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă



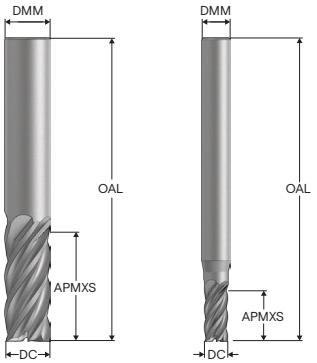
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.0Z5	SIRA	10303346	2	D	6,0	6,0	14,0	58,0	0,5	5	Cylindrical	■
ST5551-080D2R050.0Z5	SIRA	10303347	2	D	8,0	8,0	18,0	64,0	0,5	5	Cylindrical	■
ST5551-100D2R050.0Z5	SIRA	10303348	2	D	10,0	10,0	22,0	73,0	0,5	5	Cylindrical	■
ST5551-120D2R050.0Z5	SIRA	10303349	2	D	12,0	12,0	26,0	84,0	0,5	5	Cylindrical	■
ST5551-120D2R100.0Z5	SIRA	10303350	2	D	12,0	12,0	26,0	84,0	1,0	5	Cylindrical	■
ST5551-160D2R050.0Z5	SIRA	10303351	2	D	16,0	16,0	34,0	95,0	0,5	5	Cylindrical	■
ST5551-160D2R100.0Z5	SIRA	10303352	2	D	16,0	16,0	34,0	95,0	1,0	5	Cylindrical	■
ST5551-200D2R050.0Z5	SIRA	10303353	2	D	20,0	20,0	42,0	109,0	0,5	5	Cylindrical	■
ST5551-200D2R100.0Z5	SIRA	10303354	2	D	20,0	20,0	42,0	109,0	1,0	5	Cylindrical	■
ST5551-250D2R050.0Z5	SIRA	10303355	2	D	25,0	25,0	52,0	125,0	0,5	5	Cylindrical	■
ST5551-250D2R100.0Z5	SIRA	10303356	2	D	25,0	25,0	52,0	125,0	1,0	5	Cylindrical	■
ST5551-060D3R050.0Z5	SIRA	10303357	3	D	6,0	6,0	23,0	64,0	0,5	5	Cylindrical	■
ST5551-080D3R050.0Z5	SIRA	10303358	3	D	8,0	8,0	32,0	73,0	0,5	5	Cylindrical	■
ST5551-100D3R050.0Z5	SIRA	10303359	3	D	10,0	10,0	40,0	85,0	0,5	5	Cylindrical	■
ST5551-120D3R050.0Z5	SIRA	10303360	3	D	12,0	12,0	45,0	100,0	0,5	5	Cylindrical	■
ST5551-120D3R100.0Z5	SIRA	10303361	3	D	12,0	12,0	45,0	100,0	1,0	5	Cylindrical	■
ST5551-160D3R050.0Z5	SIRA	10303362	3	D	16,0	16,0	55,0	115,0	0,5	5	Cylindrical	■
ST5551-160D3R100.0Z5	SIRA	10303363	3	D	16,0	16,0	55,0	115,0	1,0	5	Cylindrical	■
ST5551-200D3R050.0Z5	SIRA	10303364	3	D	20,0	20,0	65,0	125,0	0,5	5	Cylindrical	■
ST5551-200D3R100.0Z5	SIRA	10303365	3	D	20,0	20,0	65,0	125,0	1,0	5	Cylindrical	■
ST5551-250D3R050.0Z5	SIRA	10303366	3	D	25,0	25,0	85,0	155,0	0,5	5	Cylindrical	■
ST5551-250D3R100.0Z5	SIRA	10303367	3	D	25,0	25,0	85,0	155,0	1,0	5	Cylindrical	■

■ Stoc standard.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Reascuţire posibilă dacă DC este ≥ Ø.250



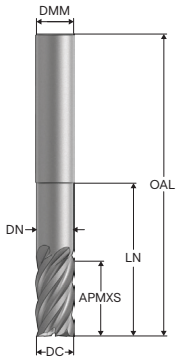
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
ST5551-.250D1S.0Z5	SIRA	10303040	1	D	0.250	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.375D1S.0Z5	SIRA	10303041	1	D	0.375	0.375	0.500	2.500	5	Cylindrical	■
ST5551-.500D1S.0Z5	SIRA	10303042	1	D	0.500	0.500	0.625	3.000	5	Cylindrical	■
ST5551-.625D1S.0Z5	SIRA	10303043	1	D	0.625	0.625	0.750	3.000	5	Cylindrical	■
ST5551-.750D1S.0Z5	SIRA	10303044	1	D	0.750	0.750	0.875	3.000	5	Cylindrical	■
ST5551-.125D2S.0Z5	SIRA	10303045	2	D	0.125	0.125	0.250	1.500	5	Cylindrical	■
ST5551-.156F2S.0Z5	SIRA	10303046	2	F	0.156	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.188D2S.0Z5	SIRA	10303047	2	D	0.188	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.219F2S.0Z5	SIRA	10303048	2	F	0.219	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.313D2S.0Z5	SIRA	10303049	2	D	0.313	0.313	0.750	2.500	5	Cylindrical	■
ST5551-.375D2S.0Z5	SIRA	10303050	2	D	0.375	0.375	0.875	2.500	5	Cylindrical	■
ST5551-.500D2S.0Z5	SIRA	10303051	2	D	0.500	0.500	1.000	3.000	5	Cylindrical	■
ST5551-.625D2S.0Z5	SIRA	10303052	2	D	0.625	0.625	1.250	3.500	5	Cylindrical	■
ST5551-.750D2S.0Z5	SIRA	10303053	2	D	0.750	0.750	1.500	4.000	5	Cylindrical	■
ST5551-.188D3S.0Z5	SIRA	10303054	3	D	0.188	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.219F3S.0Z5	SIRA	10303055	3	F	0.219	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.250D3S.0Z5	SIRA	10303056	3	D	0.250	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.500D3S.0Z5	SIRA	10303057	3	D	0.500	0.500	1.250	3.000	5	Cylindrical	■
ST5551-.125D4S.0Z5	SIRA	10303059	4	D	0.125	0.125	0.500	1.500	5	Cylindrical	■
ST5551-.156F4S.0Z5	SIRA	10303060	4	F	0.156	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.625D4S.0Z5	SIRA	10303065	4	D	0.625	0.625	1.625	3.500	5	Cylindrical	■
ST5551-.625D5S.0Z5	SIRA	10303070	5	D	0.625	0.625	2.125	4.000	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Reascuţire posibilă



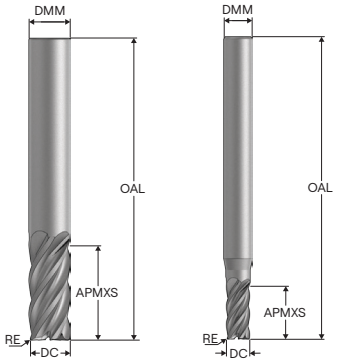
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci			
ST5551-.750E3S.0Z5	SIRA	10303058	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Cylindrical	■
ST5551-.250E4S.0Z5	SIRA	10303061	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Cylindrical	■
ST5551-.375E4S.0Z5	SIRA	10303062	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Cylindrical	■
ST5551-.500E4S.0Z5	SIRA	10303063	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Cylindrical	■
ST5551-.625E4S.0Z5	SIRA	10303064	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Cylindrical	■
ST5551-.750E4S.0Z5	SIRA	10303066	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Cylindrical	■
ST5551-.250E5S.0Z5	SIRA	10303067	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Cylindrical	■
ST5551-.375E5S.0Z5	SIRA	10303068	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Cylindrical	■
ST5551-.625E5S.0Z5	SIRA	10303069	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Cylindrical	■
ST5551-.750E5S.0Z5	SIRA	10303071	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Cylindrical	■
ST5551-.500E6S.0Z5	SIRA	10303072	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Cylindrical	■
ST5551-.250E8S.0Z5	SIRA	10303073	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Cylindrical	■
ST5551-.375E8S.0Z5	SIRA	10303074	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Cylindrical	■
ST5551-.500E8S.0Z5	SIRA	10303075	8	E	0.500	0.500	0.625	6.000	4.125	0.480	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf – Inci





– Toleranţe:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Reascuţire posibilă dacă DC este ≥ Ø.250



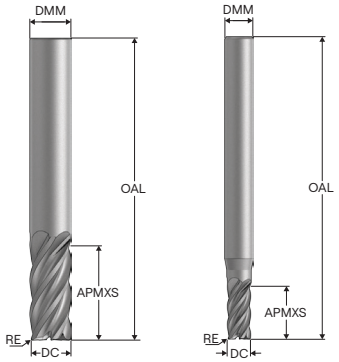
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5551-.250D1R015.0Z5	SIRA	10303076	1	D	0.250	0.250	0.375	2.000	0.015	5	Cylindrical	■
ST5551-.250D1R030.0Z5	SIRA	10303077	1	D	0.250	0.250	0.375	2.000	0.030	5	Cylindrical	■
ST5551-.250D1R045.0Z5	SIRA	10303078	1	D	0.250	0.250	0.375	2.000	0.045	5	Cylindrical	■
ST5551-.375D1R015.0Z5	SIRA	10303079	1	D	0.375	0.375	0.500	2.500	0.015	5	Cylindrical	■
ST5551-.375D1R030.0Z5	SIRA	10303080	1	D	0.375	0.375	0.500	2.500	0.030	5	Cylindrical	■
ST5551-.375D1R045.0Z5	SIRA	10303081	1	D	0.375	0.375	0.500	2.500	0.045	5	Cylindrical	■
ST5551-.500D1R015.0Z5	SIRA	10303082	1	D	0.500	0.500	0.625	3.000	0.015	5	Cylindrical	■
ST5551-.500D1R030.0Z5	SIRA	10303083	1	D	0.500	0.500	0.625	3.000	0.030	5	Cylindrical	■
ST5551-.500D1R045.0Z5	SIRA	10303084	1	D	0.500	0.500	0.625	3.000	0.045	5	Cylindrical	■
ST5551-.500D1R060.0Z5	SIRA	10303085	1	D	0.500	0.500	0.625	3.000	0.060	5	Cylindrical	■
ST5551-.500D1R120.0Z5	SIRA	10303086	1	D	0.500	0.500	0.625	3.000	0.120	5	Cylindrical	■
ST5551-.625D1R015.0Z5	SIRA	10303087	1	D	0.625	0.625	0.750	3.000	0.015	5	Cylindrical	■
ST5551-.625D1R030.0Z5	SIRA	10303088	1	D	0.625	0.625	0.750	3.000	0.030	5	Cylindrical	■
ST5551-.625D1R060.0Z5	SIRA	10303089	1	D	0.625	0.625	0.750	3.000	0.060	5	Cylindrical	■
ST5551-.625D1R120.0Z5	SIRA	10303090	1	D	0.625	0.625	0.750	3.000	0.120	5	Cylindrical	■
ST5551-.750D1R030.0Z5	SIRA	10303091	1	D	0.750	0.750	0.875	3.000	0.030	5	Cylindrical	■
ST5551-.750D1R060.0Z5	SIRA	10303092	1	D	0.750	0.750	0.875	3.000	0.060	5	Cylindrical	■
ST5551-.750D1R120.0Z5	SIRA	10303093	1	D	0.750	0.750	0.875	3.000	0.120	5	Cylindrical	■
ST5551-.125D2R010.0Z5	SIRA	10303094	2	D	0.125	0.125	0.250	1.500	0.010	5	Cylindrical	■
ST5551-.156F2R010.0Z5	SIRA	10303095	2	F	0.156	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.188D2R010.0Z5	SIRA	10303096	2	D	0.188	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.219F2R010.0Z5	SIRA	10303097	2	F	0.219	0.250	0.375	2.000	0.010	5	Cylindrical	■
ST5551-.313D2R015.0Z5	SIRA	10303098	2	D	0.313	0.313	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R015.0Z5	SIRA	10303099	2	D	0.375	0.375	0.875	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R030.0Z5	SIRA	10303100	2	D	0.375	0.375	0.875	2.500	0.030	5	Cylindrical	■
ST5551-.375D2R045.0Z5	SIRA	10303101	2	D	0.375	0.375	0.875	2.500	0.045	5	Cylindrical	■
ST5551-.375D2R060.0Z5	SIRA	10303102	2	D	0.375	0.375	0.875	2.500	0.060	5	Cylindrical	■
ST5551-.500D2R015.0Z5	SIRA	10303103	2	D	0.500	0.500	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.500D2R030.0Z5	SIRA	10303104	2	D	0.500	0.500	1.000	3.000	0.030	5	Cylindrical	■
ST5551-.500D2R060.0Z5	SIRA	10303105	2	D	0.500	0.500	1.000	3.000	0.060	5	Cylindrical	■
ST5551-.625D2R015.0Z5	SIRA	10303106	2	D	0.625	0.625	1.250	3.500	0.015	5	Cylindrical	■
ST5551-.625D2R030.0Z5	SIRA	10303107	2	D	0.625	0.625	1.250	3.500	0.030	5	Cylindrical	■
ST5551-.625D2R045.0Z5	SIRA	10303108	2	D	0.625	0.625	1.250	3.500	0.045	5	Cylindrical	■
ST5551-.625D2R060.0Z5	SIRA	10303109	2	D	0.625	0.625	1.250	3.500	0.060	5	Cylindrical	■
ST5551-.625D2R090.0Z5	SIRA	10303110	2	D	0.625	0.625	1.250	3.500	0.090	5	Cylindrical	■
ST5551-.625D2R125.0Z5	SIRA	10303111	2	D	0.625	0.625	1.250	3.500	0.125	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă dacă DC este ≥ Ø.250



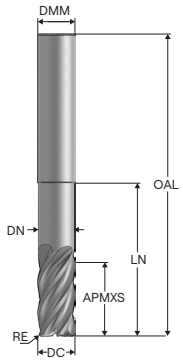
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5551-.750D2R030.0Z5	SIRA	10303112	2	D	0.750	0.750	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.750D2R060.0Z5	SIRA	10303113	2	D	0.750	0.750	1.500	4.000	0.060	5	Cylindrical	■
ST5551-.750D2R090.0Z5	SIRA	10303114	2	D	0.750	0.750	1.500	4.000	0.090	5	Cylindrical	■
ST5551-.750D2R125.0Z5	SIRA	10303115	2	D	0.750	0.750	1.500	4.000	0.125	5	Cylindrical	■
ST5551-1.00D2R015.0Z5	SIRA	10303116	2	D	1.000	1.000	1.750	4.000	0.015	5	Cylindrical	■
ST5551-1.00D2R030.0Z5	SIRA	10303117	2	D	1.000	1.000	1.750	4.000	0.030	5	Cylindrical	■
ST5551-1.00D2R060.0Z5	SIRA	10303118	2	D	1.000	1.000	1.750	4.000	0.060	5	Cylindrical	■
ST5551-.188D3R010.0Z5	SIRA	10303119	3	D	0.188	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.219F3R010.0Z5	SIRA	10303120	3	F	0.219	0.250	0.750	2.500	0.010	5	Cylindrical	■
ST5551-.250D3R015.0Z5	SIRA	10303121	3	D	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.250D3R030.0Z5	SIRA	10303122	3	D	0.250	0.250	0.750	2.500	0.030	5	Cylindrical	■
ST5551-.250D3R045.0Z5	SIRA	10303123	3	D	0.250	0.250	0.750	2.500	0.045	5	Cylindrical	■
ST5551-.375D3R030.0Z5	SIRA	10303124	3	D	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R015.0Z5	SIRA	10303125	3	D	0.500	0.500	1.250	3.000	0.015	5	Cylindrical	■
ST5551-.500D3R030.0Z5	SIRA	10303126	3	D	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R045.0Z5	SIRA	10303127	3	D	0.500	0.500	1.250	3.000	0.045	5	Cylindrical	■
ST5551-.500D3R060.0Z5	SIRA	10303128	3	D	0.500	0.500	1.250	3.000	0.060	5	Cylindrical	■
ST5551-.500D3R090.0Z5	SIRA	10303129	3	D	0.500	0.500	1.250	3.000	0.090	5	Cylindrical	■
ST5551-.500D3R125.0Z5	SIRA	10303130	3	D	0.500	0.500	1.250	3.000	0.125	5	Cylindrical	■
ST5551-.750D3R030.0Z5	SIRA	10303134	3	D	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.125D4R010.0Z5	SIRA	10303138	4	D	0.125	0.125	0.500	1.500	0.010	5	Cylindrical	■
ST5551-.156F4R010.0Z5	SIRA	10303139	4	F	0.156	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.250D4R015.0Z5	SIRA	10303142	4	D	0.250	0.250	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.375D4R030.0Z5	SIRA	10303147	4	D	0.375	0.375	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5	SIRA	10303152	4	D	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5	SIRA	10303158	4	D	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.500D5R030.0Z5	SIRA	10303165	5	D	0.500	0.500	2.000	4.000	0.030	5	Cylindrical	■
ST5551-.750D5R030.0Z5	SIRA	10303171	5	D	0.750	0.750	2.750	5.000	0.030	5	Cylindrical	■

■ Stoc standard.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf – Inci





- Toleranţe:
- DMM= -.0001"/-.0004"
- DC= + .000" / - .002"
- RE= ±.0008"
- Reascuţire posibilă



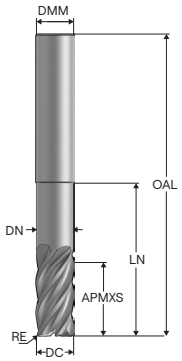
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5551-.250E4R015.0Z5	SIRA	10303140	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Cylindrical	■
ST5551-.250E4R030.0Z5	SIRA	10303141	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Cylindrical	■
ST5551-.375E4R015.0Z5	SIRA	10303143	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Cylindrical	■
ST5551-.375E4R030.0Z5	SIRA	10303144	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Cylindrical	■
ST5551-.375E4R045.0Z5	SIRA	10303145	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Cylindrical	■
ST5551-.375E4R060.0Z5	SIRA	10303146	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Cylindrical	■
ST5551-.500E4R015.0Z5	SIRA	10303148	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Cylindrical	■
ST5551-.500E4R030.0Z5	SIRA	10303149	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Cylindrical	■
ST5551-.500E4R060.0Z5	SIRA	10303150	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Cylindrical	■
ST5551-.500E4R120.0Z5	SIRA	10303151	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Cylindrical	■
ST5551-.625E4R030.0Z5	SIRA	10303153	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Cylindrical	■
ST5551-.625E4R060.0Z5	SIRA	10303154	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Cylindrical	■
ST5551-.250E5R015.0Z5	SIRA	10303159	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Cylindrical	■
ST5551-.250E5R030.0Z5	SIRA	10303160	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Cylindrical	■
ST5551-.375E5R015.0Z5	SIRA	10303161	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E5R030.0Z5	SIRA	10303162	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E5R045.0Z5	SIRA	10303163	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E5R060.0Z5	SIRA	10303164	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Cylindrical	■
ST5551-.625E5R030.0Z5	SIRA	10303166	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Cylindrical	■
ST5551-.625E5R060.0Z5	SIRA	10303167	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Cylindrical	■
ST5551-.500E6R015.0Z5	SIRA	10303172	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E6R030.0Z5	SIRA	10303173	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E6R060.0Z5	SIRA	10303174	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E6R120.0Z5	SIRA	10303175	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Cylindrical	■
ST5551-.250E8R015.0Z5	SIRA	10303176	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Cylindrical	■
ST5551-.250E8R030.0Z5	SIRA	10303177	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Cylindrical	■
ST5551-.375E8R015.0Z5	SIRA	10303178	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E8R030.0Z5	SIRA	10303179	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E8R045.0Z5	SIRA	10303180	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E8R060.0Z5	SIRA	10303181	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Cylindrical	■
ST5551-.500E8R015.0Z5	SIRA	10303182	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E8R030.0Z5	SIRA	10303183	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E8R060.0Z5	SIRA	10303184	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E8R120.0Z5	SIRA	10303185	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă



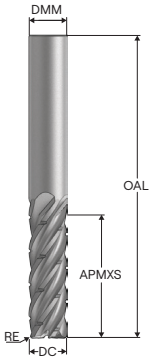
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5551-.750E3R030.0Z5	SIRA	10303131	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Cylindrical	■
ST5551-.750E3R060.0Z5	SIRA	10303132	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Cylindrical	■
ST5551-.750E3R120.0Z5	SIRA	10303133	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Cylindrical	■
ST5551-1.00E3R030.0Z5	SIRA	10303135	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Cylindrical	■
ST5551-1.00E3R060.0Z5	SIRA	10303136	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Cylindrical	■
ST5551-1.00E3R120.0Z5	SIRA	10303137	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Cylindrical	■
ST5551-.750E4R030.0Z5	SIRA	10303155	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Cylindrical	■
ST5551-.750E4R060.0Z5	SIRA	10303156	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Cylindrical	■
ST5551-.750E4R120.0Z5	SIRA	10303157	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Cylindrical	■
ST5551-.750E5R030.0Z5	SIRA	10303168	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Cylindrical	■
ST5551-.750E5R060.0Z5	SIRA	10303169	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Cylindrical	■
ST5551-.750E5R120.0Z5	SIRA	10303170	5	E	0.750	0.750	1.132	6.000	4.125	0.720	0.120	5	Cylindrical	■

■ Stoc standard.

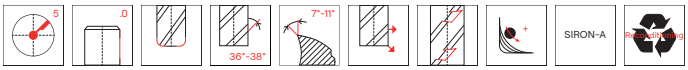
ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf – Inci





- Toleranţe:
- DMM= -.0001"/-.0004"
- DC= + .000" / - .002"
- RE= ±.0008"
- Reascuţire posibilă



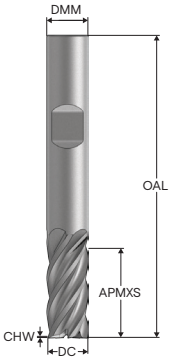
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						inci	inci	inci	inci	inci			
ST5551-.250D3R015.0Z5C	SIRA	10303186	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D3R030.0Z5C	SIRA	10303187	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R030.0Z5C	SIRA	10303188	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.625D3R030.0Z5C	SIRA	10303189	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Cylindrical	■
ST5551-.750D3R030.0Z5C	SIRA	10303190	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5C	SIRA	10303191	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5C	SIRA	10303192	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.625D5R030.0Z5C	SIRA	10303193	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Cylindrical	■

■ **Stoc standard.**

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Șanfren





—Toleranţe:
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—DC=e7
—Reascuţire posibilă



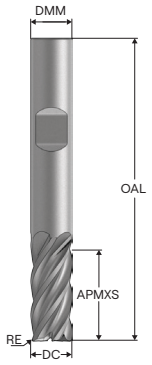
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5551-060D2C.3Z5	SIRA	10303368	2	D	6,0	6,0	14,0	58,0	0,075	5	Weldon	☐
ST5551-080D2C.3Z5	SIRA	10303369	2	D	8,0	8,0	18,0	64,0	0,1	5	Weldon	☐
ST5551-100D2C.3Z5	SIRA	10303370	2	D	10,0	10,0	22,0	73,0	0,125	5	Weldon	☐
ST5551-120D2C.3Z5	SIRA	10303371	2	D	12,0	12,0	26,0	84,0	0,15	5	Weldon	☐
ST5551-160D2C.3Z5	SIRA	10303372	2	D	16,0	16,0	34,0	95,0	0,2	5	Weldon	☐
ST5551-200D2C.3Z5	SIRA	10303373	2	D	20,0	20,0	42,0	109,0	0,25	5	Weldon	☐
ST5551-250D2C.3Z5	SIRA	10303374	2	D	25,0	25,0	52,0	125,0	0,3	5	Weldon	☐
ST5551-060D3C.3Z5	SIRA	10303375	3	D	6,0	6,0	23,0	64,0	0,075	5	Weldon	☐
ST5551-080D3C.3Z5	SIRA	10303376	3	D	8,0	8,0	32,0	73,0	0,1	5	Weldon	☐
ST5551-100D3C.3Z5	SIRA	10303377	3	D	10,0	10,0	40,0	85,0	0,125	5	Weldon	☐
ST5551-120D3C.3Z5	SIRA	10303378	3	D	12,0	12,0	45,0	100,0	0,15	5	Weldon	☐
ST5551-160D3C.3Z5	SIRA	10303379	3	D	16,0	16,0	55,0	115,0	0,2	5	Weldon	☐
ST5551-200D3C.3Z5	SIRA	10303380	3	D	20,0	20,0	65,0	125,0	0,25	5	Weldon	☐
ST5551-250D3C.3Z5	SIRA	10303381	3	D	25,0	25,0	85,0	155,0	0,3	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă



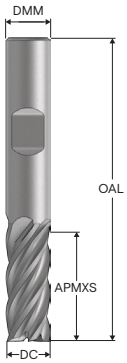
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.3Z5	SIRA	10303382	2	D	6,0	6,0	14,0	58,0	0,5	5	Weldon	☐
ST5551-080D2R050.3Z5	SIRA	10303383	2	D	8,0	8,0	18,0	64,0	0,5	5	Weldon	☐
ST5551-100D2R050.3Z5	SIRA	10303384	2	D	10,0	10,0	22,0	73,0	0,5	5	Weldon	☐
ST5551-120D2R050.3Z5	SIRA	10303385	2	D	12,0	12,0	26,0	84,0	0,5	5	Weldon	☐
ST5551-120D2R100.3Z5	SIRA	10303386	2	D	12,0	12,0	26,0	84,0	1,0	5	Weldon	☐
ST5551-160D2R050.3Z5	SIRA	10303387	2	D	16,0	16,0	34,0	95,0	0,5	5	Weldon	☐
ST5551-160D2R100.3Z5	SIRA	10303388	2	D	16,0	16,0	34,0	95,0	1,0	5	Weldon	☐
ST5551-200D2R050.3Z5	SIRA	10303389	2	D	20,0	20,0	42,0	109,0	0,5	5	Weldon	☐
ST5551-200D2R100.3Z5	SIRA	10303390	2	D	20,0	20,0	42,0	109,0	1,0	5	Weldon	☐
ST5551-250D2R050.3Z5	SIRA	10303391	2	D	25,0	25,0	52,0	125,0	0,5	5	Weldon	☐
ST5551-250D2R100.3Z5	SIRA	10303392	2	D	25,0	25,0	52,0	125,0	1,0	5	Weldon	☐
ST5551-060D3R050.3Z5	SIRA	10303393	3	D	6,0	6,0	23,0	64,0	0,5	5	Weldon	☐
ST5551-080D3R050.3Z5	SIRA	10303394	3	D	8,0	8,0	32,0	73,0	0,5	5	Weldon	☐
ST5551-100D3R050.3Z5	SIRA	10303395	3	D	10,0	10,0	40,0	85,0	0,5	5	Weldon	☐
ST5551-120D3R050.3Z5	SIRA	10303396	3	D	12,0	12,0	45,0	100,0	0,5	5	Weldon	☐
ST5551-120D3R100.3Z5	SIRA	10303397	3	D	12,0	12,0	45,0	100,0	1,0	5	Weldon	☐
ST5551-160D3R050.3Z5	SIRA	10303398	3	D	16,0	16,0	55,0	115,0	0,5	5	Weldon	☐
ST5551-160D3R100.3Z5	SIRA	10303399	3	D	16,0	16,0	55,0	115,0	1,0	5	Weldon	☐
ST5551-200D3R050.3Z5	SIRA	10303400	3	D	20,0	20,0	65,0	125,0	0,5	5	Weldon	☐
ST5551-200D3R100.3Z5	SIRA	10303401	3	D	20,0	20,0	65,0	125,0	1,0	5	Weldon	☐
ST5551-250D3R050.3Z5	SIRA	10303402	3	D	25,0	25,0	85,0	155,0	0,5	5	Weldon	☐
ST5551-250D3R100.3Z5	SIRA	10303403	3	D	25,0	25,0	85,0	155,0	1,0	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Ascuţit – Inci





—Toleranţe:
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—DC= + .000" / - .002"
—Reascuţire posibilă



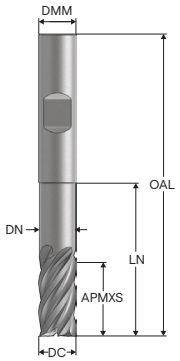
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
ST5551-.250D1S.3Z5	SIRA	10303194	1	D	0.250	0.250	0.375	2.000	5	Weldon	☐
ST5551-.375D1S.3Z5	SIRA	10303195	1	D	0.375	0.375	0.500	2.500	5	Weldon	☐
ST5551-.500D1S.3Z5	SIRA	10303196	1	D	0.500	0.500	0.625	3.000	5	Weldon	☐
ST5551-.625D1S.3Z5	SIRA	10303197	1	D	0.625	0.625	0.750	3.000	5	Weldon	☐
ST5551-.750D1S.3Z5	SIRA	10303198	1	D	0.750	0.750	0.875	3.000	5	Weldon	☐
ST5551-.313D2S.3Z5	SIRA	10303199	2	D	0.313	0.313	0.750	2.500	5	Weldon	☐
ST5551-.375D2S.3Z5	SIRA	10303200	2	D	0.375	0.375	0.875	2.500	5	Weldon	☐
ST5551-.500D2S.3Z5	SIRA	10303201	2	D	0.500	0.500	1.000	3.000	5	Weldon	☐
ST5551-.625D2S.3Z5	SIRA	10303202	2	D	0.625	0.625	1.250	3.500	5	Weldon	☐
ST5551-.750D2S.3Z5	SIRA	10303203	2	D	0.750	0.750	1.500	4.000	5	Weldon	☐
ST5551-.250D3S.3Z5	SIRA	10303204	3	D	0.250	0.250	0.750	2.500	5	Weldon	☐
ST5551-.500D3S.3Z5	SIRA	10303205	3	D	0.500	0.500	1.250	3.000	5	Weldon	☐
ST5551-.625D4S.3Z5	SIRA	10303211	4	D	0.625	0.625	1.625	3.500	5	Weldon	☐
ST5551-.625D5S.3Z5	SIRA	10303216	5	D	0.625	0.625	2.125	4.000	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Ascuţit – Inci





—Toleranţe:
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—DC= + .000" / - .002"
—Reascuţire posibilă



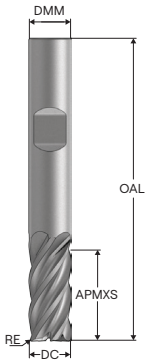
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci			
ST5551-.750E3S.3Z5	SIRA	10303206	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Weldon	☐
ST5551-.250E4S.3Z5	SIRA	10303207	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Weldon	☐
ST5551-.375E4S.3Z5	SIRA	10303208	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Weldon	☐
ST5551-.500E4S.3Z5	SIRA	10303209	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Weldon	☐
ST5551-.625E4S.3Z5	SIRA	10303210	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Weldon	☐
ST5551-.750E4S.3Z5	SIRA	10303212	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Weldon	☐
ST5551-.250E5S.3Z5	SIRA	10303213	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Weldon	☐
ST5551-.375E5S.3Z5	SIRA	10303214	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Weldon	☐
ST5551-.625E5S.3Z5	SIRA	10303215	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Weldon	☐
ST5551-.750E5S.3Z5	SIRA	10303217	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Weldon	☐
ST5551-.500E6S.3Z5	SIRA	10303218	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Weldon	☐
ST5551-.250E8S.3Z5	SIRA	10303219	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Weldon	☐
ST5551-.375E8S.3Z5	SIRA	10303220	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Weldon	☐
ST5551-.500E8S.3Z5	SIRA	10303221	8	E	0.500	0.500	0.625	6.000	4.109	0.480	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
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—RE= ±.0008"
—Reascuţire posibilă



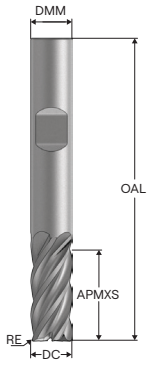
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5551-.250D1R015.3Z5	SIRA	10303222	1	D	0.250	0.250	0.375	2.000	0.015	5	Weldon	□
ST5551-.250D1R030.3Z5	SIRA	10303223	1	D	0.250	0.250	0.375	2.000	0.030	5	Weldon	□
ST5551-.250D1R045.3Z5	SIRA	10303224	1	D	0.250	0.250	0.375	2.000	0.045	5	Weldon	□
ST5551-.375D1R015.3Z5	SIRA	10303225	1	D	0.375	0.375	0.500	2.500	0.015	5	Weldon	□
ST5551-.375D1R030.3Z5	SIRA	10303226	1	D	0.375	0.375	0.500	2.500	0.030	5	Weldon	□
ST5551-.375D1R045.3Z5	SIRA	10303227	1	D	0.375	0.375	0.500	2.500	0.045	5	Weldon	□
ST5551-.500D1R015.3Z5	SIRA	10303228	1	D	0.500	0.500	0.625	3.000	0.015	5	Weldon	□
ST5551-.500D1R030.3Z5	SIRA	10303231	1	D	0.500	0.500	0.625	3.000	0.030	5	Weldon	□
ST5551-.500D1R045.3Z5	SIRA	10303229	1	D	0.500	0.500	0.625	3.000	0.045	5	Weldon	□
ST5551-.500D1R060.3Z5	SIRA	10303232	1	D	0.500	0.500	0.625	3.000	0.060	5	Weldon	□
ST5551-.500D1R120.3Z5	SIRA	10303230	1	D	0.500	0.500	0.625	3.000	0.120	5	Weldon	□
ST5551-.625D1R015.3Z5	SIRA	10303233	1	D	0.625	0.625	0.750	3.000	0.015	5	Weldon	□
ST5551-.625D1R030.3Z5	SIRA	10303235	1	D	0.625	0.625	0.750	3.000	0.030	5	Weldon	□
ST5551-.625D1R060.3Z5	SIRA	10303236	1	D	0.625	0.625	0.750	3.000	0.060	5	Weldon	□
ST5551-.625D1R120.3Z5	SIRA	10303234	1	D	0.625	0.625	0.750	3.000	0.120	5	Weldon	□
ST5551-.750D1R030.3Z5	SIRA	10303237	1	D	0.750	0.750	0.875	3.000	0.030	5	Weldon	□
ST5551-.750D1R060.3Z5	SIRA	10303238	1	D	0.750	0.750	0.875	3.000	0.060	5	Weldon	□
ST5551-.750D1R120.3Z5	SIRA	10303239	1	D	0.750	0.750	0.875	3.000	0.120	5	Weldon	□
ST5551-.313D2R015.3Z5	SIRA	10303240	2	D	0.313	0.313	0.750	2.500	0.015	5	Weldon	□
ST5551-.375D2R015.3Z5	SIRA	10303241	2	D	0.375	0.375	0.875	2.500	0.015	5	Weldon	□
ST5551-.375D2R030.3Z5	SIRA	10303242	2	D	0.375	0.375	0.875	2.500	0.030	5	Weldon	□
ST5551-.375D2R045.3Z5	SIRA	10303243	2	D	0.375	0.375	0.875	2.500	0.045	5	Weldon	□
ST5551-.375D2R060.3Z5	SIRA	10303244	2	D	0.375	0.375	0.875	2.500	0.060	5	Weldon	□
ST5551-.500D2R015.3Z5	SIRA	10303245	2	D	0.500	0.500	1.000	3.000	0.015	5	Weldon	□
ST5551-.500D2R030.3Z5	SIRA	10303246	2	D	0.500	0.500	1.000	3.000	0.030	5	Weldon	□
ST5551-.500D2R060.3Z5	SIRA	10303247	2	D	0.500	0.500	1.000	3.000	0.060	5	Weldon	□
ST5551-.625D2R015.3Z5	SIRA	10303248	2	D	0.625	0.625	1.250	3.500	0.015	5	Weldon	□
ST5551-.625D2R030.3Z5	SIRA	10303249	2	D	0.625	0.625	1.250	3.500	0.030	5	Weldon	□
ST5551-.625D2R045.3Z5	SIRA	10303250	2	D	0.625	0.625	1.250	3.500	0.045	5	Weldon	□
ST5551-.625D2R060.3Z5	SIRA	10303251	2	D	0.625	0.625	1.250	3.500	0.060	5	Weldon	□
ST5551-.625D2R090.3Z5	SIRA	10303252	2	D	0.625	0.625	1.250	3.500	0.090	5	Weldon	□
ST5551-.625D2R125.3Z5	SIRA	10303253	2	D	0.625	0.625	1.250	3.500	0.125	5	Weldon	□
ST5551-.750D2R030.3Z5	SIRA	10303254	2	D	0.750	0.750	1.500	4.000	0.030	5	Weldon	□
ST5551-.750D2R060.3Z5	SIRA	10303255	2	D	0.750	0.750	1.500	4.000	0.060	5	Weldon	□
ST5551-.750D2R090.3Z5	SIRA	10303256	2	D	0.750	0.750	1.500	4.000	0.090	5	Weldon	□
ST5551-.750D2R125.3Z5	SIRA	10303257	2	D	0.750	0.750	1.500	4.000	0.125	5	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf – Inci





– Toleranţe:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Reascuţire posibilă



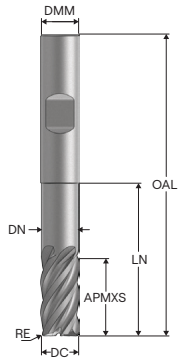
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5551-1.00D2R015.3Z5	SIRA	10303258	2	D	1.000	1.000	1.750	4.000	0.015	5	Weldon	☐
ST5551-1.00D2R030.3Z5	SIRA	10303259	2	D	1.000	1.000	1.750	4.000	0.030	5	Weldon	☐
ST5551-1.00D2R060.3Z5	SIRA	10303260	2	D	1.000	1.000	1.750	4.000	0.060	5	Weldon	☐
ST5551-.250D3R015.3Z5	SIRA	10303261	3	D	0.250	0.250	0.750	2.500	0.015	5	Weldon	☐
ST5551-.250D3R030.3Z5	SIRA	10303262	3	D	0.250	0.250	0.750	2.500	0.030	5	Weldon	☐
ST5551-.250D3R045.3Z5	SIRA	10303263	3	D	0.250	0.250	0.750	2.500	0.045	5	Weldon	☐
ST5551-.375D3R030.3Z5	SIRA	10303264	3	D	0.375	0.375	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R015.3Z5	SIRA	10303265	3	D	0.500	0.500	1.250	3.000	0.015	5	Weldon	☐
ST5551-.500D3R030.3Z5	SIRA	10303266	3	D	0.500	0.500	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R045.3Z5	SIRA	10303267	3	D	0.500	0.500	1.250	3.000	0.045	5	Weldon	☐
ST5551-.500D3R060.3Z5	SIRA	10303268	3	D	0.500	0.500	1.250	3.000	0.060	5	Weldon	☐
ST5551-.500D3R090.3Z5	SIRA	10303269	3	D	0.500	0.500	1.250	3.000	0.090	5	Weldon	☐
ST5551-.500D3R125.3Z5	SIRA	10303270	3	D	0.500	0.500	1.250	3.000	0.125	5	Weldon	☐
ST5551-.750D3R030.3Z5	SIRA	10303274	3	D	0.750	0.750	1.625	4.000	0.030	5	Weldon	☐
ST5551-.250D4R015.3Z5	SIRA	10303280	4	D	0.250	0.250	1.000	3.000	0.015	5	Weldon	☐
ST5551-.375D4R030.3Z5	SIRA	10303285	4	D	0.375	0.375	1.500	4.000	0.030	5	Weldon	☐
ST5551-.500D4R030.3Z5	SIRA	10303290	4	D	0.500	0.500	1.625	4.000	0.030	5	Weldon	☐
ST5551-.750D4R030.3Z5	SIRA	10303296	4	D	0.750	0.750	2.250	5.000	0.030	5	Weldon	☐
ST5551-.500D5R030.3Z5	SIRA	10303303	5	D	0.500	0.500	2.000	4.000	0.030	5	Weldon	☐
ST5551-.750D5R030.3Z5	SIRA	10303309	5	D	0.750	0.750	2.750	5.000	0.030	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
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—Reascuţire posibilă



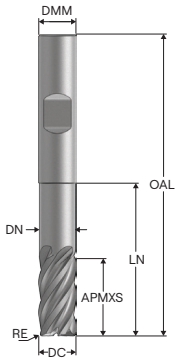
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5551-.750E3R030.3Z5	SIRA	10303271	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Weldon	□
ST5551-.750E3R060.3Z5	SIRA	10303272	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Weldon	□
ST5551-.750E3R120.3Z5	SIRA	10303273	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Weldon	□
ST5551-1.00E3R030.3Z5	SIRA	10303275	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Weldon	□
ST5551-1.00E3R060.3Z5	SIRA	10303276	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Weldon	□
ST5551-1.00E3R120.3Z5	SIRA	10303277	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Weldon	□
ST5551-.250E4R015.3Z5	SIRA	10303278	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Weldon	□
ST5551-.250E4R030.3Z5	SIRA	10303279	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Weldon	□
ST5551-.375E4R015.3Z5	SIRA	10303281	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Weldon	□
ST5551-.375E4R030.3Z5	SIRA	10303282	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Weldon	□
ST5551-.375E4R045.3Z5	SIRA	10303283	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Weldon	□
ST5551-.375E4R060.3Z5	SIRA	10303284	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Weldon	□
ST5551-.500E4R015.3Z5	SIRA	10303286	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Weldon	□
ST5551-.500E4R030.3Z5	SIRA	10303287	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Weldon	□
ST5551-.500E4R060.3Z5	SIRA	10303288	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Weldon	□
ST5551-.500E4R120.3Z5	SIRA	10303289	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Weldon	□
ST5551-.625E4R030.3Z5	SIRA	10303291	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Weldon	□
ST5551-.625E4R060.3Z5	SIRA	10303292	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Weldon	□
ST5551-.750E4R030.3Z5	SIRA	10303293	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Weldon	□
ST5551-.750E4R060.3Z5	SIRA	10303294	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Weldon	□
ST5551-.750E4R120.3Z5	SIRA	10303295	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
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—Reascuţire posibilă



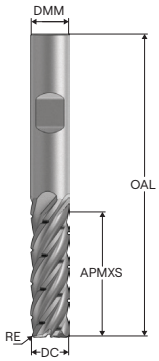
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5551-.250E5R015.3Z5	SIRA	10303297	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Weldon	☐
ST5551-.250E5R030.3Z5	SIRA	10303298	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Weldon	☐
ST5551-.375E5R015.3Z5	SIRA	10303299	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Weldon	☐
ST5551-.375E5R030.3Z5	SIRA	10303300	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Weldon	☐
ST5551-.375E5R045.3Z5	SIRA	10303301	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Weldon	☐
ST5551-.375E5R060.3Z5	SIRA	10303302	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Weldon	☐
ST5551-.625E5R030.3Z5	SIRA	10303304	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Weldon	☐
ST5551-.625E5R060.3Z5	SIRA	10303305	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Weldon	☐
ST5551-.750E5R030.3Z5	SIRA	10303306	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Weldon	☐
ST5551-.750E5R060.3Z5	SIRA	10303307	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Weldon	☐
ST5551-.750E5R120.3Z5	SIRA	10303308	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.120	5	Weldon	☐
ST5551-.500E6R015.3Z5	SIRA	10303310	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Weldon	☐
ST5551-.500E6R030.3Z5	SIRA	10303311	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Weldon	☐
ST5551-.500E6R060.3Z5	SIRA	10303312	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Weldon	☐
ST5551-.500E6R120.3Z5	SIRA	10303313	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Weldon	☐
ST5551-.250E8R015.3Z5	SIRA	10303314	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Weldon	☐
ST5551-.250E8R030.3Z5	SIRA	10303315	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Weldon	☐
ST5551-.375E8R015.3Z5	SIRA	10303316	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Weldon	☐
ST5551-.375E8R030.3Z5	SIRA	10303317	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Weldon	☐
ST5551-.375E8R045.3Z5	SIRA	10303318	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Weldon	☐
ST5551-.375E8R060.3Z5	SIRA	10303319	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Weldon	☐
ST5551-.500E8R015.3Z5	SIRA	10303320	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Weldon	☐
ST5551-.500E8R030.3Z5	SIRA	10303321	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Weldon	☐
ST5551-.500E8R060.3Z5	SIRA	10303322	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Weldon	☐
ST5551-.500E8R120.3Z5	SIRA	10303323	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

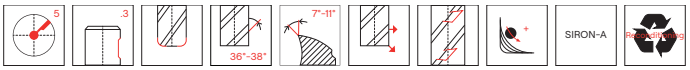
ST5551

Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
						inci	inci	inci	inci	inci			
ST5551-.250D3R015.3Z5C	SIRA	10303324	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Weldon	□
ST5551-.375D3R030.3Z5C	SIRA	10303325	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Weldon	□
ST5551-.500D3R030.3Z5C	SIRA	10303326	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Weldon	□
ST5551-.625D3R030.3Z5C	SIRA	10303327	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Weldon	□
ST5551-.750D3R030.3Z5C	SIRA	10303328	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Weldon	□
ST5551-.500D4R030.3Z5C	SIRA	10303329	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Weldon	□
ST5551-.750D4R030.3Z5C	SIRA	10303330	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Weldon	□
ST5551-.625D5R030.3Z5C	SIRA	10303331	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – ST5551 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,040 *0.0016*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,028 *0.0011*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	110 (85 — 140) *360 (280 — 450)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	110 (85 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	95 (75 — 120) *310 (250 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – ST5551 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	0,022 *0.00085*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5551 Frezare laterală degroşare avansată a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
P1	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	215 (170 — 260) *710 (560 — 850)*
P2	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	210 (170 — 260) *690 (560 — 850)*
P3	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
P4	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	160 (130 — 190) *520 (430 — 620)*
P5	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P6	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	170 (140 — 210) *560 (460 — 680)*
P7	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 200) *520 (430 — 650)*
P8	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P11	M/A/D/E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	2,0 *2.0*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	90 (78 — 100) *295 (260 — 320)*
M1	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (150 — 190) *560 (500 — 620)*
M2	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (120 — 150) *460 (400 — 490)*
M3	E	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	110 (93 — 120) *360 (310 — 390)*
M4	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (71 — 94) *260 (240 — 300)*
M5	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	70 (59 — 79) *230 (200 — 250)*
K1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
K2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 190) *510 (400 — 620)*
K3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	135 (110 — 160) *445 (370 — 520)*
K4	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	125 (97 — 160) *410 (320 — 520)*
K5	E	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (58 — 96) *245 (200 — 310)*
K6	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	130 (110 — 160) *425 (370 — 520)*
K7	E	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	115 (88 — 140) *375 (290 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – ST5551 Frezare laterală degroșare avansată a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	0,032 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5551 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 140) *360 (280 — 450)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	95 (75 — 120) *310 (250 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – ST5551 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5551 Frezare laterală degroşare avansată a_e/DC = 0,10

SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	215 (170 — 260) *710 (560 — 850)*
P2	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	210 (170 — 260) *690 (560 — 850)*
P3	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	180 (140 — 220) *590 (460 — 720)*
P4	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 190) *520 (430 — 620)*
P5	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P6	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	170 (140 — 210) *560 (460 — 680)*
P7	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 200) *520 (430 — 650)*
P8	M/A/D/E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	155 (120 — 180) *510 (400 — 590)*
P11	M/A/D/E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	2,0 *2.0*	0,017 *0.00065*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	90 (78 — 100) *295 (260 — 320)*
M1	E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	170 (150 — 190) *560 (500 — 620)*
M2	E	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (120 — 150) *460 (400 — 490)*
M3	E	2,0 *2.0*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	110 (93 — 120) *360 (310 — 390)*
M4	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (71 — 94) *260 (240 — 300)*
M5	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	70 (59 — 79) *230 (200 — 250)*
K1	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
K2	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	155 (120 — 190) *510 (400 — 620)*
K3	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	135 (110 — 160) *445 (370 — 520)*
K4	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	125 (97 — 160) *410 (320 — 520)*
K5	E	2,0 *2.0*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (58 — 96) *245 (200 — 310)*
K6	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*	130 (110 — 160) *425 (370 — 520)*
K7	E	2,0 *2.0*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	115 (88 — 140) *375 (290 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – ST5551 Frezare laterală degroșare avansată a_e/DC = 0,10

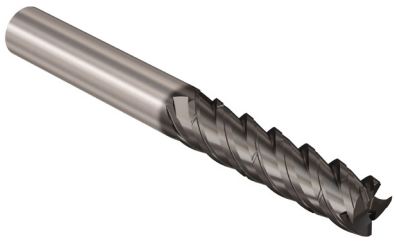
SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

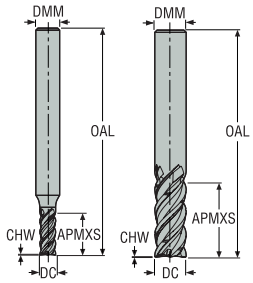
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

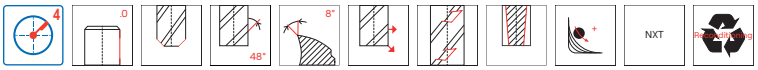
JS564

Degroşare avansată – Universale – Pătrat – 4 Caneluri – Cilindrică – Şanfren





—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă dacă DC este ≥ Ø8

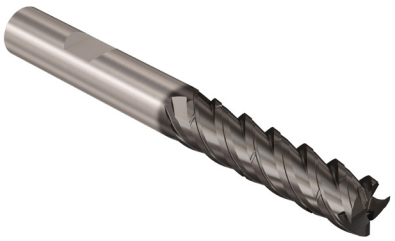


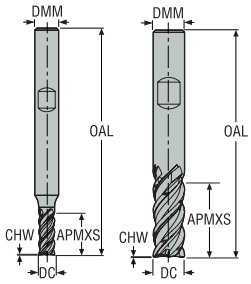
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Cylindrical	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Cylindrical	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Cylindrical	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Cylindrical	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Cylindrical	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Cylindrical	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Cylindrical	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Cylindrical	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Cylindrical	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Cylindrical	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Cylindrical	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Cylindrical	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Cylindrical	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Cylindrical	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Cylindrical	■
JS564060D4C.0Z4C-NXT	10273179	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Cylindrical	■
JS564080D4C.0Z4C-NXT	10273180	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Cylindrical	■
JS564100D4C.0Z4C-NXT	10273181	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Cylindrical	■
JS564120D4C.0Z4C-NXT	10273182	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Cylindrical	■
JS564160D4C.0Z4C-NXT	10273183	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Cylindrical	■
JS564200D4C.0Z4C-NXT	10273184	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Cylindrical	■
JS564250D4C.0Z4C-NXT	10273185	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Cylindrical	■

■ **Stoc standard.**

JS564

Degroșare avansată – Universale – Pătrat – 4 Caneluri – Weldon – Șanfren





—Toleranțe:
—DMM= h5
—DC e7
—Reascuțire posibilă dacă DC este ≥ Ø8

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Weldon	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Weldon	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Weldon	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Weldon	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Weldon	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Weldon	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Weldon	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Weldon	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Weldon	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Weldon	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Weldon	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Weldon	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Weldon	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Weldon	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Weldon	■
JS564060D4C.3Z4C-NXT	10273186	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Weldon	□
JS564080D4C.3Z4C-NXT	10273187	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Weldon	□
JS564100D4C.3Z4C-NXT	10273188	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Weldon	□
JS564120D4C.3Z4C-NXT	10273189	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Weldon	□
JS564160D4C.3Z4C-NXT	10273190	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Weldon	□
JS564200D4C.3Z4C-NXT	10273191	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Weldon	□
JS564250D4C.3Z4C-NXT	10273192	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JS564 Frezare laterală degroşare avansată

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	305 (270 — 340) *1000 (890 — 1100)*
P2	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	295 (260 — 330) *970 (860 — 1000)*
P3	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (230 — 290) *850 (760 — 950)*
P4	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P5	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	215 (190 — 240) *710 (630 — 780)*
P6	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	240 (210 — 270) *790 (690 — 880)*
P7	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P8	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	215 (190 — 240) *710 (630 — 780)*
P11	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	200 (180 — 220) *660 (600 — 720)*
P12	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (120 — 140) *425 (400 — 450)*
M1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	195 (170 — 210) *640 (560 — 680)*
M2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 170) *520 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	260 (230 — 290) *850 (760 — 950)*
K2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
K3	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	195 (170 — 210) *640 (560 — 680)*
K4	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (170 — 200) *610 (560 — 650)*
K5	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	115 (99 — 120) *375 (330 — 390)*
K6	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
K7	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS564 Frezare laterală degroșare avansată

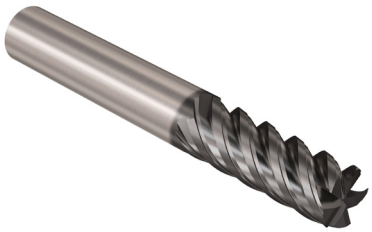
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600 — 790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	450 (390 — 510) *1475 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	350 (300 — 390) *1150 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	60 (37 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	50 (30 — 69) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	43 (26 — 60) *140 (86 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.018 *0,00070*	0.024 *0,00095*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	125 (110 — 140) *410 (370 — 450)*

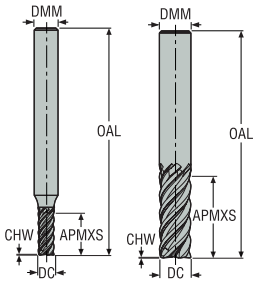
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

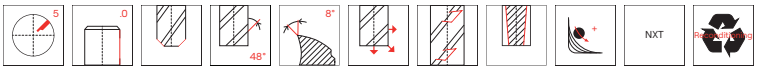
JS565

Degroşare avansată – Universale – Pătrat – 5 Caneluri – Cilindrică – Şanfren





– Toleranţe:
– DMM= h5
– DC e7
– Reascuţire posibilă dacă DC este ≥ Ø8



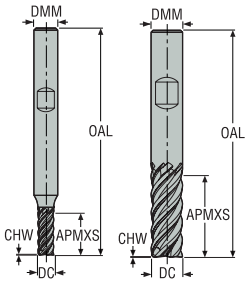
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Cylindrical	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Cylindrical	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Cylindrical	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Cylindrical	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Cylindrical	■
JS565060D4C.0Z5C-NXT	10273193	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Cylindrical	■
JS565080D4C.0Z5C-NXT	10273194	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Cylindrical	■
JS565100D4C.0Z5C-NXT	10273195	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Cylindrical	■
JS565120D4C.0Z5C-NXT	10273196	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Cylindrical	■
JS565160D4C.0Z5C-NXT	10273197	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Cylindrical	■
JS565200D4C.0Z5C-NXT	10273198	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Cylindrical	■
JS565250D4C.0Z5C-NXT	10273199	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Cylindrical	■

■ **Stoc standard.**

JS565

Degroșare avansată – Universale – Pătrat – 5 Caneluri – Weldon – Șanfren





—Toleranțe:
—DMM= h5
—DC e7
—Reascuțire posibilă dacă DC este ≥ Ø8

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Weldon	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Weldon	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Weldon	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Weldon	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Weldon	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Weldon	■
JS565060D4C.3Z5C-NXT	10273200	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Weldon	□
JS565080D4C.3Z5C-NXT	10273201	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Weldon	□
JS565100D4C.3Z5C-NXT	10273202	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Weldon	□
JS565120D4C.3Z5C-NXT	10273203	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Weldon	□
JS565160D4C.3Z5C-NXT	10273204	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Weldon	□
JS565200D4C.3Z5C-NXT	10273205	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Weldon	□
JS565250D4C.3Z5C-NXT	10273206	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JS565 Frezare laterală degroşare avansată

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	325 (270 — 340) *1075 (890 — 1100)*
P2	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	315 (260 — 330) *1025 (860 — 1000)*
P3	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	280 (230 — 290) *920 (760 — 950)*
P4	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P5	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	230 (190 — 240) *750 (630 — 780)*
P6	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	260 (210 — 270) *850 (690 — 880)*
P7	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P8	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	230 (190 — 240) *750 (630 — 780)*
P11	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	225 (190 — 230) *740 (630 — 750)*
P12	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	140 (120 — 140) *460 (400 — 450)*
M1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	205 (180 — 210) *670 (600 — 680)*
M2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	170 (140 — 170) *560 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	275 (230 — 290) *900 (760 — 950)*
K2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
K3	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	205 (170 — 210) *670 (560 — 680)*
K4	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	200 (170 — 200) *660 (560 — 650)*
K5	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	120 (98 — 120) *395 (330 — 390)*
K6	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 180) *570 (500 — 590)*
K7	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (130 — 160) *510 (430 — 520)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS565 Frezare laterală degroșare avansată

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600 — 790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	475 (390 — 510) *1550 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	370 (300 — 390) *1225 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	60 (38 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	50 (30 — 70) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	43 (27 — 60) *140 (89 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	155 (140 — 180) *510 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (110 — 140) *395 (370 — 450)*

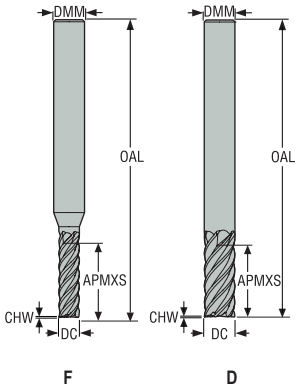
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

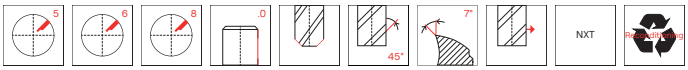
JS520

Înaltă performanţă – Universale – Pătrat – 5-8 Caneluri – Cilindrică – Şanfren





– Toleranţe:
– DMM=h5
– DC=e7
– Reascuţire posibilă dacă DC este ≥ Ø6



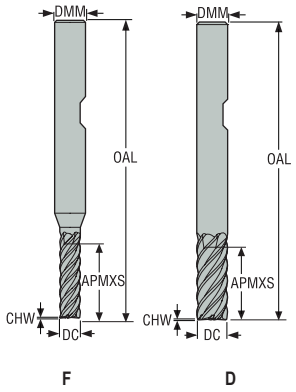
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	Cylindrical	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	Cylindrical	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	Cylindrical	■
JS520060D2C.0Z6-NXT	02927479	2	D	6,0	6,0	15,0	57,0	0,06	6	Cylindrical	■
JS520080D2C.0Z5-NXT	02927482	2	D	8,0	8,0	20,0	63,0	0,08	5	Cylindrical	■
JS520080D2C.0Z6-NXT	02927483	2	D	8,0	8,0	20,0	63,0	0,08	6	Cylindrical	■
JS520100D2C.0Z6-NXT	02927486	2	D	10,0	10,0	25,0	72,0	0,1	6	Cylindrical	■
JS520120D2C.0Z6-NXT	02927488	2	D	12,0	12,0	25,0	83,0	0,12	6	Cylindrical	■
JS520140D2C.0Z6-NXT	02927490	2	D	14,0	14,0	30,0	83,0	0,14	6	Cylindrical	■
JS520160D2C.0Z6-NXT	02927491	2	D	16,0	16,0	30,0	92,0	0,16	6	Cylindrical	■
JS520160D2C.0Z8-NXT	02927492	2	D	16,0	16,0	30,0	92,0	0,16	8	Cylindrical	■
JS520200D2C.0Z8-NXT	02927495	2	D	20,0	20,0	35,0	104,0	0,2	8	Cylindrical	■
JS520250D2C.0Z8-NXT	02927497	2	D	25,0	25,0	50,0	125,0	0,25	8	Cylindrical	■
JS520040F3C.0Z5-NXT	02927475	3	F	4,0	6,0	15,0	57,0	0,04	5	Cylindrical	■
JS520050F3C.0Z5-NXT	02927477	3	F	5,0	6,0	19,0	57,0	0,05	5	Cylindrical	■
JS520060D3C.0Z5-NXT	02927480	3	D	6,0	6,0	20,0	63,0	0,06	5	Cylindrical	■
JS520060D3C.0Z6-NXT	02927481	3	D	6,0	6,0	20,0	63,0	0,06	6	Cylindrical	■
JS520080D3C.0Z5-NXT	02927484	3	D	8,0	8,0	30,0	80,0	0,08	5	Cylindrical	■
JS520080D3C.0Z6-NXT	02927485	3	D	8,0	8,0	30,0	80,0	0,08	6	Cylindrical	■
JS520100D3C.0Z6-NXT	02927487	3	D	10,0	10,0	40,0	89,0	0,1	6	Cylindrical	■
JS520120D3C.0Z6-NXT	02927489	3	D	12,0	12,0	45,0	100,0	0,12	6	Cylindrical	■
JS520160D3C.0Z6-NXT	02927493	3	D	16,0	16,0	65,0	125,0	0,16	6	Cylindrical	■
JS520160D3C.0Z8-NXT	02927494	3	D	16,0	16,0	65,0	125,0	0,16	8	Cylindrical	■
JS520200D3C.0Z8-NXT	02927496	3	D	20,0	20,0	65,0	125,0	0,2	8	Cylindrical	■
JS520250D3C.0Z8-NXT	02927498	3	D	25,0	25,0	75,0	150,0	0,25	8	Cylindrical	■

■ **Stoc standard.**

JS520

Înaltă performanţă – Universale – Pătrat – 5-8 Caneluri – Weldon – Şanfren





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS520040F2C.3Z5-NXT	02927499	2	F	4,0	6,0	10,0	57,0	0,04	5	Weldon	□
JS520050F2C.3Z5-NXT	02927501	2	F	5,0	6,0	12,0	57,0	0,05	5	Weldon	□
JS520060D2C.3Z5-NXT	02927503	2	D	6,0	6,0	15,0	57,0	0,06	5	Weldon	□
JS520060D2C.3Z6-NXT	02927504	2	D	6,0	6,0	15,0	57,0	0,06	6	Weldon	□
JS520080D2C.3Z5-NXT	02927507	2	D	8,0	8,0	20,0	63,0	0,08	5	Weldon	□
JS520080D2C.3Z6-NXT	02927508	2	D	8,0	8,0	20,0	63,0	0,08	6	Weldon	■
JS520100D2C.3Z6-NXT	02927511	2	D	10,0	10,0	25,0	72,0	0,1	6	Weldon	■
JS520120D2C.3Z6-NXT	02927513	2	D	12,0	12,0	25,0	83,0	0,12	6	Weldon	■
JS520140D2C.3Z6-NXT	02927515	2	D	14,0	14,0	30,0	83,0	0,14	6	Weldon	□
JS520160D2C.3Z6-NXT	02927516	2	D	16,0	16,0	30,0	92,0	0,16	6	Weldon	□
JS520160D2C.3Z8-NXT	02927517	2	D	16,0	16,0	30,0	92,0	0,16	8	Weldon	■
JS520200D2C.3Z8-NXT	02927520	2	D	20,0	20,0	35,0	104,0	0,2	8	Weldon	■
JS520250D2C.3Z8-NXT	02927522	2	D	25,0	25,0	50,0	125,0	0,25	8	Weldon	■
JS520040F3C.3Z5-NXT	02927500	3	F	4,0	6,0	15,0	57,0	0,04	5	Weldon	□
JS520050F3C.3Z5-NXT	02927502	3	F	5,0	6,0	19,0	57,0	0,05	5	Weldon	□
JS520060D3C.3Z5-NXT	02927505	3	D	6,0	6,0	20,0	63,0	0,06	5	Weldon	□
JS520060D3C.3Z6-NXT	02927506	3	D	6,0	6,0	20,0	63,0	0,06	6	Weldon	□
JS520080D3C.3Z5-NXT	02927509	3	D	8,0	8,0	30,0	80,0	0,08	5	Weldon	□
JS520080D3C.3Z6-NXT	02927510	3	D	8,0	8,0	30,0	80,0	0,08	6	Weldon	□
JS520100D3C.3Z6-NXT	02927512	3	D	10,0	10,0	40,0	89,0	0,1	6	Weldon	□
JS520120D3C.3Z6-NXT	02927514	3	D	12,0	12,0	45,0	100,0	0,12	6	Weldon	□
JS520160D3C.3Z6-NXT	02927518	3	D	16,0	16,0	65,0	125,0	0,16	6	Weldon	□
JS520160D3C.3Z8-NXT	02927519	3	D	16,0	16,0	65,0	125,0	0,16	8	Weldon	□
JS520200D3C.3Z8-NXT	02927521	3	D	20,0	20,0	65,0	125,0	0,2	8	Weldon	■
JS520250D3C.3Z8-NXT	02927523	3	D	25,0	25,0	75,0	150,0	0,25	8	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS520 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (120 — 250) *590 (400 — 820)*
P2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
P3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (95 — 210) *510 (320 — 680)*
P4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (84 — 180) *445 (280 — 590)*
P5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	130 (81 — 180) *425 (270 — 590)*
P6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (90 — 200) *475 (300 — 650)*
P7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (85 — 190) *460 (280 — 620)*
P8	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	130 (80 — 170) *425 (270 — 550)*
P11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	195 (160 — 230) *640 (530 — 750)*
P12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
M1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (130 — 180) *490 (430 — 590)*
M2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 150) *410 (330 — 490)*
M3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	100 (75 — 120) *330 (250 — 390)*
M4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (58 — 96) *245 (200 — 310)*
M5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (49 — 80) *215 (170 — 260)*
K1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
K2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	155 (97 — 210) *510 (320 — 680)*
K3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (82 — 180) *445 (270 — 590)*
K4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (79 — 170) *410 (260 — 550)*
K5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (48 — 100) *245 (160 — 320)*
K6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (69 — 150) *360 (230 — 490)*
K7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (62 — 130) *330 (210 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS520 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
N2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	320 (290 — 350) *1050 (960 — 1100)*
N3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	215 (200 — 230) *710 (660 — 750)*
N11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	75 (63 — 86) *245 (210 — 280)*
S2	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (50 — 70) *195 (170 — 220)*
S3	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	40 (30 — 49) *130 (99 — 160)*
S11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	105 (92 — 110) *345 (310 — 360)*
S12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	80 (71 — 90) *260 (240 — 290)*
S13	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*
H5	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (64 — 180) *410 (210 — 590)*
H8	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H11	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	160 (81 — 240) *520 (270 — 780)*
H12	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (76 — 220) *490 (250 — 720)*
H21	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H31	M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (51 — 150) *330 (170 — 490)*
TS1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
TP1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	395 (350 — 440) *1300 (1200 — 1400)*
GR1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*

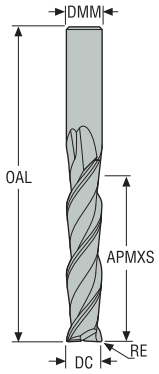
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

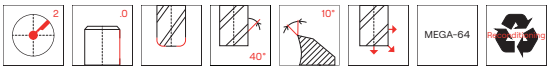
JS522

Înaltă performanţă – Universale – Pătrat – 2 Caneluri – Prag înalt – Cilindrică – Rază la vârf





D



- Toleranţe:
- Bătaie radială= Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM= h5
- DC -0,02/-0,04 mm
- RE= 0,1+0,1 mm, RE= 0,5 ±0,03 mm
  RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm
  RE= 6 ±0,05 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
522060R010Z2.0-MEGA-64	02747756	4	D	6,0	6,0	30,0	80,0	0,1	2	Cylindrical	■
522080R010Z2.0-MEGA-64	02747763	4	D	8,0	8,0	40,0	85,0	0,1	2	Cylindrical	■
522100R010Z2.0-MEGA-64	02747765	4	D	10,0	10,0	50,0	100,0	0,1	2	Cylindrical	■
522120R010Z2.0-MEGA-64	02747766	4	D	12,0	12,0	60,0	115,0	0,1	2	Cylindrical	■
522160R050Z2.0-MEGA-64	02747767	4	D	16,0	16,0	80,0	150,0	0,5	2	Cylindrical	■
522160R310Z2.0-MEGA-64	02747768	4	D	16,0	16,0	80,0	150,0	3,1	2	Cylindrical	■
JS522160D4R600.0Z2-M64	03093681	4	D	16,0	16,0	80,0	150,0	6,0	2	Cylindrical	■
522200R050Z2.0-MEGA-64	02747769	4	D	20,0	20,0	100,0	175,0	0,5	2	Cylindrical	■
522200R310Z2.0-MEGA-64	02747770	4	D	20,0	20,0	100,0	175,0	3,1	2	Cylindrical	■
JS522200D4R600.0Z2-M64	03093682	4	D	20,0	20,0	100,0	175,0	6,0	2	Cylindrical	■
522250R050Z2.0-MEGA-64	02747771	4	D	25,0	25,0	125,0	205,0	0,5	2	Cylindrical	■
522250R310Z2.0-MEGA-64	02747772	4	D	25,0	25,0	125,0	205,0	3,1	2	Cylindrical	■
522250R400Z2.0-MEGA-64	02747773	4	D	25,0	25,0	125,0	205,0	4,0	2	Cylindrical	■
JS522250D4R600.0Z2-M64	03093683	4	D	25,0	25,0	125,0	205,0	6,0	2	Cylindrical	■
522320R050Z2.0-MEGA-64	02747774	4	D	32,0	32,0	160,0	245,0	0,5	2	Cylindrical	■
522320R400Z2.0-MEGA-64	02747775	4	D	32,0	32,0	160,0	245,0	4,0	2	Cylindrical	■
JS522320D4R600.0Z2-M64	03093684	4	D	32,0	32,0	160,0	245,0	6,0	2	Cylindrical	■

■ **Stoc standard.**

*JS522 long flute finisher, with its special geometry designed to machine high shoulders with exellent surface finish and perpendicularity.

Parametri de așchiere – JS522 Semifinisare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
P1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	160 (140 — 170) *520 (460 — 550)*
P2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	120 (110 — 140) *395 (370 — 450)*
P7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	115 (95 — 130) *375 (320 — 420)*
P8	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	105 (89 — 120) *345 (300 — 390)*
P11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	105 (87 — 120) *345 (290 — 390)*
P12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (55 — 75) *215 (190 — 240)*
M1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (86 — 130) *360 (290 — 420)*
M2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (71 — 110) *295 (240 — 360)*
M3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	80 (61 — 100) *260 (210 — 320)*
M4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	60 (47 — 76) *195 (160 — 240)*
M5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (39 — 63) *165 (130 — 200)*
K1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 98) *280 (240 — 320)*
K5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (81 — 120) *330 (270 — 390)*
K6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (110 — 150) *425 (370 — 490)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JS522 Semifinisare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (210 — 400) *980 (690 — 1300)*
N3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	200 (140 — 260) *660 (460 — 850)*
N11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (260 — 350) *980 (860 — 1100)*
S1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	48 (39 — 57) *155 (130 — 180)*
S2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	39 (31 — 46) *130 (110 — 150)*
S3	E/M/A	0.0300 *0,0300*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	42 (32 — 51) *140 (110 — 160)*
S11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
S12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	95 (77 — 110) *310 (260 — 360)*
S13	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (61 — 90) *245 (210 — 290)*
TS1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*
TP1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
GR1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*

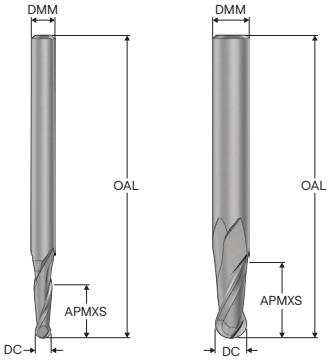
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

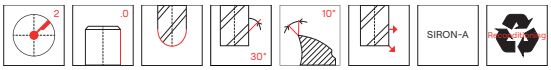
C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică





—Toleranţe:
—DMM=h5
—DC= h10
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø10



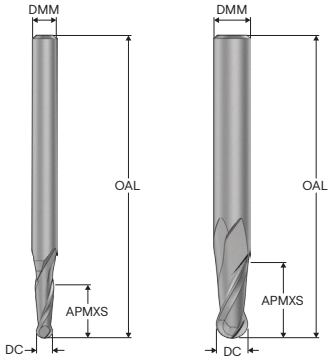
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
C5321-060D1B.0Z2	SIRA	10268679	1	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
C5321-020F2B.0Z2	SIRA	10268669	2	F	2,0	3,0	4,0	38,0	1,0	2	Cylindrical	■
C5321-030D2B.0Z2	SIRA	10268672	2	D	3,0	3,0	6,0	38,0	1,5	2	Cylindrical	■
C5321-040D2B.0Z2	SIRA	10268675	2	D	4,0	4,0	8,0	50,0	2,0	2	Cylindrical	■
C5321-050F2B.0Z2	SIRA	10268677	2	F	5,0	6,0	10,0	57,0	2,5	2	Cylindrical	■
C5321-060D2B.0Z2	SIRA	10268680	2	D	6,0	6,0	12,0	57,0	3,0	2	Cylindrical	■
C5321-080D2B.0Z2	SIRA	10268682	2	D	8,0	8,0	16,0	63,0	4,0	2	Cylindrical	■
C5321-090F2B.0Z2	SIRA	10268684	2	F	9,0	10,0	22,0	72,0	4,5	2	Cylindrical	■
C5321-100D2B.0Z2	SIRA	10268685	2	D	10,0	10,0	22,0	72,0	5,0	2	Cylindrical	■
C5321-120D2B.0Z2	SIRA	10268687	2	D	12,0	12,0	25,0	83,0	6,0	2	Cylindrical	■
C5321-015F3B.0Z2	SIRA	10268668	3	F	1,5	3,0	4,5	38,0	0,75	2	Cylindrical	■
C5321-020F3B.0Z2	SIRA	10268670	3	F	2,0	3,0	6,3	38,0	1,0	2	Cylindrical	■
C5321-035F3B.0Z2	SIRA	10268674	3	F	3,5	4,0	12,0	50,0	1,75	2	Cylindrical	■
C5321-050F3B.0Z2	SIRA	10268678	3	F	5,0	6,0	16,0	57,0	2,5	2	Cylindrical	■
C5321-060D3B.0Z2	SIRA	10268681	3	D	6,0	6,0	19,0	63,0	3,0	2	Cylindrical	■
C5321-080D3B.0Z2	SIRA	10268683	3	D	8,0	8,0	20,0	63,0	4,0	2	Cylindrical	■
C5321-010F4B.0Z2	SIRA	10268667	4	F	1,0	3,0	4,0	38,0	0,5	2	Cylindrical	■
C5321-030D4B.0Z2	SIRA	10268673	4	D	3,0	3,0	12,0	38,0	1,5	2	Cylindrical	■
C5321-040D4B.0Z2	SIRA	10268676	4	D	4,0	4,0	14,0	50,0	2,0	2	Cylindrical	■
C5321-100D4B.0Z2	SIRA	10268686	4	D	10,0	10,0	35,0	89,0	5,0	2	Cylindrical	■
C5321-120D4B.0Z2	SIRA	10268688	4	D	12,0	12,0	50,0	100,0	6,0	2	Cylindrical	■

■ **Stoc standard.**

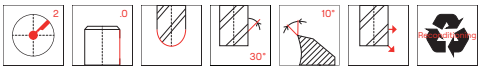
C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Reascuţire posibilă dacă DC este ≥ Ø.375

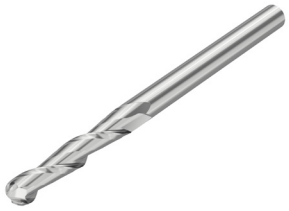


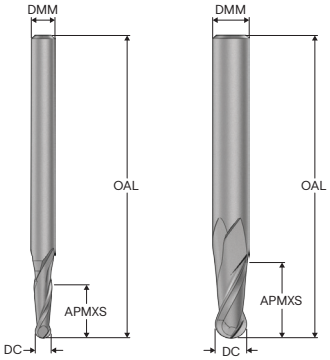
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
C5321-.500D1B.0Z2	10268913	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-1.000D1B.0Z2	10268923	1	D	1.000	1.000	1.500	4.000	0.500	2	Cylindrical	■
C5321-.016F2B.0Z2	10268878	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	10268881	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	10268883	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	10268886	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	10268888	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	10268891	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	10268896	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	10268899	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	10268908	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	10268914	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	10268919	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	10268921	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	10268879	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	10268882	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	10268884	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	10268887	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	10268889	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	10268895	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	10268897	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	10268900	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	10268905	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	10268909	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	10268915	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	10268922	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Stoc standard.**

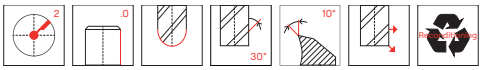
C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Reascuţire posibilă dacă DC este ≥ Ø.375



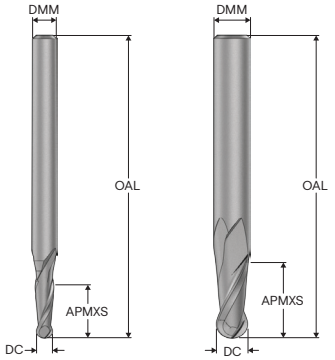
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				inci	inci	inci	inci	inci			
C5321-.031F4B.0Z2	10268880	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	10268885	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	10268890	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	10268892	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	10268898	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	10268901	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	10268910	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	10268916	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	10268893	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	10268902	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	10268906	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	10268917	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	10268894	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	10268903	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	10268911	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	10268918	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.375D7B.0Z2	10268912	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

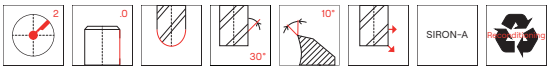
■ **Stoc standard.**

C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică – Inci







—Toleranţe:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Reascuţire posibilă dacă DC este ≥ Ø.375

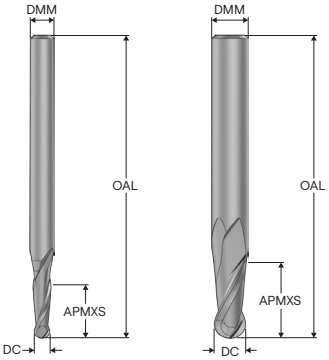
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5321-.500D1B.0Z2	SIRA	10268630	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-.750D1B.0Z2	SIRA	10268637	1	D	0.750	0.750	1.000	3.000	0.375	2	Cylindrical	■
C5321-.016F2B.0Z2	SIRA	10268595	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	SIRA	10268598	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	SIRA	10268600	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	SIRA	10268603	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	SIRA	10268605	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	SIRA	10268608	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	SIRA	10268613	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	SIRA	10268616	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	SIRA	10268625	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	SIRA	10268631	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	SIRA	10268636	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	SIRA	10268638	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	SIRA	10268596	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	SIRA	10268599	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	SIRA	10268601	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	SIRA	10268604	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	SIRA	10268606	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	SIRA	10268612	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	SIRA	10268614	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	SIRA	10268617	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	SIRA	10268622	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	SIRA	10268626	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	SIRA	10268632	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	SIRA	10268639	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Stoc standard.**

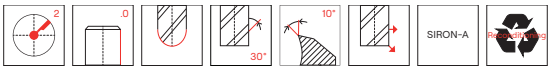
C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică – Inci





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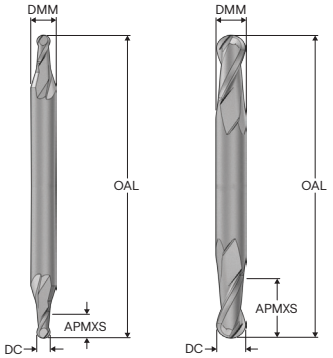
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5321-.031F4B.0Z2	SIRA	10268597	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	SIRA	10268602	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	SIRA	10268607	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	SIRA	10268609	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	SIRA	10268615	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	SIRA	10268618	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	SIRA	10268627	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	SIRA	10268633	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	SIRA	10268610	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	SIRA	10268619	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	SIRA	10268623	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	SIRA	10268634	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	SIRA	10268611	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	SIRA	10268620	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	SIRA	10268628	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	SIRA	10268635	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.313D7B.0Z2	SIRA	10268624	7	D	0.313	0.313	1.625	4.000	0.156	2	Cylindrical	■
C5321-.375D7B.0Z2	SIRA	10268629	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

■ **Stoc standard.**

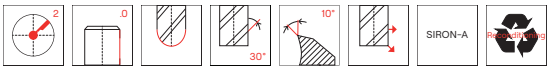
C5321

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică – Inci





– Toleranţe:
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– DC ≤ Ø7/64" = ±.0005"
– DC > Ø7/64" = +.000"/-.002"
– RE= ±.0005"
– Două capete
– Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5321-.031F2B.0Z2D	SIRA	10268656	2	F	0.031	0.125	0.063	1.500	0.016	2	Cylindrical	■
C5321-.047F2B.0Z2D	SIRA	10268657	2	F	0.047	0.125	0.094	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2D	SIRA	10268658	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2D	SIRA	10268659	2	F	0.078	0.125	0.125	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2D	SIRA	10268660	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2D	SIRA	10268661	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2D	SIRA	10268662	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2D	SIRA	10268663	2	D	0.250	0.250	0.500	2.500	0.125	2	Cylindrical	■
C5321-.313D2B.0Z2D	SIRA	10268664	2	D	0.313	0.313	0.500	2.500	0.156	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – C5321 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	150 (135 — 165) *490 (440— 540)*
P2	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	58 (45— 70) *190 (147 — 230)*
P3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	55 (45— 65) *180 (147 — 213)*
M1	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	55 (45 —65) *180 (147 — 213)*
M4	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,10 *0.10*	1,0 *1.0*	0,0034 *0.00013*	0,005 *0.00020*	0,0065 *0.00026*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,10 *0.10*	1,0 *1.0*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,044 *0.0017*	0,05 *0.0020*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,10 *0.10*	1,0 *1.0*	0,0028 *0.00011*	0,004 *0.00016*	0,0055 *0.00022*	0,008 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,10 *0.10*	1,0 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	110 (95— 120) *360 (311 — 390)*
S12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	30 (20 — 40) *100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – C5321 Degroşare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z												v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	150 (135 — 165)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*490 (440— 540)*
P2	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	58 (45— 70)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	100 (90 — 110)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	68 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	87 (77 — 100)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*280 (230 — 310)*
P12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	55 (45— 65)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*180 (147 — 213)*
M1	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	93 (83 — 100)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*305 (270 — 360)*
M2	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	60 (50 — 70)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*200 (165 — 230)*
M3	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	55 (45 —65)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*180 (147 — 213)*
M4	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	45 (35 — 55)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0026	0,0055	0,011	0,013	0,016	0,019	0,022	0,026	0,032	0,042	0,048	0,055	0,065	35 (20 — 45)
		0.10	*1.0*	*0.00010*	*0.00022*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0019*	*0.0022*	*0.0026*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	80 (70 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,042	0,055	0,065	0,07	0,085	87 (75 — 100)
		0.10	*1.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0017*	*0.0022*	*0.0026*	*0.0028*	*0.0034*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	50 (35 — 65)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	45 (30 — 55)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (65 — 85)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (200 — 290)*
S1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	50 (35 — 60)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0022	0,0044	0,009	0,011	0,013	0,015	0,018	0,022	0,026	0,034	0,04	0,044	0,055	25 (15 — 35)
		0.10	*1.0*	*0.000085*	*0.00017*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0022*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0014	0,0028	0,0055	0,007	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,034	11 (7,5 — 16)
		0.10	*1.0*	*0.000055*	*0.00011*	*0.00022*	*0.00028*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*35 (25 — 52)*
S11	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	110 (95— 120)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*360 (311 — 390)*
S12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	77 (60 — 90)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*250 (190 — 290)*
S13	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	30 (20 — 40)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*100 (65 — 130)*

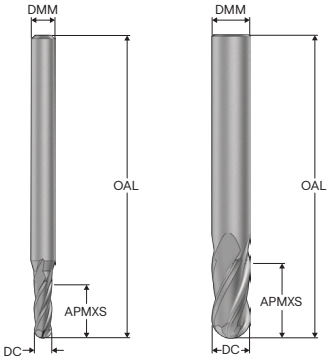
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

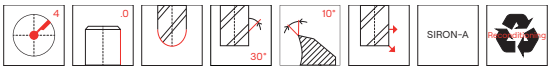
C5341

Uz general – Universale – Cap sferic – 4 Caneluri – Cilindrică





—Toleranţe:
—DMM=h5
—DC= h10
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø10



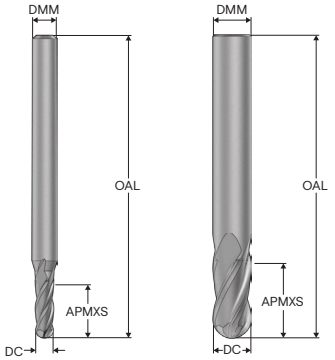
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
C5341-020F2B.0Z4	SIRA	10268568	2	F	2,0	3,0	4,0	39,0	1,0	4	Cylindrical	■
C5341-030D2B.0Z4	SIRA	10268570	2	D	3,0	3,0	6,0	39,0	1,5	4	Cylindrical	■
C5341-040D2B.0Z4	SIRA	10268573	2	D	4,0	4,0	8,0	50,0	2,0	4	Cylindrical	■
C5341-050F2B.0Z4	SIRA	10268575	2	D	5,0	6,0	10,0	57,0	2,5	4	Cylindrical	■
C5341-060D1B.0Z4	SIRA	10268577	2	D	6,0	6,0	9,0	51,0	3,0	4	Cylindrical	■
C5341-060D2B.0Z4	SIRA	10268578	2	D	6,0	6,0	12,0	57,0	3,0	4	Cylindrical	■
C5341-080D2B.0Z4	SIRA	10268580	2	D	8,0	8,0	16,0	63,0	4,0	4	Cylindrical	■
C5341-090F2B.0Z4	SIRA	10268581	2	F	9,0	10,0	22,0	72,0	4,5	4	Cylindrical	■
C5341-100D2B.0Z4	SIRA	10268582	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
C5341-120D2B.0Z4	SIRA	10268584	2	D	12,0	12,0	25,0	74,0	6,0	4	Cylindrical	■
C5341-160D2B.0Z4	SIRA	10268586	2	D	16,0	16,0	32,0	92,0	8,0	4	Cylindrical	■
C5341-200D2B.0Z4	SIRA	10268588	2	D	20,0	20,0	35,0	104,0	10,0	4	Cylindrical	■
C5341-015F3B.0Z4	SIRA	10268567	3	F	1,5	3,0	4,5	38,0	0,75	4	Cylindrical	■
C5341-020F3B.0Z4	SIRA	10268569	3	F	2,0	3,0	6,3	38,0	1,0	4	Cylindrical	■
C5341-035F3B.0Z4	SIRA	10268572	3	F	3,5	4,0	12,0	50,0	1,5	4	Cylindrical	■
C5341-050F3B.0Z4	SIRA	10268576	3	F	5,0	6,0	16,0	51,0	2,5	4	Cylindrical	■
C5341-060D3B.0Z4	SIRA	10268579	3	D	6,0	6,0	19,0	51,0	3,0	4	Cylindrical	■
C5341-160D3B.0Z4	SIRA	10268587	3	D	16,0	16,0	50,0	115,0	8,0	4	Cylindrical	■
C5341-200D3B.0Z4	SIRA	10268589	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■
C5341-010F4B.0Z4	SIRA	10268566	4	F	1,0	3,0	4,0	39,0	0,5	4	Cylindrical	■
C5341-030D4B.0Z4	SIRA	10268571	4	D	3,0	3,0	12,0	39,0	1,5	4	Cylindrical	■
C5341-040D4B.0Z4	SIRA	10268574	4	D	4,0	4,0	14,0	51,0	2,0	4	Cylindrical	■
C5341-100D4B.0Z4	SIRA	10268583	4	D	10,0	10,0	35,0	89,0	5,0	4	Cylindrical	■
C5341-120D4B.0Z4	SIRA	10268585	4	D	12,0	12,0	50,0	100,0	6,0	4	Cylindrical	■

■ **Stoc standard.**

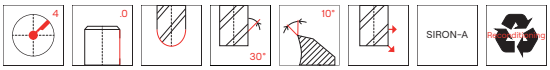
C5341

Uz general – Universale – Cap sferic – 4 Caneluri – Cilindrică – Inci





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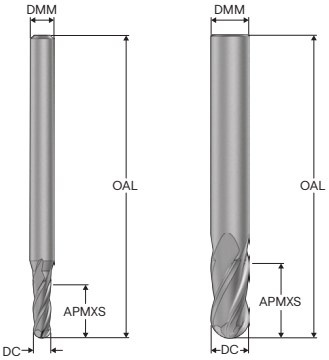
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5341-.500D1B.0Z4	SIRA	10268532	1	D	0.500	0.500	0.625	2.500	0.250	4	Cylindrical	■
C5341-.625D1B.0Z4	SIRA	10268539	1	D	0.625	0.625	0.750	3.000	0.313	4	Cylindrical	■
C5341-.750D1B.0Z4	SIRA	10268543	1	D	0.750	0.750	1.000	3.000	0.375	4	Cylindrical	■
C5341-.016F2B.0Z4	SIRA	10268474	2	F	0.016	0.125	0.031	1.500	0.008	4	Cylindrical	■
C5341-.047F2B.0Z4	SIRA	10268477	2	F	0.047	0.125	0.109	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4	SIRA	10268479	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4	SIRA	10268483	2	F	0.078	0.125	0.188	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4	SIRA	10268485	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4	SIRA	10268490	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4	SIRA	10268497	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.188D2B.0Z4	SIRA	10268500	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4	SIRA	10268508	2	D	0.250	0.250	0.500	2.000	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4	SIRA	10268515	2	D	0.313	0.313	0.500	2.000	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4	SIRA	10268521	2	D	0.375	0.375	0.625	2.000	0.188	4	Cylindrical	■
C5341-.406F2B.0Z4	SIRA	10268528	2	F	0.406	0.438	1.000	2.750	0.203	4	Cylindrical	■
C5341-.438D2B.0Z4	SIRA	10268529	2	D	0.438	0.438	1.000	2.750	0.219	4	Cylindrical	■
C5341-.500D2B.0Z4	SIRA	10268533	2	D	0.500	0.500	1.000	3.000	0.250	4	Cylindrical	■
C5341-.563D2B.0Z4	SIRA	10268538	2	D	0.563	0.563	1.125	3.500	0.281	4	Cylindrical	■
C5341-.625D2B.0Z4	SIRA	10268540	2	D	0.625	0.625	1.250	3.500	0.313	4	Cylindrical	■
C5341-.750D2B.0Z4	SIRA	10268544	2	D	0.750	0.750	1.500	4.000	0.375	4	Cylindrical	■
C5341-.875D2B.0Z4	SIRA	10268548	2	D	0.875	0.875	1.500	4.000	0.438	4	Cylindrical	■
C5341-1.000D2B.0Z4	SIRA	10268549	2	D	1.000	1.000	1.500	4.000	0.500	4	Cylindrical	■

■ **Stoc standard.**

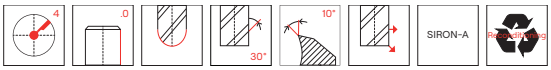
C5341

Uz general – Universale – Cap sferic – 4 Caneluri – Cilindrică – Inci





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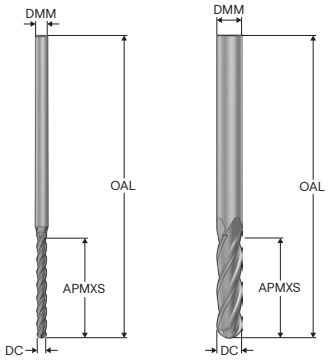
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5341-.031F3B.0Z4	SIRA	10268475	3	F	0.031	0.125	0.078	1.500	0.016	4	Cylindrical	■
C5341-.047F3B.0Z4	SIRA	10268478	3	F	0.047	0.125	0.125	1.500	0.023	4	Cylindrical	■
C5341-.063F3B.0Z4	SIRA	10268480	3	F	0.063	0.125	0.188	1.500	0.031	4	Cylindrical	■
C5341-.078F3B.0Z4	SIRA	10268484	3	F	0.078	0.125	0.250	1.500	0.039	4	Cylindrical	■
C5341-.094F3B.0Z4	SIRA	10268486	3	F	0.094	0.125	0.281	1.500	0.047	4	Cylindrical	■
C5341-.109F3B.0Z4	SIRA	10268489	3	F	0.109	0.125	0.375	1.500	0.055	4	Cylindrical	■
C5341-.156F3B.0Z4	SIRA	10268498	3	F	0.156	0.188	0.500	2.000	0.078	4	Cylindrical	■
C5341-.188D3B.0Z4	SIRA	10268501	3	D	0.188	0.188	0.625	2.000	0.094	4	Cylindrical	■
C5341-.203F3B.0Z4	SIRA	10268505	3	F	0.203	0.250	0.625	2.500	0.102	4	Cylindrical	■
C5341-.219F3B.0Z4	SIRA	10268506	3	F	0.219	0.250	0.625	2.500	0.109	4	Cylindrical	■
C5341-.234F3B.0Z4	SIRA	10268507	3	F	0.234	0.250	0.750	2.500	0.117	4	Cylindrical	■
C5341-.250D3B.0Z4	SIRA	10268509	3	D	0.250	0.250	0.750	2.500	0.125	4	Cylindrical	■
C5341-.281F3B.0Z4	SIRA	10268514	3	F	0.281	0.313	0.750	2.500	0.141	4	Cylindrical	■
C5341-.313D3B.0Z4	SIRA	10268516	3	D	0.313	0.313	0.813	2.500	0.156	4	Cylindrical	■
C5341-.328F3B.0Z4	SIRA	10268519	3	F	0.328	0.375	1.000	2.500	0.164	4	Cylindrical	■
C5341-.344F3B.0Z4	SIRA	10268520	3	F	0.344	0.375	1.000	2.500	0.172	4	Cylindrical	■
C5341-.375D3B.0Z4	SIRA	10268522	3	D	0.375	0.375	1.000	2.500	0.188	4	Cylindrical	■
C5341-.438D3B.0Z4	SIRA	10268530	3	D	0.438	0.438	1.000	4.000	0.219	4	Cylindrical	■
C5341-.500D3B.0Z4	SIRA	10268534	3	D	0.500	0.500	1.000	4.000	0.250	4	Cylindrical	■
C5341-.625D3B.0Z4	SIRA	10268541	3	D	0.625	0.625	2.000	6.000	0.313	4	Cylindrical	■
C5341-.750D3B.0Z4	SIRA	10268545	3	D	0.750	0.750	2.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D3B.0Z4	SIRA	10268550	3	D	1.000	1.000	2.000	6.000	0.500	4	Cylindrical	■
C5341-.031F4B.0Z4	SIRA	10268476	4	F	0.031	0.125	0.094	1.500	0.016	4	Cylindrical	■
C5341-.063F4B.0Z4	SIRA	10268481	4	F	0.063	0.125	0.250	1.500	0.031	4	Cylindrical	■
C5341-.094F4B.0Z4	SIRA	10268487	4	F	0.094	0.125	0.375	1.500	0.047	4	Cylindrical	■
C5341-.125D4B.0Z4	SIRA	10268491	4	D	0.125	0.125	0.500	1.500	0.063	4	Cylindrical	■
C5341-.141F4B.0Z4	SIRA	10268496	4	F	0.141	0.188	0.500	2.000	0.070	4	Cylindrical	■
C5341-.172F4B.0Z4	SIRA	10268499	4	F	0.172	0.188	0.625	2.000	0.086	4	Cylindrical	■
C5341-.188D4B.0Z4	SIRA	10268502	4	D	0.188	0.188	1.000	3.000	0.094	4	Cylindrical	■
C5341-.250D4B.0Z4	SIRA	10268510	4	D	0.250	0.250	1.000	3.000	0.125	4	Cylindrical	■
C5341-.313D4B.0Z4	SIRA	10268517	4	D	0.313	0.313	1.000	3.000	0.156	4	Cylindrical	■
C5341-.375D4B.0Z4	SIRA	10268523	4	D	0.375	0.375	1.000	3.000	0.188	4	Cylindrical	■
C5341-.500D4B.0Z4	SIRA	10268535	4	D	0.500	0.500	1.500	6.000	0.250	4	Cylindrical	■
C5341-.750D4B.0Z4	SIRA	10268546	4	D	0.750	0.750	3.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D4B.0Z4	SIRA	10268551	4	D	1.000	1.000	3.000	6.000	0.500	4	Cylindrical	■

■ **Stoc standard.**

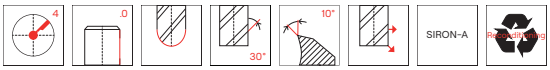
C5341

Uz general – Universale – Cap sferic – 4 Caneluri – Cilindrică – Inci





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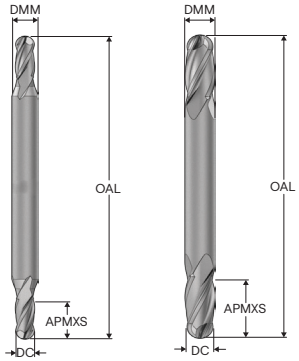
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5341-.125D5B.0Z4	SIRA	10268492	5	D	0.125	0.125	0.625	2.000	0.063	4	Cylindrical	■
C5341-.188D5B.0Z4	SIRA	10268503	5	D	0.188	0.188	1.000	4.000	0.094	4	Cylindrical	■
C5341-.250D5B.0Z4	SIRA	10268511	5	D	0.250	0.250	1.000	4.000	0.125	4	Cylindrical	■
C5341-.375D5B.0Z4	SIRA	10268524	5	D	0.375	0.375	1.000	4.000	0.188	4	Cylindrical	■
C5341-.500D5B.0Z4	SIRA	10268536	5	D	0.500	0.500	2.000	4.000	0.250	4	Cylindrical	■
C5341-.625D5B.0Z4	SIRA	10268542	5	D	0.625	0.625	3.000	6.000	0.313	4	Cylindrical	■
C5341-.750D5B.0Z4	SIRA	10268547	5	D	0.750	0.750	4.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D5B.0Z4	SIRA	10268552	5	D	1.000	1.000	4.000	7.000	0.500	4	Cylindrical	■
C5341-.125D6B.0Z4	SIRA	10268493	6	D	0.125	0.125	0.750	3.000	0.063	4	Cylindrical	■
C5341-.188D6B.0Z4	SIRA	10268504	6	D	0.188	0.188	1.125	3.000	0.094	4	Cylindrical	■
C5341-.250D6B.0Z4	SIRA	10268512	6	D	0.250	0.250	1.500	4.000	0.125	4	Cylindrical	■
C5341-.313D6B.0Z4	SIRA	10268518	6	D	0.313	0.313	1.500	6.000	0.156	4	Cylindrical	■
C5341-.375D6B.0Z4	SIRA	10268525	6	D	0.375	0.375	1.500	6.000	0.188	4	Cylindrical	■
C5341-.500D6B.0Z4	SIRA	10268537	6	D	0.500	0.500	3.000	6.000	0.250	4	Cylindrical	■
C5341-.125D7B.0Z4	SIRA	10268494	7	D	0.125	0.125	1.000	3.000	0.063	4	Cylindrical	■
C5341-.250D7B.0Z4	SIRA	10268513	7	D	0.250	0.250	1.500	6.000	0.125	4	Cylindrical	■
C5341-.375D7B.0Z4	SIRA	10268526	7	D	0.375	0.375	2.000	4.000	0.188	4	Cylindrical	■
C5341-.063F8B.0Z4	SIRA	10268482	8	F	0.063	0.125	1.000	3.000	0.031	4	Cylindrical	■
C5341-.094F8B.0Z4	SIRA	10268488	8	F	0.094	0.125	1.000	3.000	0.047	4	Cylindrical	■
C5341-.125D8B.0Z4	SIRA	10268495	8	D	0.125	0.125	1.000	4.000	0.063	4	Cylindrical	■
C5341-.375D8B.0Z4	SIRA	10268527	8	D	0.375	0.375	3.000	6.000	0.188	4	Cylindrical	■

■ **Stoc standard.**

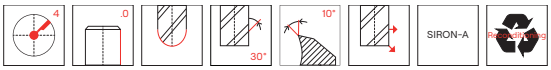
C5341

Uz general – Universale – Cap sferic – 4 Caneluri – Cilindrică – Inci





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Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
C5341-.500D1B.0Z4D	SIRA	10268565	1	D	0.500	0.500	0.625	3.000	0.250	4	Cylindrical	■
C5341-.031F2B.0Z4D	SIRA	10268553	2	F	0.031	0.125	0.063	1.500	0.016	4	Cylindrical	■
C5341-.047F2B.0Z4D	SIRA	10268554	2	F	0.047	0.125	0.094	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4D	SIRA	10268555	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4D	SIRA	10268556	2	F	0.078	0.125	0.125	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4D	SIRA	10268557	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4D	SIRA	10268558	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4D	SIRA	10268559	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.172F2B.0Z4D	SIRA	10268560	2	F	0.172	0.188	0.313	2.000	0.086	4	Cylindrical	■
C5341-.188D2B.0Z4D	SIRA	10268561	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4D	SIRA	10268562	2	D	0.250	0.250	0.500	2.500	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4D	SIRA	10268563	2	D	0.313	0.313	0.500	2.500	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4D	SIRA	10268564	2	D	0.375	0.375	0.563	2.500	0.188	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – C5341 Degroşare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	150 (135 — 165)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*490 (440— 540)*
P2	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	58 (45— 70)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	100 (90 — 110)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	68 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	87 (77 — 100)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*280 (230 — 310)*
P12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	55 (45— 65)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*180 (147 — 213)*
M1	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	93 (83 — 100)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*305 (270 — 360)*
M2	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	60 (50 — 70)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*200 (165 — 230)*
M3	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	55 (45 —65)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*180 (147 — 213)*
M4	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	45 (35 — 55)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0034	0,005	0,0065	0,01	0,012	0,013	0,017	0,02	0,026	0,03	0,034	0,04	0,05	0,055	35 (20 — 45)
		0.10	*1.0*	*0.00013*	*0.00020*	*0.00026*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	80 (70 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,04	0,044	0,05	0,065	0,075	87 (75 — 100)
		0.10	*1.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	50 (35 — 65)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	45 (30 — 55)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (65 — 85)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (60 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (200 — 290)*
S1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	50 (35 — 60)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0028	0,004	0,0055	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,032	0,04	0,046	25 (15 — 35)
		0.10	*1.0*	*0.00011*	*0.00016*	*0.00022*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*0.0016*	*0.0018*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,025	0,03	11 (7,5 — 16)
		0.10	*1.0*	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*35 (25 — 52)*
S11	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	110 (95— 120)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*360 (311 — 390)*
S12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*250 (190 — 290)*
S13	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	30 (20 — 40)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*100 (65 — 130)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – C5341 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	0,08 *0.0032*	150 (135 — 165) *490 (440— 540)*
P2	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	58 (45— 70) *190 (147 — 230)*
P3	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,10 *0.10*	1,0 *1.0*	0,002 *0.000080*	0,004 *0.00016*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	55 (45— 65) *180 (147 — 213)*
M1	E	0,10 *0.10*	1,0 *1.0*	0,003 *0.00012*	0,006 *0.00024*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,03 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,10 *0.10*	1,0 *1.0*	0,003 *0.00012*	0,006 *0.00024*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,03 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,10 *0.10*	1,0 *1.0*	0,003 *0.00012*	0,006 *0.00024*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,03 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	55 (45 —65) *180 (147 — 213)*
M4	E	0,10 *0.10*	1,0 *1.0*	0,003 *0.00012*	0,006 *0.00024*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,03 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,10 *0.10*	1,0 *1.0*	0,0026 *0.00010*	0,0055 *0.00022*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,10 *0.10*	1,0 *1.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,07 *0.0028*	0,085 *0.0034*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	0,08 *0.0032*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,10 *0.10*	1,0 *1.0*	0,0022 *0.000085*	0,0044 *0.00017*	0,009 *0.00036*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,044 *0.0017*	0,055 *0.0022*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,10 *0.10*	1,0 *1.0*	0,0014 *0.000055*	0,0028 *0.00011*	0,0055 *0.00022*	0,007 *0.00028*	0,008 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,028 *0.0011*	0,034 *0.0013*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,10 *0.10*	1,0 *1.0*	0,003 *0.00012*	0,006 *0.00024*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,024 *0.00095*	0,03 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	110 (95— 120) *360 (311 — 390)*
S12	E	0,10 *0.10*	1,0 *1.0*	0,002 *0.000080*	0,004 *0.00016*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,10 *0.10*	1,0 *1.0*	0,002 *0.000080*	0,004 *0.00016*	0,008 *0.00032*	0,01 *0.00040*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	30 (20 — 40) *100 (65 — 130)*

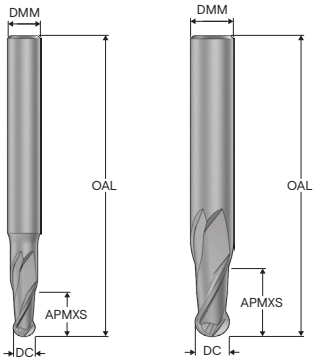
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

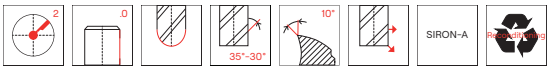
JSB512

Uz general – Universale – Cap sferic – 2 Caneluri – Cilindrică





F D



– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø10

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	1,0	2	Cylindrical	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	1,5	2	Cylindrical	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2,0	2	Cylindrical	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2,5	2	Cylindrical	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	4,0	2	Cylindrical	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	5,0	2	Cylindrical	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	6,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JSB512 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P2	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P3	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P4	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P5	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P6	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P7	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P8	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P11	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
P12	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M2	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M3	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M4	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M5	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
K1	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K2	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K3	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K4	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K5	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K7	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
N1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	500 (380 — 620) *1650 (1300 — 2000)*
N11	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	375 (260 — 500) *1225 (860 — 1600)*
S11	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (66 — 130) *295 (220 — 420)*
S12	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
S13	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*

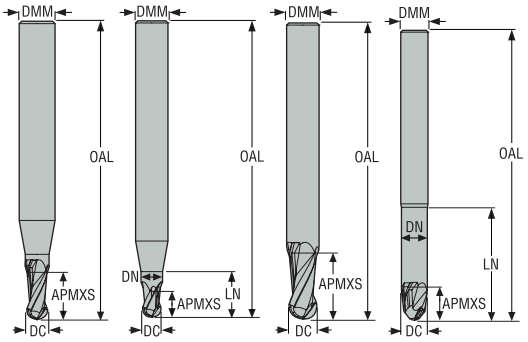
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

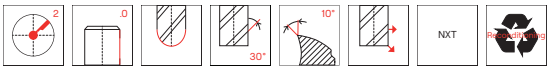
JS532

Înaltă performanţă – Universale – Cap sferic – 2 Caneluri – Cilindrică





– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



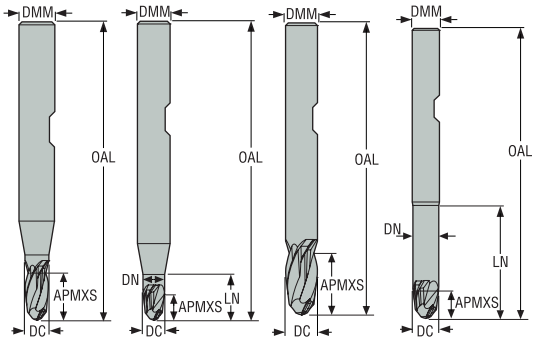
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	–	–	0,5	2	Cylindrical	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	–	–	0,75	2	Cylindrical	■
JS532020F1B.0Z2-NXT	02928195	1	F	2,0	3,0	4,0	38,0	–	–	1,0	2	Cylindrical	■
JS532025F1B.0Z2-NXT	02928197	1	F	2,5	3,0	5,0	38,0	–	–	1,25	2	Cylindrical	■
JS532030D1B.0Z2-NXT	02928199	1	D	3,0	3,0	6,0	38,0	–	–	1,5	2	Cylindrical	■
JS532035F1B.0Z2-NXT	02928202	1	F	3,5	6,0	7,0	57,0	–	–	1,75	2	Cylindrical	■
JS532040F1B.0Z2-NXT	02928203	1	F	4,0	6,0	8,0	57,0	–	–	2,0	2	Cylindrical	■
JS532045F1B.0Z2-NXT	02928206	1	F	4,5	6,0	9,0	57,0	–	–	2,25	2	Cylindrical	■
JS532050F1B.0Z2-NXT	02928207	1	F	5,0	6,0	10,0	57,0	–	–	2,5	2	Cylindrical	■
JS532060D1B.0Z2-NXT	02928210	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	Cylindrical	■
JS532080D1B.0Z2-NXT	02928213	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	Cylindrical	■
JS532100D1B.0Z2-NXT	02928216	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	Cylindrical	■
JS532120D1B.0Z2-NXT	02928219	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	Cylindrical	■
JS532160D1B.0Z2-NXT	02928222	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	Cylindrical	■
JS532200D1B.0Z2-NXT	02928225	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	Cylindrical	■
JS532020G2B.0Z2-NXT	02928196	2	G	2,0	3,0	2,0	38,0	8,0	1,9	1,0	2	Cylindrical	■
JS532030E2B.0Z2-NXT	02928200	2	E	3,0	3,0	3,0	38,0	10,0	2,85	1,5	2	Cylindrical	■
JS532040G2B.0Z2-NXT	02928204	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	2	Cylindrical	■
JS532050G2B.0Z2-NXT	02928208	2	G	5,0	6,0	5,0	57,0	20,0	4,8	2,5	2	Cylindrical	■
JS532060E2B.0Z2-NXT	02928211	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	Cylindrical	■
JS532080E2B.0Z2-NXT	02928214	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	Cylindrical	■
JS532100E2B.0Z2-NXT	02928217	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	Cylindrical	■
JS532120E2B.0Z2-NXT	02928220	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	Cylindrical	■
JS532160E2B.0Z2-NXT	02928223	2	E	16,0	16,0	16,0	125,0	72,0	15,2	8,0	2	Cylindrical	■
JS532030E3B.0Z2-NXT	02928201	3	E	3,0	3,0	3,0	52,0	20,0	2,85	1,5	2	Cylindrical	■
JS532040G3B.0Z2-NXT	02928205	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	Cylindrical	■
JS532050G3B.0Z2-NXT	02928209	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	Cylindrical	■
JS532060E3B.0Z2-NXT	02928212	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	Cylindrical	■
JS532080E3B.0Z2-NXT	02928215	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	Cylindrical	■
JS532100E3B.0Z2-NXT	02928218	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	Cylindrical	■
JS532120E3B.0Z2-NXT	02928221	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	Cylindrical	■
JS532160E3B.0Z2-NXT	02928224	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	Cylindrical	■

■ **Stoc standard.**

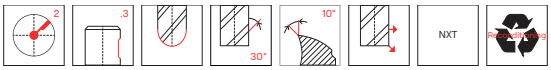
JS532

Înaltă performanţă – Universale – Cap sferic – 2 Caneluri – Weldon





—Toleranţe:
—DMM=h5
—DC=e8
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS532035F1B.3Z2-NXT	02928254	1	F	3,5	6,0	7,0	57,0	–	–	1,75	2	Weldon	■
JS532040F1B.3Z2-NXT	02928255	1	F	4,0	6,0	8,0	57,0	–	–	2,0	2	Weldon	□
JS532045F1B.3Z2-NXT	02928258	1	F	4,5	6,0	9,0	57,0	–	–	2,25	2	Weldon	□
JS532050F1B.3Z2-NXT	02928259	1	F	5,0	6,0	10,0	57,0	–	–	2,5	2	Weldon	□
JS532060D1B.3Z2-NXT	02928263	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	Weldon	□
JS532080D1B.3Z2-NXT	02928266	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	Weldon	□
JS532100D1B.3Z2-NXT	02928269	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	Weldon	□
JS532120D1B.3Z2-NXT	02928272	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	Weldon	□
JS532160D1B.3Z2-NXT	02928275	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	Weldon	□
JS532200D1B.3Z2-NXT	02928278	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	Weldon	□
JS532040G2B.3Z2-NXT	02928256	2	G	4,0	6,0	4,0	57,0	18,0	3,8	2,0	2	Weldon	□
JS532050G2B.3Z2-NXT	02928260	2	G	5,0	6,0	5,0	57,0	18,0	4,8	2,5	2	Weldon	□
JS532060E2B.3Z2-NXT	02928264	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	Weldon	□
JS532080E2B.3Z2-NXT	02928267	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	Weldon	□
JS532100E2B.3Z2-NXT	02928270	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	Weldon	□
JS532120E2B.3Z2-NXT	02928273	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	Weldon	□
JS532160E2B.3Z2-NXT	02928276	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	2	Weldon	□
JS532040G3B.3Z2-NXT	02928257	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	Weldon	□
JS532050G3B.3Z2-NXT	02928261	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	Weldon	□
JS532060E3B.3Z2-NXT	02928265	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	Weldon	□
JS532080E3B.3Z2-NXT	02928268	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	Weldon	□
JS532100E3B.3Z2-NXT	02928271	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	Weldon	□
JS532120E3B.3Z2-NXT	02928274	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	Weldon	□
JS532160E3B.3Z2-NXT	02928277	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS532 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	205 (140 — 180) *670 (460 — 590)*
P2	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	200 (130 — 180) *660 (430 — 590)*
P3	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	170 (110 — 150) *560 (370 — 490)*
P4	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.10 *0,0040*	150 (97 — 130) *490 (320 — 420)*
P5	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	145 (93 — 130) *475 (310 — 420)*
P6	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	160 (110 — 140) *520 (370 — 450)*
P7	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (98 — 140) *490 (330 — 450)*
P8	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	145 (93 — 130) *475 (310 — 420)*
P11	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	170 (110 — 150) *560 (370 — 490)*
P12	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	100 (64 — 92) *330 (210 — 300)*
M1	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	195 (170 — 220) *640 (560 — 720)*
M2	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	115 (93 — 130) *375 (310 — 420)*
M3	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	95 (73 — 110) *310 (240 — 360)*
M4	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	70 (55 — 85) *230 (190 — 270)*
M5	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	60 (46 — 71) *195 (160 — 230)*
K1	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	195 (180 — 210) *640 (600 — 680)*
K2	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	170 (160 — 180) *560 (530 — 590)*
K3	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	145 (130 — 150) *475 (430 — 490)*
K4	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	140 (130 — 150) *460 (430 — 490)*
K5	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	165 (150 — 180) *540 (500 — 590)*
K6	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	245 (220 — 270) *800 (730 — 880)*
K7	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	210 (190 — 230) *690 (630 — 750)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS532 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	610 (520 — 710) *2000 (1800 — 2300)*
N2	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.200 *0,200*	0.30 *0,30*	0.0050 *0,00020*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	415 (370 — 460) *1350 (1300 — 1500)*
S1	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	60 (52 — 72) *195 (180 — 230)*
S2	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	50 (42 — 58) *165 (140 — 190)*
S3	E	0.100 *0,100*	0.10 *0,10*	0.0036 *0,00014*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.018 *0,00070*	0.020 *0,00080*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	32 (22 — 42) *105 (73 — 130)*
S11	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (94 — 110) *345 (310 — 360)*
S12	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (72 — 92) *260 (240 — 300)*
S13	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.080 *0,0032*	0.090 *0,0036*	65 (57 — 72) *215 (190 — 230)*
TS1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
TP1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
GR1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*

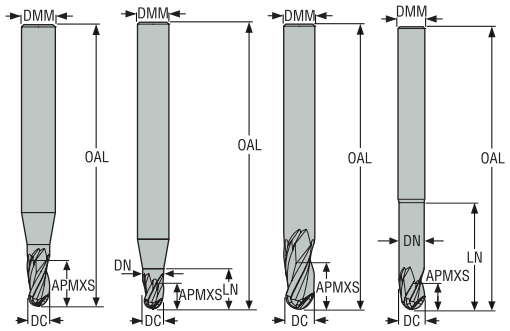
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

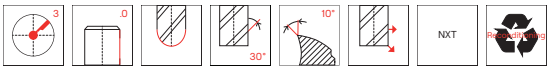
JS533

Înaltă performanţă – Universale – Cap sferic – 3 Caneluri – Cilindrică





– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



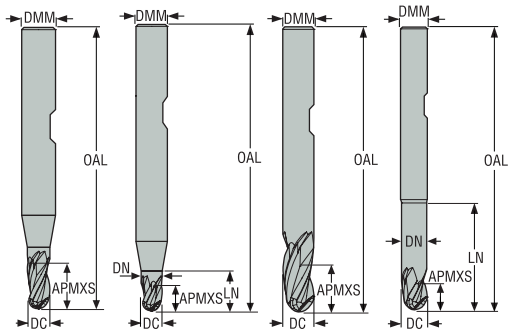
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	–	–	0,5	3	Cylindrical	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	–	–	0,75	3	Cylindrical	■
JS533020F1B.0Z3-NXT	02928287	1	F	2,0	3,0	4,0	38,0	–	–	1,0	3	Cylindrical	■
JS533030D1B.0Z3-NXT	02928289	1	D	3,0	3,0	6,0	38,0	–	–	1,5	3	Cylindrical	■
JS533040F1B.0Z3-NXT	02928291	1	F	4,0	6,0	8,0	57,0	–	–	2,0	3	Cylindrical	■
JS533050F1B.0Z3-NXT	02928293	1	F	5,0	6,0	10,0	57,0	–	–	2,5	3	Cylindrical	■
JS533060D1B.0Z3-NXT	02928295	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	Cylindrical	■
JS533080D1B.0Z3-NXT	02928297	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	Cylindrical	■
JS533100D1B.0Z3-NXT	02928299	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	Cylindrical	■
JS533120D1B.0Z3-NXT	02928301	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	Cylindrical	■
JS533160D1B.0Z3-NXT	02928303	1	D	16,0	16,0	32,0	110,0	–	–	8,0	3	Cylindrical	■
JS533200D1B.0Z3-NXT	02928305	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	Cylindrical	■
JS533020G2B.0Z3-NXT	02928288	2	G	2,0	3,0	2,0	38,0	7,0	1,9	1,0	3	Cylindrical	■
JS533030E2B.0Z3-NXT	02928290	2	E	3,0	3,0	3,0	38,0	9,0	2,85	1,5	3	Cylindrical	■
JS533040G2B.0Z3-NXT	02928292	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	Cylindrical	■
JS533050G2B.0Z3-NXT	02928294	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	Cylindrical	■
JS533060E2B.0Z3-NXT	02928296	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	Cylindrical	■
JS533080E2B.0Z3-NXT	02928298	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	Cylindrical	■
JS533100E2B.0Z3-NXT	02928300	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	Cylindrical	■
JS533120E2B.0Z3-NXT	02928302	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	Cylindrical	■
JS533160E2B.0Z3-NXT	02928304	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	3	Cylindrical	■

■ **Stoc standard.**

JS533

Înaltă performanţă – Universale – Cap sferic – 3 Caneluri – Weldon





—Toleranţe:
—DMM=h5
—DC=e8
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	–	–	2,0	3	Weldon	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	–	–	2,5	3	Weldon	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	Weldon	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	Weldon	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	Weldon	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	Weldon	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	Weldon	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	Weldon	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	Weldon	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	Weldon	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	Weldon	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	Weldon	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	Weldon	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	Weldon	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS533 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	195 (170 — 220) *640 (560 — 720)*
P3	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	140 (130 — 160) *460 (430 — 520)*
P6	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	140 (120 — 150) *460 (400 — 490)*
P11	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 160) *460 (430 — 520)*
P12	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	85 (73 — 97) *280 (240 — 310)*
M1	E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	125 (99 — 140) *410 (330 — 450)*
M2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (80 — 120) *330 (270 — 390)*
M3	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	70 (50 — 90) *230 (170 — 290)*
M4	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	55 (38 — 67) *180 (130 — 210)*
M5	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	44 (32 — 56) *145 (110 — 180)*
K1	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
K2	E	0.0300 *0,0300*	0.80 *0,80*	0.0036 *0,00014*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (91 — 110) *345 (300 — 360)*
K4	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (100 — 140) *395 (330 — 450)*
K5	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (61 — 84) *230 (210 — 270)*
K6	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (89 — 120) *345 (300 — 390)*
K7	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	155 (130 — 180) *510 (430 — 590)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS533 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 2900)*
N2	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	510 (450 — 570) *1675 (1500 — 1800)*
N3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	345 (300 — 380) *1125 (990 — 1200)*
N11	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (90 — 110) *330 (300 — 360)*
S2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	80 (73 — 88) *260 (240 — 280)*
S11	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	130 (120 — 140) *425 (400 — 450)*
S12	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (91 — 110) *330 (300 — 360)*
S13	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	80 (70 — 85) *260 (230 — 270)*
TS1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
TP1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
GR1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*

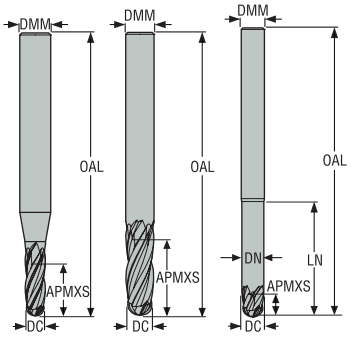
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

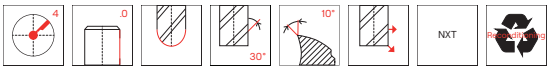
JS534

Înaltă performanţă – Universale – Cap sferic – 4 Caneluri – Cilindrică





– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



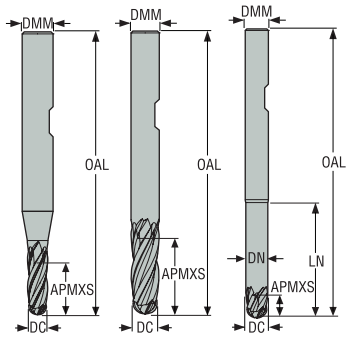
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	–	–	1,0	4	Cylindrical	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	Cylindrical	■
JS534040F1B.0Z4-NXT	02928368	1	F	4,0	6,0	12,0	57,0	–	–	2,0	4	Cylindrical	■
JS534050F1B.0Z4-NXT	02928370	1	F	5,0	6,0	15,0	57,0	–	–	2,5	4	Cylindrical	■
JS534060D1B.0Z4-NXT	02928372	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	Cylindrical	■
JS534080D1B.0Z4-NXT	02928375	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	Cylindrical	■
JS534100D1B.0Z4-NXT	02928378	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	Cylindrical	■
JS534120D1B.0Z4-NXT	02928381	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	Cylindrical	■
JS534160D1B.0Z4-NXT	02928384	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	Cylindrical	■
JS534200D1B.0Z4-NXT	02928387	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	Cylindrical	■
JS534040F2B.0Z4-NXT	02928369	2	F	4,0	6,0	20,0	63,0	–	–	2,0	4	Cylindrical	■
JS534050F2B.0Z4-NXT	02928371	2	F	5,0	6,0	25,0	75,0	–	–	2,5	4	Cylindrical	■
JS534060D2B.0Z4-NXT	02928373	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	Cylindrical	■
JS534080D2B.0Z4-NXT	02928376	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	Cylindrical	■
JS534100D2B.0Z4-NXT	02928379	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	Cylindrical	■
JS534120D2B.0Z4-NXT	02928382	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	Cylindrical	■
JS534160D2B.0Z4-NXT	02928385	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	Cylindrical	■
JS534060E3B.0Z4-NXT	02928374	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	Cylindrical	■
JS534080E3B.0Z4-NXT	02928377	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	Cylindrical	■
JS534100E3B.0Z4-NXT	02928380	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	Cylindrical	■
JS534120E3B.0Z4-NXT	02928383	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	Cylindrical	■
JS534160E3B.0Z4-NXT	02928386	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	Cylindrical	■
JS534200E3B.0Z4-NXT	02928388	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	Cylindrical	■

■ **Stoc standard.**

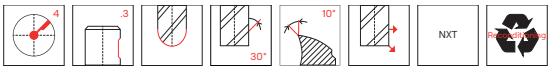
JS534

Înaltă performanţă – Universale – Cap sferic – 4 Caneluri – Weldon





– Toleranţe:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	–	–	2,0	4	Weldon	□
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	–	–	2,5	4	Weldon	□
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	Weldon	□
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	Weldon	□
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	Weldon	□
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	Weldon	□
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	Weldon	□
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	Weldon	□
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	–	–	2,0	4	Weldon	□
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	–	–	2,5	4	Weldon	□
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	Weldon	□
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	Weldon	□
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	Weldon	□
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	Weldon	□
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	Weldon	□
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	Weldon	□
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	Weldon	□
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	Weldon	□
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	Weldon	□
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	Weldon	□
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS534 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	345 (310 — 370) *1125 (1100 — 1200)*
P2	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	335 (300 — 360) *1100 (990 — 1100)*
P3	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	290 (260 — 310) *950 (860 — 1000)*
P4	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	255 (230 — 280) *840 (760 — 910)*
P5	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
P6	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	230 (210 — 250) *750 (690 — 820)*
P7	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	220 (200 — 240) *720 (660 — 780)*
P8	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	205 (190 — 220) *670 (630 — 720)*
P11	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	210 (190 — 230) *690 (630 — 750)*
P12	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	125 (120 — 130) *410 (400 — 420)*
M1	E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
M2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
M3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (140 — 180) *510 (460 — 590)*
M4	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	120 (100 — 130) *395 (330 — 420)*
M5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	100 (83 — 110) *330 (280 — 360)*
K1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
K2	E	0.0300 *0,0300*	4.0 *4,0*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	215 (200 — 230) *710 (660 — 750)*
K3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	180 (160 — 190) *590 (530 — 620)*
K4	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	170 (160 — 180) *560 (530 — 590)*
K5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	200 (180 — 220) *660 (600 — 720)*
K6	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	295 (260 — 330) *970 (860 — 1000)*
K7	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	260 (230 — 280) *850 (760 — 910)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS534 Degroșare pentru frezare prin copiere

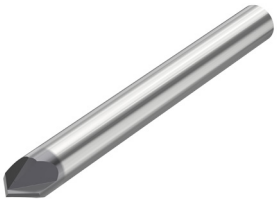
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910 — 1100) *3375 (3000 — 3600)*
N2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	910 (780 — 1000) *2975 (2600 — 3200)*
N3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	600 (520 — 690) *1975 (1800 — 2200)*
N11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	500 (440 — 560) *1650 (1500 — 1800)*
S1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	110 (88 — 110) *360 (290 — 360)*
S2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (71 — 90) *295 (240 — 290)*
S3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (63 — 87) *280 (210 — 280)*
S11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	185 (150 — 180) *610 (500 — 590)*
S12	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	140 (120 — 140) *460 (400 — 450)*
S13	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	110 (91 — 110) *360 (300 — 360)*
TS1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
TP1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
GR1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*

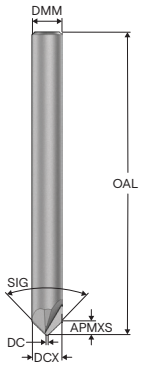
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

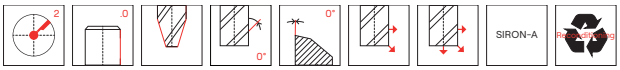
C5021

Uz general – Universale – Şanfren – 2-4 Caneluri – Cilindrică – Inci





– Toleranţe:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Reascuţire posibilă dacă DC este ≥ Ø.375



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci				
C5021-.250N1S.0Z2T30	SIRA	10268641	1	N	0.250	0.035	0.250	0.186	2.500	30,0	2	Cylindrical	■
C5021-.250N1S.0Z2T45	SIRA	10268644	1	N	0.250	0.035	0.250	0.108	2.500	45,0	2	Cylindrical	■
C5021-.375N1S.0Z2T30	SIRA	10268642	1	N	0.375	0.040	0.375	0.290	2.500	30,0	2	Cylindrical	■
C5021-.375N1S.0Z2T45	SIRA	10268645	1	N	0.375	0.040	0.375	0.168	2.500	45,0	2	Cylindrical	■
C5021-.500N1S.0Z2T30	SIRA	10268643	1	N	0.500	0.045	0.500	0.186	3.000	30,0	2	Cylindrical	■
C5021-.500N1S.0Z2T45	SIRA	10268646	1	N	0.500	0.045	0.500	0.228	3.000	45,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – C5021 Șanfrenare – Inci

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				1/4	3/8	1/2	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	110 (94 — 140) *360 (310 — 450)*

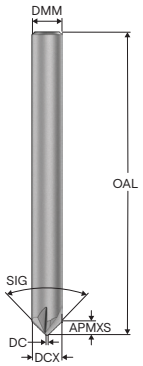
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

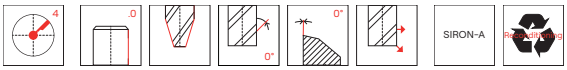
C5041

Uz general – Universale – Şanfren – 2-4 Caneluri – Cilindrică – Inci





– Toleranţe:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Reascuţire posibilă dacă DMM este ≥ Ø.375"



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci				
C5041-.250N1S.0Z4T30	SIRA	10268647	1	N	0.250	0.035	0.250	0.186	2.500	30,0	4	Cylindrical	■
C5041-.250N1S.0Z4T45	SIRA	10268652	1	N	0.250	0.035	0.250	0.108	2.500	45,0	4	Cylindrical	■
C5041-.375N1S.0Z4T30	SIRA	10268648	1	N	0.375	0.040	0.375	0.290	2.500	30,0	4	Cylindrical	■
C5041-.375N1S.0Z4T45	SIRA	10268653	1	N	0.375	0.040	0.375	0.168	2.500	45,0	4	Cylindrical	■
C5041-.500N1S.0Z4T30	SIRA	10268649	1	N	0.500	0.045	0.500	0.394	3.000	30,0	4	Cylindrical	■
C5041-.500N1S.0Z4T45	SIRA	10268654	1	N	0.500	0.045	0.500	0.228	3.000	45,0	4	Cylindrical	■
C5041-.750N1S.0Z4T30	SIRA	10268651	1	N	0.750	0.055	0.750	0.602	3.000	30,0	4	Cylindrical	■
C5041-.750N1S.0Z4T45	SIRA	10268655	1	N	0.750	0.055	0.750	0.348	3.000	45,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – C5041 Șanfrenare – Inci

SMG		a_e/DCX	a_p/DCX	f_z				v_c
				1/4	3/8	1/2	3/4	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	0,08 *0.0032*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	110 (94 — 140) *360 (310 — 450)*

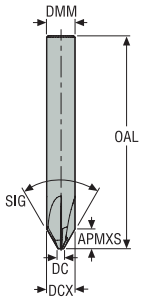
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JS506

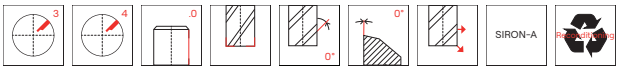
Uz general – Universale – Şanfren – 3-4 Caneluri – Cilindrică





N

—Toleranţe:
—DMM=h5
—SIG= ±0,5°
—Reascuţire posibilă dacă DMM este ≥ Ø6



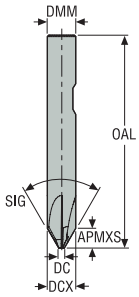
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
JS506030N2CZ3.0-SIRA	02881622	2	N	3,0	0,6	3,0	2,0	50,0	30,0	3	Cylindrical	■
JS506040N2CZ3.0-SIRA	02881623	2	N	4,0	0,8	4,0	2,7	50,0	30,0	3	Cylindrical	■
JS506060N2CZ4.0-SIRA	02881624	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Cylindrical	■
JS506080N2CZ4.0-SIRA	02881626	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Cylindrical	■
JS506100N2CZ4.0-SIRA	02881628	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Cylindrical	■
JS506120N2CZ4.0-SIRA	02881630	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Cylindrical	■

■ **Stoc standard.**

JS506

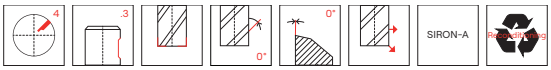
Uz general – Universale – Șanfren – 3-4 Caneluri – Weldon





N

– Toleranțe:
– DMM=h5
– SIG= ±0,5°
– Reascuțire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
JS506060N2CZ4.3-SIRA	02881625	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Weldon	■
JS506080N2CZ4.3-SIRA	02881627	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Weldon	■
JS506100N2CZ4.3-SIRA	02881629	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Weldon	■
JS506120N2CZ4.3-SIRA	02881631	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JS506 Şanfrenare

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	180 (160 — 200) *590 (530 — 650)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	155 (140 — 170) *510 (460 — 550)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 160) *460 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	130 (120 — 140) *425 (400 — 450)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (76 — 110) *310 (250 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (47 — 69) *195 (160 — 220)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	110 (87 — 120) *360 (290 — 390)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (72 — 100) *295 (240 — 320)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	60 (41 — 75) *195 (140 — 240)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	44 (31 — 57) *145 (110 — 180)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	37 (26 — 48) *120 (86 — 150)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	185 (160 — 200) *610 (530 — 650)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	130 (120 — 140) *425 (400 — 450)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	80 (69 — 89) *260 (230 — 290)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	115 (100 — 130) *375 (330 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	100 (88 — 110) *330 (290 — 360)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS506 Șanfrenare

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	445 (410 — 480) *1450 (1400 — 1500)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	285 (260 — 310) *940 (860 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	190 (180 — 200) *620 (600 — 650)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	255 (230 — 270) *840 (760 — 880)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	42 (14 — 69) *140 (46 — 220)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	34 (12 — 56) *110 (40 — 180)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	29 (9,8 — 48) *95 (33 — 150)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	85 (64 — 100) *280 (210 — 320)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	65 (49 — 84) *215 (170 — 270)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	55 (39 — 66) *180 (130 — 210)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	65 (47 — 87) *215 (160 — 280)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	85 (60 — 110) *280 (200 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	80 (55 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*

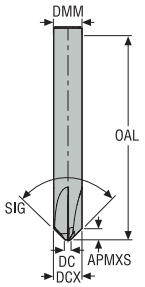
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JS509

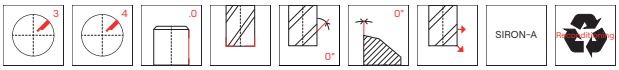
Uz general – Universale – Şanfren – 3-4 Caneluri – Cilindrică





N

– Toleranţe:
– DMM=h5
– SIG= ±0,5°
– Reascuţire posibilă dacă DMM este ≥ Ø6



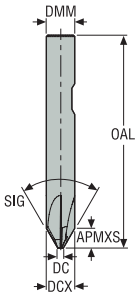
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
JS509030N2CZ3.0-SIRA	02881634	2	N	3,0	0,6	3,0	1,2	50,0	45,0	3	Cylindrical	■
JS509040N2CZ3.0-SIRA	02881635	2	N	4,0	0,8	4,0	1,6	50,0	45,0	3	Cylindrical	■
JS509060N2CZ4.0-SIRA	02881636	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Cylindrical	■
JS509080N2CZ4.0-SIRA	02881638	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Cylindrical	■
JS509100N2CZ4.0-SIRA	02881640	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Cylindrical	■
JS509120N2CZ4.0-SIRA	02881642	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Cylindrical	■

■ **Stoc standard.**

JS509

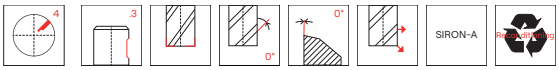
Uz general – Universale – Șanfren – 3-4 Caneluri – Weldon





N

—Toleranţe:
—DMM=h5
—SIG= ±0,5°
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
JS509060N2CZ4.3-SIRA	02881637	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Weldon	■
JS509080N2CZ4.3-SIRA	02881639	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Weldon	■
JS509100N2CZ4.3-SIRA	02881641	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Weldon	■
JS509120N2CZ4.3-SIRA	02881643	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Weldon	■

■ **Stoc standard.**

Parametri de aşchiere – JS509 Şanfrenare

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 170) *520 (460 — 550)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	140 (130 — 150) *460 (430 — 490)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	100 (79 — 110) *330 (260 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (49 — 72) *195 (170 — 230)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	115 (92 — 130) *375 (310 — 420)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (75 — 110) *310 (250 — 360)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	60 (43 — 79) *195 (150 — 250)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	46 (32 — 60) *150 (110 — 190)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	39 (27 — 50) *130 (89 — 160)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	195 (170 — 210) *640 (560 — 680)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	170 (150 — 190) *560 (500 — 620)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	120 (110 — 130) *395 (370 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	105 (92 — 120) *345 (310 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS509 Șanfrenare

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	470 (430 — 510) *1550 (1500 — 1600)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	300 (280 — 330) *980 (920 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (190 — 220) *660 (630 — 720)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	265 (250 — 290) *870 (830 — 950)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	45 (15 — 74) *150 (50 — 240)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	36 (12 — 59) *120 (40 — 190)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	31 (11 — 51) *100 (37 — 160)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (67 — 110) *295 (220 — 360)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	70 (52 — 88) *230 (180 — 280)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	70 (49 — 92) *230 (170 — 300)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	90 (63 — 110) *295 (210 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	80 (57 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*

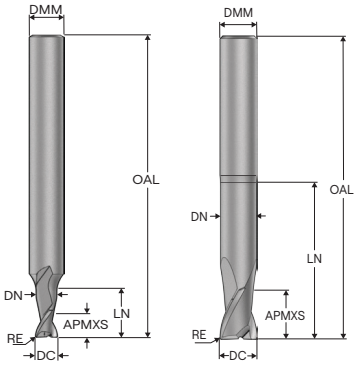
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

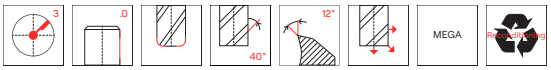
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH910

Viteză mare – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf







– Toleranţe:
– DMM= h5
– DC= -0,02/-0,03 mm
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

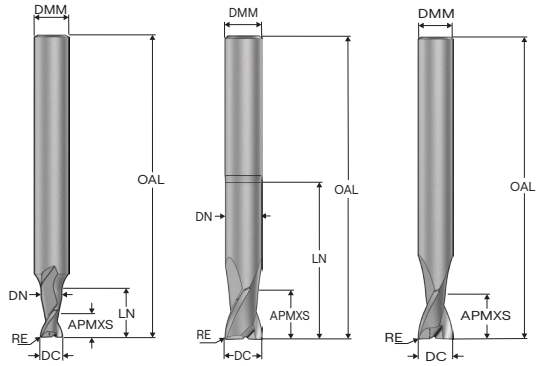
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	Cylindrical	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	Cylindrical	■
910030R010-MEGA	00020073	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,1	–	3	Cylindrical	■
910030R020-MEGA	00020142	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,2	–	3	Cylindrical	■
910035R020-MEGA	00020144	2	G	3,5	6,0	5,0	50,0	9,0	3,2	0,2	6,0	3	Cylindrical	■
910040R020-MEGA	00020151	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,2	5,0	3	Cylindrical	■
910040R030-MEGA	00020152	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,3	5,0	3	Cylindrical	■
910040R050-MEGA	00020155	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,5	5,0	3	Cylindrical	■
910050R020-MEGA	00020159	2	G	5,0	6,0	6,0	50,0	11,0	4,6	0,2	2,5	3	Cylindrical	■
910060R020-MEGA	00020160	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,2	–	3	Cylindrical	■
910060R030-MEGA	00020161	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,3	–	3	Cylindrical	■
910060R050-MEGA	00020162	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,5	–	3	Cylindrical	■
910080R020-MEGA	00020163	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,2	–	3	Cylindrical	■
910080R050-MEGA	00020164	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,5	–	3	Cylindrical	■
910100R020-MEGA	00020165	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,2	–	3	Cylindrical	■
910100R050-MEGA	00020166	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,5	–	3	Cylindrical	■
910100R100-MEGA	00020167	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	3	Cylindrical	■
910120R050-MEGA	00020168	2	E	12,0	12,0	15,0	80,0	30,0	11,4	0,5	–	3	Cylindrical	■
910120R100-MEGA	00020169	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,0	–	3	Cylindrical	■

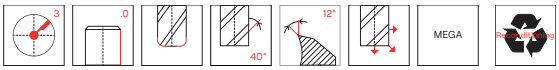
■ **Stoc standard.**

JH910

Viteză mare – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM= h5
—DC= -0,02/-0,03 mm
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
910L020-MEGA	00022002	3	G	2,0	3,0	3,0	60,0	10,0	1,9	0,2	2,5	3	Cylindrical	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	3	Cylindrical	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	3	Cylindrical	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	3	Cylindrical	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	3	Cylindrical	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	3	Cylindrical	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	3	Cylindrical	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	3	Cylindrical	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	3	Cylindrical	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	3	Cylindrical	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	3	Cylindrical	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	3	Cylindrical	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	3	Cylindrical	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	3	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH910 Degroşare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	455 (410 — 500)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1500 (1400 — 1600)*
P2	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	445 (400 — 490)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1450 (1400 — 1600)*
P3	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	385 (350 — 420)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1275 (1200 — 1300)*
P4	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	335 (300 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1100 (990 — 1200)*
P5	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P6	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	360 (330 — 400)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (1100 — 1300)*
P7	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	340 (310 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1125 (1100 — 1200)*
P8	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P11	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	330 (300 — 360)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1075 (990 — 1100)*
P12	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	195 (180 — 210)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*640 (600 — 680)*
M1	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	200 (180 — 220)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*660 (600 — 720)*
M2	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	160 (150 — 170)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*520 (500 — 550)*
M3	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	110 (91 — 120)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*360 (300 — 390)*
M4	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	80 (68 — 94)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*260 (230 — 300)*
M5	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	70 (57 — 78)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*230 (190 — 250)*
K1	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	315 (270 — 350)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1025 (890 — 1100)*
K2	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	270 (240 — 310)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*890 (790 — 1000)*
K3	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	230 (200 — 260)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*750 (660 — 850)*
K4	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	220 (190 — 250)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*720 (630 — 820)*
K5	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	280 (240 — 320)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*920 (790 — 1000)*
K6	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	415 (350 — 480)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1350 (1200 — 1500)*
K7	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	355 (300 — 410)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (990 — 1300)*
S1	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	115 (93 — 130)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*375 (310 — 420)*
S2	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	95 (75 — 110)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*310 (250 — 360)*
S3	E/M/A	0.0200	0.50	0.016	0.024	0.032	0.040	0.048	0.055	0.065	0.070	0.080	0.090	0.095	0.10	0.13	0.14	50 (40 — 59)
		0,0200	*0,50*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0022*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*0,0050*	*0,0055*	*165 (140 — 190)*
S11	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	175 (160 — 190)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*570 (530 — 620)*
S12	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	135 (120 — 150)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*445 (400 — 490)*
S13	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	105 (90 — 110)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*345 (300 — 360)*
TP1	A	0.150	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.15	0.15	205 (180 — 240)
		0,150	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0060*	*670 (600 — 780)*
GR1	A	0.500	1.0	0.024	0.036	0.048	0.060	0.070	0.085	0.095	0.11	0.12	0.13	0.14	0.15	0.18	0.18	610 (510 — 710)
		0,500	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0034*	*0,0038*	*0,0044*	*0,0048*	*0,0050*	*0,0055*	*0,0060*	*0,0070*	*0,0070*	*2000 (1700 — 2300)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JH910 Frezare de canal

SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170 — 190) *590 (560 — 620)*
P6	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170 — 190) *590 (560 — 620)*
P11	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	195 (180 — 210) *640 (600 — 680)*
P12	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	115 (110 — 120) *375 (370 — 390)*
M1	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	120 (110 — 130) *395 (370 — 420)*
M2	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	95 (86 — 100) *310 (290 — 320)*
M3	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51 — 70) *195 (170 — 220)*
M4	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	45 (38 — 52) *150 (130 — 170)*
M5	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	38 (32 — 43) *125 (110 — 140)*
K1	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	175 (160 — 200) *570 (530 — 650)*
K2	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (140 — 170) *490 (460 — 550)*
K3	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	130 (120 — 140) *425 (400 — 450)*
K4	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	125 (110 — 140) *410 (370 — 450)*
K5	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (130 — 170) *490 (430 — 550)*
K6	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	220 (190 — 250) *720 (630 — 820)*
K7	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 220) *620 (560 — 720)*
S1	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (50 — 74) *195 (170 — 240)*
S2	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	50 (41 — 60) *165 (140 — 190)*
S3	E/M/A	0.080 *0,080*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	25 (21 — 30) *80 (69 — 98)*
S11	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	100 (85 — 110) *330 (280 — 360)*
S12	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	75 (65 — 84) *245 (220 — 270)*
S13	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51 — 65) *195 (170 — 210)*
TP1	A	0.24 *0,24*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
GR1	A	0.36 *0,36*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	600 (510 — 700) *1975 (1700 — 2200)*

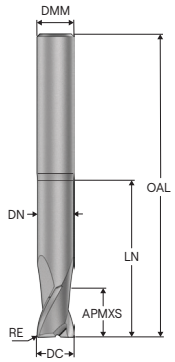
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH930

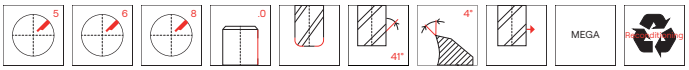
Viteză mare – Universale – Pătrat – 5-8 Caneluri – Cilindrică – Rază la vârf





E

- Toleranţe:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH930 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

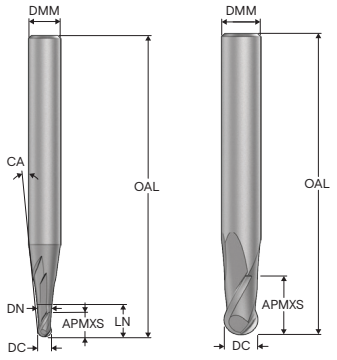
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

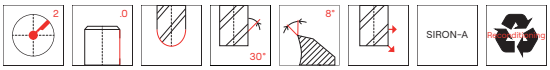
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHB970

Viteză mare – Universale – Cap sferic – 2 Caneluri – Cilindrică







– Toleranţe:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JHB970 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

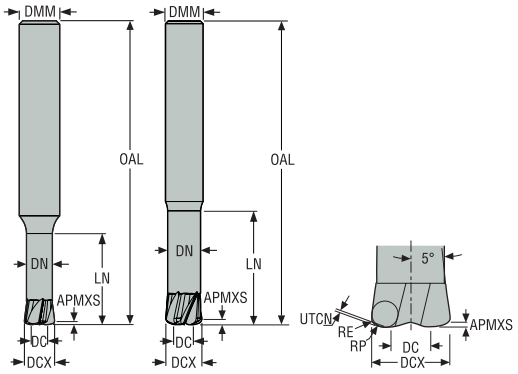
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHF980

Avans mare – Universale – 2-5 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—DMM= h5
—DC= -0,02/-0,05 mm
—RE= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

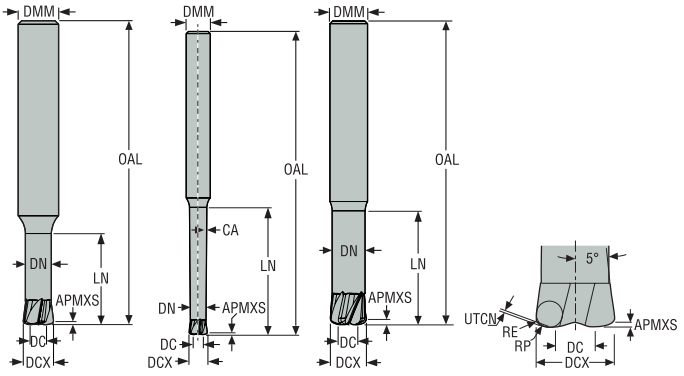
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm					
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	-5,0	3	Cylindrical	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	-5,0	5	Cylindrical	■
980K100Z3-MEGA	02587117	1	E	10,0	5,0	10,0	0,45	80,0	15,0	3,8	0,8	1,176	0,232	–	-5,0	3	Cylindrical	■
JHF980100E1H.0Z5-MEGA	03003385	1	E	10,0	5,0	10,0	0,45	80,0	15,0	8,8	0,8	1,176	0,232	–	-5,0	5	Cylindrical	■
980K120Z3-MEGA	02587118	1	E	12,0	6,0	12,0	0,5	80,0	18,0	4,6	1,0	1,417	0,265	–	-5,0	3	Cylindrical	■
JHF980120E1H.0Z5-MEGA	03003386	1	E	12,0	6,0	12,0	0,5	80,0	18,0	10,6	1,0	1,417	0,265	–	-5,0	5	Cylindrical	■
980010-MEGA	02587111	2	G	1,0	0,5	6,0	0,07	40,0	3,0	0,7	0,07	0,127	0,028	19,5	-5,0	2	Cylindrical	■
980015-MEGA	02511199	2	G	1,5	0,75	6,0	0,1	40,0	4,5	1,2	0,1	0,183	0,043	14,0	-5,0	2	Cylindrical	■
980020-MEGA	02511221	2	G	2,0	1,0	6,0	0,15	40,0	6,0	1,7	0,15	0,269	0,055	11,0	-5,0	2	Cylindrical	■
980030-MEGA	02511224	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,0	-5,0	2	Cylindrical	■
JHF980030G2H.0Z4-MEGA	03003387	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,12	-5,0	4	Cylindrical	■
980040-MEGA	02511229	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	-5,0	2	Cylindrical	■
JHF980040G2H.0Z4-MEGA	03003388	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	-5,0	4	Cylindrical	■
980050-MEGA	02511233	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	2,0	-5,0	2	Cylindrical	■
JHF980050G2H.0Z4-MEGA	03003389	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	1,77	-5,0	4	Cylindrical	■
980060-MEGA	02511314	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	3,0	-5,0	2	Cylindrical	■
JHF980060G2H.0Z4-MEGA	03003390	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	2,86	-5,0	4	Cylindrical	■
980080-MEGA	02511322	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	-5,0	2	Cylindrical	■
JHF980080E2H.0Z5-MEGA	03003391	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	-5,0	5	Cylindrical	■
980100-MEGA	02511341	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	2	Cylindrical	■
980100Z3-MEGA	02511342	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	3	Cylindrical	■
JHF980100E2H.0Z5-MEGA	03003392	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	5	Cylindrical	■
980120-MEGA	02511346	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	2	Cylindrical	■
980120Z3-MEGA	02511347	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	3	Cylindrical	■
JHF980120E2H.0Z5-MEGA	03003393	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	5	Cylindrical	■

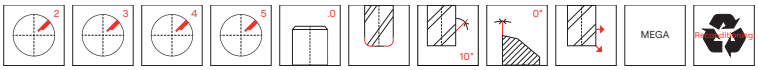
■ **Stoc standard.**
*UTCN=grosime neaşchiată

JHF980

Avans mare – Universale – 2-5 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM= h5
—DC= -0,02/-0,05 mm
—RE= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm						
980ML010-MEGA	02587113	3	G	1,0	0,5	6,0	0,07	40,0	5,0	0,7	0,07	0,127	0,028	15,5	–	-5,0	2	Cylindrical	■
980ML015-MEGA	02511219	3	G	1,5	0,75	6,0	0,1	40,0	7,5	1,2	0,1	0,183	0,043	10,5	–	-5,0	2	Cylindrical	■
980ML020-MEGA	02511222	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,0	–	-5,0	2	Cylindrical	■
JHF980020G3H.0Z4-MEGA	03003394	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,46	–	-5,0	4	Cylindrical	■
980ML030-MEGA	02511225	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	5,0	–	-5,0	2	Cylindrical	■
JHF980030G3H.0Z4-MEGA	03003395	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	4,79	–	-5,0	4	Cylindrical	■
980ML040-MEGA	02511231	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,5	–	-5,0	2	Cylindrical	■
JHF980040G3H.0Z4-MEGA	03003396	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,59	–	-5,0	4	Cylindrical	■
980ML050-MEGA	02511234	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,5	–	-5,0	2	Cylindrical	■
JHF980050G3H.0Z4-MEGA	03003397	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,12	–	-5,0	4	Cylindrical	■
980ML060-MEGA	02511315	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	2,0	–	-5,0	2	Cylindrical	■
JHF980060G3H.0Z4-MEGA	03003398	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	1,8	–	-5,0	4	Cylindrical	■
980ML080-MEGA	02511338	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	–	-5,0	2	Cylindrical	■
JHF980080E3H.0Z5-MEGA	03003399	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	–	-5,0	5	Cylindrical	■
980ML100-MEGA	02511344	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	–	-5,0	2	Cylindrical	■
JHF980100E3H.0Z5-MEGA	03003400	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	–	-5,0	5	Cylindrical	■
980ML120-MEGA	02511348	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	–	-5,0	2	Cylindrical	■
JHF980120E3H.0Z5-MEGA	03003401	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	–	-5,0	5	Cylindrical	■
980TL010-MEGA	02587114	4	J	1,0	0,5	6,0	0,07	40,0	7,0	0,7	0,07	0,127	0,028	13,0	0,5	-5,0	2	Cylindrical	■
980TL015-MEGA	02511220	4	J	1,5	0,75	6,0	0,1	40,0	10,5	1,2	0,1	0,183	0,043	8,5	0,5	-5,0	2	Cylindrical	■
980TL020-MEGA	02511223	4	J	2,0	1,0	6,0	0,15	50,0	14,0	1,7	0,15	0,269	0,055	6,5	0,5	-5,0	2	Cylindrical	■
980TL030-MEGA	02511226	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,5	0,5	-5,0	2	Cylindrical	■
JHF980030J4H.0Z4-MEGA	03003402	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,63	0,5	-5,0	4	Cylindrical	■
980TL040-MEGA	02511232	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	2,0	0,5	-5,0	2	Cylindrical	■
JHF980040J4H.0Z4-MEGA	03003403	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	1,93	0,5	-5,0	4	Cylindrical	■
980TL050-MEGA	02511240	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	1,0	0,5	-5,0	2	Cylindrical	■
JHF980050J4H.0Z4-MEGA	03003404	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	0,82	0,5	-5,0	4	Cylindrical	■
980TL060-MEGA	02511321	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,5	0,5	-5,0	2	Cylindrical	■
JHF980060J4H.0Z4-MEGA	03003405	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,33	0,5	-5,0	4	Cylindrical	■
980TL080-MEGA	02511340	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,5	-5,0	2	Cylindrical	■
JHF980080E4H.0Z5-MEGA	03003406	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	–	-5,0	5	Cylindrical	■
980TL100-MEGA	02511345	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,5	-5,0	2	Cylindrical	■
JHF980100E4H.0Z5-MEGA	03003407	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	–	-5,0	5	Cylindrical	■
980TL120-MEGA	02511349	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,5	-5,0	2	Cylindrical	■
JHF980120E4H.0Z5-MEGA	03003408	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	–	-5,0	5	Cylindrical	■

■ **Stoc standard.***UTCN=grosime neașchiată

Parametri de aşchiere – JHF980 Frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z										v_c
				1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	385 (350 — 430) *1275 (1200 — 1400)*
P2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	375 (340 — 410) *1225 (1200 — 1300)*
P3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	325 (290 — 360) *1075 (960 — 1100)*
P4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	285 (260 — 310) *940 (860 — 1000)*
P5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	275 (250 — 300) *900 (830 — 980)*
P6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	215 (190 — 240) *710 (630 — 780)*
P7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	205 (180 — 230) *670 (600 — 750)*
P8	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	190 (170 — 210) *620 (560 — 680)*
P11	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	195 (170 — 220) *640 (560 — 720)*
P12	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	120 (110 — 130) *395 (370 — 420)*
M1	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
M4	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	70 (61 — 83) *230 (210 — 270)*
K1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	195 (170 — 220) *640 (560 — 720)*
K3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	165 (150 — 180) *540 (500 — 590)*
K4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	155 (140 — 170) *510 (460 — 550)*
K5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	165 (140 — 190) *540 (460 — 620)*
K6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	245 (200 — 290) *800 (660 — 950)*
K7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	210 (170 — 250) *690 (560 — 820)*
S1	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	60 (50 — 74) *195 (170 — 240)*
S2	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	50 (41 — 60) *165 (140 — 190)*
S3	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	37 (25 — 49) *120 (83 — 160)*
S11	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	175 (160 — 190) *570 (530 — 620)*
S12	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	105 (90 — 110) *345 (300 — 360)*
H5	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H8	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H21	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H31	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	90 (74 — 100) *295 (250 — 320)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JHF980 Frezare de canal

SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100 — 1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	330 (300 — 360) *1075 (990 — 1100)*
P3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	285 (260 — 310) *940 (860 — 1000)*
P4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	250 (230 — 270) *820 (760 — 880)*
P5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	165 (150 — 180) *540 (500 — 590)*
P11	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	105 (90 — 110) *345 (300 — 360)*
M1	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	65 (53 — 72) *215 (180 — 230)*
K1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	42 (34 — 50) *140 (120 — 160)*
S3	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	31 (21 — 41) *100 (69 — 130)*
S11	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
S12	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	120 (110 — 130) *395 (370 — 420)*
S13	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	95 (82 — 100) *310 (270 — 320)*
H5	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H8	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H21	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H31	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (65 — 88) *245 (220 — 280)*

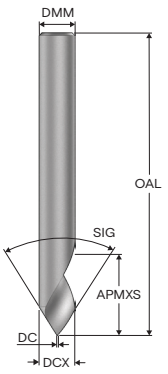
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

J29

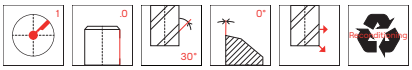
Uz general – Universale – Gravare – 1 Canelură – Cilindrică





D

– Toleranţe:
– DMM=h5
– Reascuţire posibilă dacă DMM este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
29030	00029373	2	D	3,0	0,2	3,0	2,6	40,0	30,0	1	Cylindrical	■
29040	00029381	2	D	4,0	0,2	4,0	3,5	50,0	30,0	1	Cylindrical	■
29060	00029396	2	D	6,0	0,2	6,0	5,2	50,0	30,0	1	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – J29 Frezare de canal

SMG		a_p/DC	f_z			v_c
			3	4	6	
P1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	42 (32 — 63) *140 (110 — 200)*
P2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.30 *0,012*	41 (32 — 61) *135 (110 — 200)*
P3	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	36 (28 — 54) *120 (92 — 170)*
P4	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 47) *100 (79 — 150)*
P5	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
P6	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	34 (26 — 51) *110 (86 — 160)*
P7	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	32 (25 — 48) *105 (83 — 150)*
P8	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	30 (23 — 45) *100 (76 — 140)*
P11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 46) *100 (79 — 150)*
P12	E	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	19 (15 — 29) *60 (50 — 95)*
M1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M3	E	0.50 *0,50*	0.18 *0,0070*	0.19 *0,0075*	0.22 *0,0085*	24 (18 — 35) *80 (60 — 110)*
M4	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	18 (14 — 27) *60 (46 — 88)*
M5	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	15 (12 — 22) *49 (40 — 72)*
K1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
K2	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	26 (21 — 40) *85 (69 — 130)*
K3	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	22 (17 — 33) *70 (56 — 100)*
K4	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	21 (17 — 32) *70 (56 — 100)*
K5	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	13 (9.8 — 19) *43 (33 — 62)*
K6	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	19 (15 — 28) *60 (50 — 91)*
K7	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	16 (13 — 25) *50 (43 — 82)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – J29 Frezare de canal

SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8 — 19) *43 (33 — 62)*
N11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	17 (14 — 26) *55 (46 — 85)*
S1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	43 (33 — 64) *140 (110 — 200)*
S2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	34 (27 — 51) *110 (89 — 160)*
S3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 59) *130 (99 — 190)*
S12	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S13	E	0.50 *0,50*	0.19 *0,0075*	0.20 *0,0080*	0.24 *0,0095*	24 (18 — 35) *80 (60 — 110)*
H5	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
H8	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H11	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 58) *130 (99 — 190)*
H12	M/A/D	0.50 *0,50*	0.12 *0,0048*	0.12 *0,0048*	0.14 *0,0055*	12 (9.1 — 18) *39 (30 — 59)*
H21	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H31	M/A/D	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.17 *0,0065*	24 (19 — 36) *80 (63 — 110)*
TS1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
TP1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
GR1	D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*

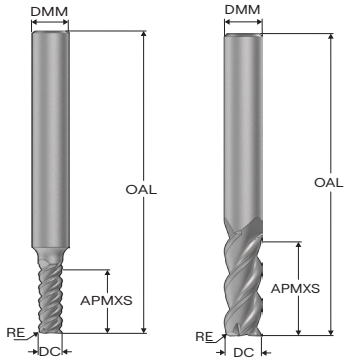
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

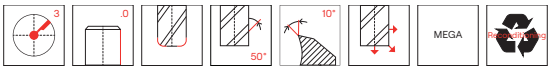
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

J36

Uz general – Universale – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM= h5
—DC= Ø2-Ø6= -0,02/-0,034 mm
—DC= Ø8-Ø20= -0,02/-0,044 mm
—RE= Ø2-Ø12= +0,05 mm
—RE= Ø14-Ø20= +0,1 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	Cylindrical	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	Cylindrical	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	Cylindrical	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	Cylindrical	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	Cylindrical	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	Cylindrical	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	Cylindrical	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	Cylindrical	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	Cylindrical	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – J36 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
P2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	190 (170 — 210) *620 (560 — 680)*
P3	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P4	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 160) *490 (430 — 520)*
P5	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
P6	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	160 (140 — 180) *520 (460 — 590)*
P7	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
P8	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	140 (130 — 160) *460 (430 — 520)*
P11	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	145 (130 — 160) *475 (430 — 520)*
P12	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	115 (92 — 140) *375 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	95 (76 — 110) *310 (250 — 360)*
M3	E	0.100 *0,100*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	75 (56 — 95) *245 (190 — 310)*
M4	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 73) *195 (150 — 230)*
M5	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	48 (36 — 60) *155 (120 — 190)*
K1	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
K2	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	105 (91 — 120) *345 (300 — 390)*
K4	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	100 (87 — 110) *330 (290 — 360)*
K5	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	60 (53 — 69) *195 (180 — 220)*
K6	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	90 (76 — 100) *295 (250 — 320)*
K7	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – J36 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	650 (540 — 750) *2125 (1800 — 2400)*
N2	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	275 (240 — 320) *900 (790 — 1000)*
N11	E	0.300 *0,300*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	305 (260 — 350) *1000 (860 — 1100)*
S1	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	70 (60 — 83) *230 (200 — 270)*
S2	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	60 (48 — 67) *195 (160 — 210)*
S3	E	0.120 *0,120*	0.90 *0,90*	0.0036 *0,00014*	0.0055 *0,00022*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	39 (30 — 48) *130 (99 — 150)*
S11	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	100 (89 — 110) *330 (300 — 360)*
S12	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	80 (68 — 87) *260 (230 — 280)*
S13	E	0.300 *0,300*	1.0 *0,90*	0.0085 *0,00036*	0.013 *0,00050*	0.017 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (54 — 69) *195 (180 — 220)*
TS1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*
TP1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*

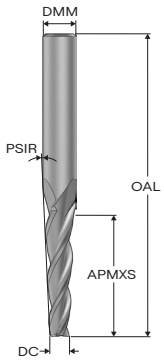
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

HK

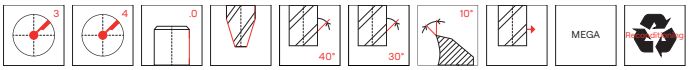
Uz general – Universale – Conic – 3-4 Caneluri – Cilindrică – Conic ascuţit





N

—Toleranţe:
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—DC= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă



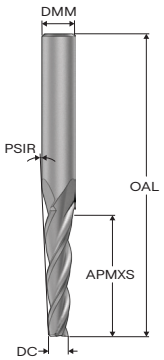
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK020-040-MEGA	00028666	2	N	6,0	4,0	6,0	20,0	65,0	2,0	3	Cylindrical	■
HK020-050-MEGA	00028669	2	N	8,0	5,0	8,0	30,0	75,0	2,0	3	Cylindrical	■
HK020-100-MEGA	00028694	2	N	12,0	10,0	12,0	28,0	80,0	2,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HKM-HK

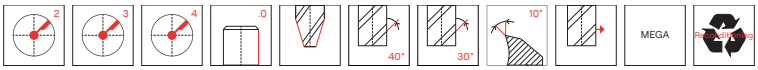
Uz general – Universale – Conic – 2-4 Caneluri – Cilindrică – Conic ascuţit





N

—Toleranţe:
—DMM= h5
—DC= HKM= +0,07/+0,03 mm
—DC= HK= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă dacă DC este ≥ Ø6



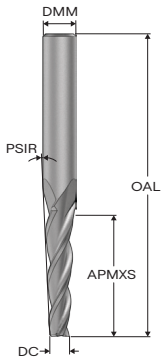
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HKM030-015-MEGA	00028738	2	N	3,0	1,5	3,0	6,0	40,0	3,0	2	Cylindrical	■
HK030-025-MEGA	00028741	2	N	6,0	2,5	6,0	20,0	65,0	3,0	3	Cylindrical	■
HK030-033-MEGA	00028744	2	N	8,0	3,0	8,0	30,0	75,0	3,0	3	Cylindrical	■
HK030-065-MEGA	00028759	2	N	12,0	6,0	12,0	55,0	110,0	3,0	3	Cylindrical	■
HK030-083-MEGA	00028771	2	N	12,0	8,0	12,0	30,0	80,0	3,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

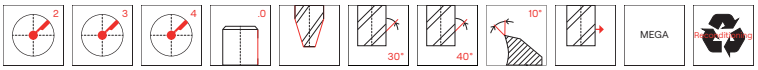
HKM-HK

Uz general – Universale – Conic – 2-4 Caneluri – Cilindrică – Conic ascuţit





N



—Toleranţe:
—DMM= h5
—DC= HKM= +0,07/+0,03 mm
—DC= HK= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă dacă DC este ≥ Ø6

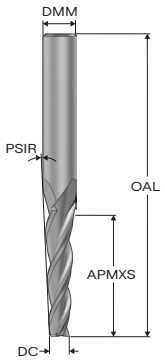
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HKM050-010-MEGA	00028947	2	N	3,0	1,0	3,0	4,0	40,0	5,0	2	Cylindrical	■
HKM050-015-MEGA	00028952	2	N	3,0	1,5	3,0	6,0	40,0	5,0	2	Cylindrical	■
HKM050-020-MEGA	00028954	2	N	4,0	2,0	4,0	10,0	50,0	5,0	2	Cylindrical	■
HKM050-025-MEGA	00028958	2	N	5,0	2,5	5,0	10,0	50,0	5,0	2	Cylindrical	■
HK050-025-MEGA	00028960	2	N	6,0	2,5	6,0	20,0	65,0	5,0	3	Cylindrical	■
HK050-032-MEGA	00028972	2	N	8,0	3,0	8,0	28,0	70,0	5,0	3	Cylindrical	■
HK050-0420-MEGA	00028998	2	N	8,0	4,0	8,0	22,0	65,0	5,0	3	Cylindrical	■
HK050-050-MEGA	00029012	2	N	12,0	5,0	12,0	40,0	100,0	5,0	3	Cylindrical	■
HK050-063-MEGA	00029014	2	N	12,0	6,0	12,0	32,0	90,0	5,0	3	Cylindrical	■
HK050-065-MEGA	00029017	2	N	16,0	6,0	16,0	55,0	110,0	5,0	3	Cylindrical	■
HK050-103-MEGA	00029020	2	N	16,0	10,0	16,0	32,0	90,0	5,0	4	Cylindrical	■
HK050-105-MEGA	00029025	2	N	20,0	10,0	20,0	55,0	115,0	5,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

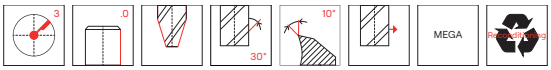
Uz general – Universale – Conic – 3 Caneluri – Cilindrică – Conic ascuţit





N

—Toleranţe:
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—DC= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă



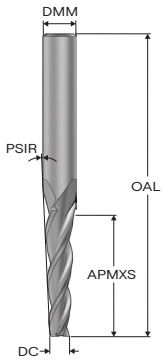
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK070-025-MEGA	00029030	2	N	8,0	2,5	8,0	22,0	65,0	7,0	3	Cylindrical	■
HK070-050-MEGA	00029034	2	N	12,0	5,0	12,0	28,0	80,0	7,0	3	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

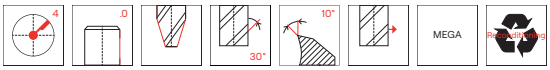
Uz general – Universale – Conic – 4 Caneluri – Cilindrică – Conic ascuţit





N

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—Reascuţire posibilă



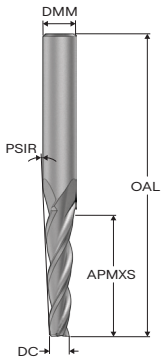
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK080-083-MEGA	00029041	2	N	18,0	8,0	18,0	35,0	90,0	8,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

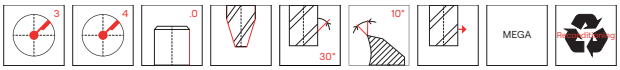
Uz general – Universale – Conic – 3-4 Caneluri – Cilindrică – Conic ascuţit





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—Reascuţire posibilă



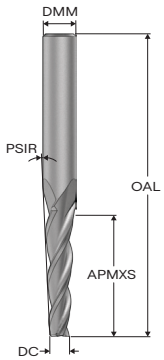
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK100-025-MEGA	00029052	2	N	10,0	2,5	10,0	20,0	75,0	10,0	3	Cylindrical	■
HK100-030-MEGA	00029066	2	N	14,0	3,0	14,0	30,0	90,0	10,0	3	Cylindrical	■
HK100-050-MEGA	00029069	2	N	16,0	5,0	16,0	30,0	90,0	10,0	3	Cylindrical	■
HK100-080-MEGA	00029083	2	N	20,0	8,0	20,0	32,0	90,0	10,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

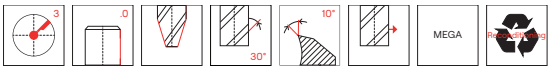
Uz general – Universale – Conic – 3 Caneluri – Cilindrică – Conic ascuţit





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—Reascuţire posibilă



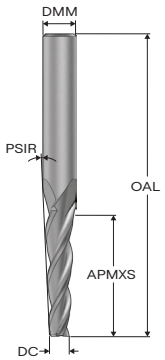
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK110-020-MEGA	00029110	2	N	10,0	2,0	10,0	20,0	75,0	11,0	3	Cylindrical	■
HK110-050-MEGA	00029117	2	N	14,0	5,0	14,0	20,0	80,0	11,0	3	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

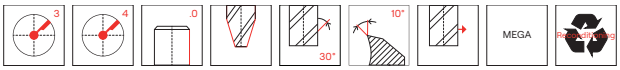
Uz general – Universale – Conic – 3-4 Caneluri – Cilindrică – Conic ascuţit





N

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—PSIR= ±0,1°
—Reascuţire posibilă



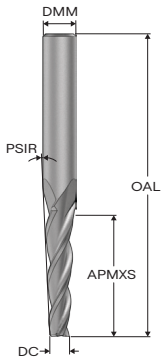
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK150-025	00029119	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-025-MEGA	00029151	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-040	00029124	2	N	12,0	4,0	12,0	15,0	65,0	15,0	3	Cylindrical	■
HK150-040-MEGA	00029154	2	N	12,0	4,0	12,0	15,0	65,0	15,0	3	Cylindrical	■
HK150-0651	00029133	2	N	12,0	6,5	12,0	10,0	65,0	15,0	3	Cylindrical	■
HK150-0651-MEGA	00029160	2	N	12,0	6,5	12,0	10,0	65,0	15,0	3	Cylindrical	■
HK150-0652	00029138	2	N	20,0	6,5	20,0	25,0	90,0	15,0	3	Cylindrical	■
HK150-0652-MEGA	00029161	2	N	20,0	6,5	20,0	25,0	90,0	15,0	3	Cylindrical	■
HK150-080	00029149	2	N	20,0	8,0	20,0	20,0	80,0	15,0	4	Cylindrical	■
HK150-080-MEGA	00029162	2	N	20,0	8,0	20,0	20,0	80,0	15,0	4	Cylindrical	■

■ Stoc standard.
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

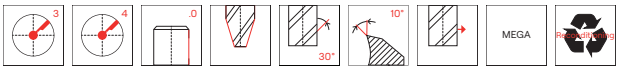
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N

- Toleranţe:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Reascuţire posibilă



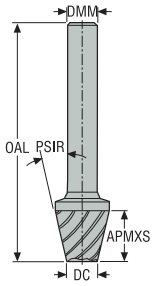
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK200-025	00029165	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-025-MEGA	00029168	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-045	00029166	2	N	16,0	4,5	16,0	15,0	90,0	20,0	4	Cylindrical	■
HK200-045-MEGA	00029203	2	N	16,0	4,5	16,0	15,0	90,0	20,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

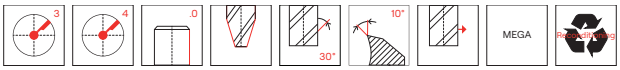
Uz general – Universale – Conic – 3-4 Caneluri – Cilindrică – Conic ascuţit





N

—Toleranţe:
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—DC= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă



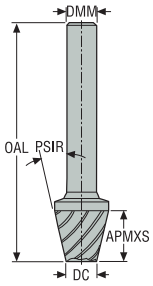
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK300-025	00029208	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-025-MEGA	00029211	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-045	00029210	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■
HK300-045-MEGA	00029212	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

HK

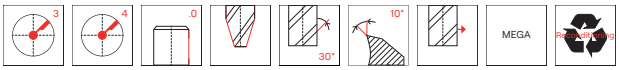
Uz general – Universale – Conic – 3-4 Caneluri – Cilindrică – Conic ascuţit





N

—Toleranţe:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Reascuţire posibilă



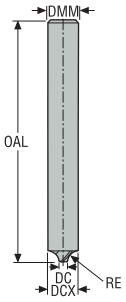
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm				
HK450-025	00029215	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-025-MEGA	00029229	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-045	00029217	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■
HK450-045-MEGA	00029232	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■

■ **Stoc standard.**
Pentru parametri de aşchiere, consultaţi My Pages – Suggest la www.secotools.com

V31

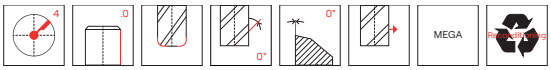
Uz general – Universale – Concav – 4 Caneluri – Cilindrică





D

—Toleranţe:
—DMM= h5
—DC= ±0,04 mm
—RE= ±0,02 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm			
31100-MEGA	00029307	2	D	6,0	4,0	6,0	1,0	64,0	1,0	4	Cylindrical	■
31200-MEGA	00029315	2	D	8,0	4,0	8,0	2,0	75,0	2,0	4	Cylindrical	■
31300-MEGA	00029326	2	D	10,0	4,0	10,0	3,0	75,0	3,0	4	Cylindrical	■
31400-MEGA	00029328	2	D	12,0	4,0	12,0	4,0	75,0	4,0	4	Cylindrical	■
31050-MEGA	00029285	2	D	6,0	5,0	6,0	0,5	64,0	0,5	4	Cylindrical	■
31150-MEGA	00029313	2	D	8,0	5,0	8,0	1,5	75,0	1,5	4	Cylindrical	■
31250-MEGA	00029324	2	D	10,0	5,0	10,0	2,5	75,0	2,5	4	Cylindrical	■
31350-MEGA	00029327	2	D	12,0	5,0	12,0	3,5	75,0	3,5	4	Cylindrical	■
31500-MEGA	00029330	2	D	16,0	6,0	16,0	5,0	75,0	5,0	4	Cylindrical	■
31600-MEGA	00029331	2	D	20,0	8,0	20,0	6,0	80,0	6,0	4	Cylindrical	■
31999-MEGA	00029335	2	D	28,0	8,0	25,0	10,0	80,0	10,0	4	Cylindrical	■
31800-MEGA	00029333	2	D	25,0	9,0	25,0	8,0	75,0	8,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – V31 Degroşare prin frezare laterală

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
P1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0034*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	105 (70 — 115) *345 (220 — 375)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – V31 Degroșare prin frezare laterală

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	265 (180 — 285) *870 (590 — 940)*
S12	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S13	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	0,075 *0,003*	0,080 *0,0032*	155 (105 — 165) *510 (345 — 540)*
H5	M/A	0,24 *0,24*	0,034 *0,0013*	0,046 *0,0018*	0,055 *0,0022*	0,070 *0,0028*	0,090 *0,0036*	0,11 *0,0044*	0,13 *0,0050*	0,14 *0,0055*	275 (185 — 295) *900 (610 — 950)*
H8	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H21	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H31	M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TS1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*

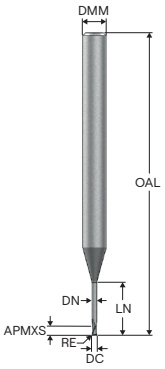
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

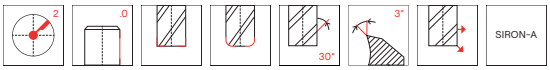
JME542

Miniatură – Universale – Pătrat – 2 Caneluri – DMM 4 – Cilindrică – Rază la vârf sau ascuţit





G



—Toleranţe:
—Bătaie radială= <0,007 mm
—DMM= h5
—DC= Ø0,2-Ø0,4= 0,-0,01 mm
—DC= Ø0,5-Ø3,0= 0,-0,013 mm
—RE= ±0,005 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JME542002G1S.0Z2-SIRA	03171095	1	G	0,2	4,0	0,3	45,0	0,4	0,18	–	14,41	2	Cylindrical	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	14,0	2	Cylindrical	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	13,5	2	Cylindrical	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	13,17	2	Cylindrical	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	12,76	2	Cylindrical	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	11,96	2	Cylindrical	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	11,22	2	Cylindrical	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	10,43	2	Cylindrical	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	9,2	2	Cylindrical	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	11,03	2	Cylindrical	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	10,36	2	Cylindrical	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	9,14	2	Cylindrical	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	8,09	2	Cylindrical	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	7,13	2	Cylindrical	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	5,89	2	Cylindrical	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	4,14	2	Cylindrical	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2,79	2	Cylindrical	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	1,67	2	Cylindrical	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	9,49	2	Cylindrical	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	8,56	2	Cylindrical	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	7,05	2	Cylindrical	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	6,1	2	Cylindrical	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	5,27	2	Cylindrical	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	4,29	2	Cylindrical	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2,9	2	Cylindrical	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	1,1	2	Cylindrical	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	3,64	2	Cylindrical	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2,41	2	Cylindrical	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	0,9	2	Cylindrical	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2,64	2	Cylindrical	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	1,7	2	Cylindrical	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	0,61	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JME542 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300 — 1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200 — 1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100 — 1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920 — 1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92 — 130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890 — 1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JME542 Frezare de canal

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.022	0.022	0.026	0.028	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00085*	*0,00085*	*0,0010*	*0,0011*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.048	0.050	350 (300 — 400)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*1150 (990 — 1300)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	110 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*360 (310 — 390)*
H3	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 400)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1300)*

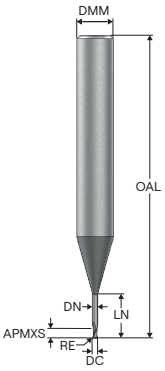
Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JME562

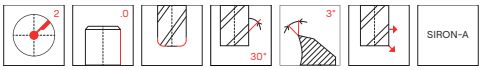
Miniatură – Universale – Pătrat – 2 Caneluri – DMM 6 – Cilindrică – Rază la vârf





G

—Toleranţe:
—Bătaie radială= <0,007 mm
—DMM= h5
—DC= 0,-0,013 mm
—RE= ±0,005 mm



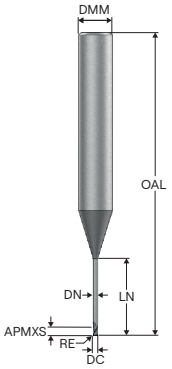
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	13,48	2	Cylindrical	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	12,9	2	Cylindrical	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	12,28	2	Cylindrical	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	10,85	2	Cylindrical	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	10,31	2	Cylindrical	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	9,67	2	Cylindrical	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	9,12	2	Cylindrical	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	8,53	2	Cylindrical	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	7,15	2	Cylindrical	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	5,81	2	Cylindrical	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	11,54	2	Cylindrical	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	10,93	2	Cylindrical	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	9,81	2	Cylindrical	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	8,86	2	Cylindrical	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	8,0	2	Cylindrical	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	6,86	2	Cylindrical	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	5,36	2	Cylindrical	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	3,22	2	Cylindrical	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	10,42	2	Cylindrical	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	9,71	2	Cylindrical	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	8,48	2	Cylindrical	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	7,48	2	Cylindrical	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	6,62	2	Cylindrical	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	5,54	2	Cylindrical	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	4,19	2	Cylindrical	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2,41	2	Cylindrical	■

■ **Stoc standard.**

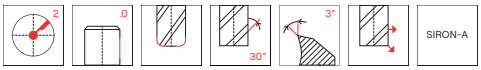
JME562

Miniatură – Universale – Pătrat – 2 Caneluri – DMM 6 – Cilindrică – Rază la vârf





G



—Toleranţe:
—Bătaie radială= <0,007 mm
—DMM= h5
—DC= 0,-0,013 mm
—RE= ±0,005 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JME562010G6R010.0Z2-SIRA	03171175	6	G	1,0	6,0	1,5	60,0	15,0	0,95	0,1	5,94	2	Cylindrical	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	5,14	2	Cylindrical	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	4,2	2	Cylindrical	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	3,07	2	Cylindrical	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	1,7	2	Cylindrical	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	4,93	2	Cylindrical	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	4,2	2	Cylindrical	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	3,38	2	Cylindrical	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2,42	2	Cylindrical	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	1,31	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JME562 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300 — 1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200 — 1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100 — 1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920 — 1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92 — 130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890 — 1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JME562 Frezare de canal

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.022	0.022	0.026	0.028	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00085*	*0,00085*	*0,0010*	*0,0011*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.048	0.050	350 (300 — 400)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*1150 (990 — 1300)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	110 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*360 (310 — 390)*
H3	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 400)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1300)*

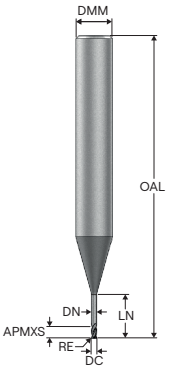
Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JME564

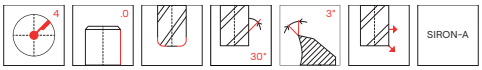
Miniatură – Universale – Pătrat – 4 Caneluri – DMM 6 – Cilindrică – Rază la vârf





G

—Toleranţe:
—Bătaie radială= <0-0,007 mm
—DMM= h5
—DC= 0,-0,013 mm
—RE= ±0,005 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JME564005G2R005.0Z4-SIRA	03227166	2	G	0,5	6,0	1,0	50,0	1,5	0,46	0,05	13,48	4	Cylindrical	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	12,9	4	Cylindrical	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	12,28	4	Cylindrical	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	10,85	4	Cylindrical	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	10,31	4	Cylindrical	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	9,67	4	Cylindrical	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	8,53	4	Cylindrical	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	7,15	4	Cylindrical	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	5,81	4	Cylindrical	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	11,54	4	Cylindrical	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	10,93	4	Cylindrical	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	9,81	4	Cylindrical	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	8,86	4	Cylindrical	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	8,0	4	Cylindrical	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	6,86	4	Cylindrical	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	5,36	4	Cylindrical	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	3,22	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JME564 Degroşare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z									v_c
				0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (360 — 430) *1300 (1200 — 1400)*
P2	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P3	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P4	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P5	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P6	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 320) *970 (890 — 1000)*
P8	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P11	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (260 — 310) *940 (860 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (160 — 180) *560 (530 — 590)*
M1	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (200 — 280) *770 (660 — 910)*
M2	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M3	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M4	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	145 (120 — 160) *475 (400 — 520)*
M5	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (99 — 140) *395 (330 — 450)*
N1	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 410) *1200 (1100 — 1300)*
N11	E/M/A	0.100 *0,100*	0.90 *0,90*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	490 (430 — 560) *1600 (1500 — 1800)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (250 — 320) *940 (830 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 250) *720 (630 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (150 — 190) *560 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H5	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	240 (210 — 260) *790 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H8	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (270 — 340) *1000 (890 — 1100)*
H12	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	275 (250 — 310) *900 (830 — 1000)*
H21	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.048 *0,0019*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.65 *0,50*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	390 (340 — 440) *1300 (1200 — 1400)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JME564 Frezare de canal

SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	245 (220 — 270) *800 (730 — 880)*
P3	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	210 (190 — 230) *690 (630 — 750)*
P4	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P5	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P6	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P8	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P11	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P12	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.026 *0,0010*	0.030 *0,0012*	105 (96 — 110) *345 (320 — 360)*
M1	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (110 — 150) *445 (370 — 490)*
M2	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M3	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M4	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (67 — 95) *260 (220 — 310)*
M5	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (56 — 79) *215 (190 — 250)*
N1	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N2	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N3	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	260 (230 — 290) *850 (760 — 950)*
N11	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	345 (300 — 390) *1125 (990 — 1200)*
S11	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 150) *445 (400 — 490)*
S13	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	105 (92 — 120) *345 (310 — 390)*
H3	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H5	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (140 — 170) *520 (460 — 550)*
H7	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H8	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H11	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
H12	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	185 (170 — 200) *610 (560 — 650)*
H21	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H31	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.20 *0,20*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.024 *0,00095*	0.026 *0,0010*	325 (280 — 370) *1075 (920 — 1200)*

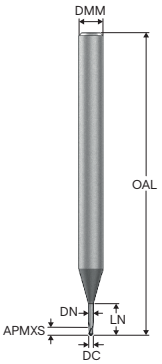
Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

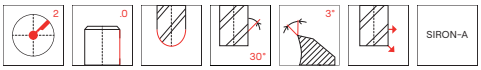
JMB542

Miniatură – Universale – Cap sferic – 2 Caneluri – DMM 4 – Cilindrică





G



—Toleranţe:
—Bătaie radială=<0,007 mm
—DMM= h5
—DC= 0,-0,01 mm
—RE= ±0,005 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JMB542002G1B.0Z2-SIRA	03171221	1	G	0,2	4,0	0,2	45,0	0,4	0,18	0,1	14,57	2	Cylindrical	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	14,24	2	Cylindrical	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	13,81	2	Cylindrical	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	13,47	2	Cylindrical	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	13,14	2	Cylindrical	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	12,46	2	Cylindrical	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	11,77	2	Cylindrical	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	11,07	2	Cylindrical	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	9,88	2	Cylindrical	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	11,25	2	Cylindrical	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	10,61	2	Cylindrical	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	9,44	2	Cylindrical	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	8,38	2	Cylindrical	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,44	2	Cylindrical	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	6,13	2	Cylindrical	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,4	2	Cylindrical	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	1,81	2	Cylindrical	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	9,65	2	Cylindrical	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	8,74	2	Cylindrical	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	7,23	2	Cylindrical	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	6,27	2	Cylindrical	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	5,44	2	Cylindrical	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	4,44	2	Cylindrical	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	3,02	2	Cylindrical	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	1,16	2	Cylindrical	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	3,75	2	Cylindrical	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2,5	2	Cylindrical	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	0,93	2	Cylindrical	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2,7	2	Cylindrical	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	1,74	2	Cylindrical	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	0,63	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JMB542 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100 — 1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920 — 1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860 — 1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140 — 170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110 — 150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90 — 120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300 — 1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830 — 1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200 — 1500)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JMB542 Frezare de canal

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (300 — 390)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (990 — 1200)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	105 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*345 (310 — 390)*
H3	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 390)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1200)*

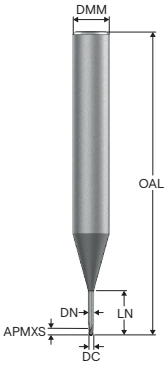
Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JMB562

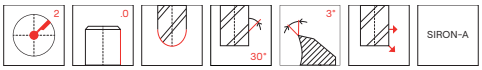
Miniatură – Universale – Cap sferic – 2 Caneluri – DMM 6 – Cilindrică





G

—Toleranţe:
—Bătaie radială=<0,007 mm
—DMM= h5
—DC= 0,-0,01 mm
—RE= ±0,005 mm



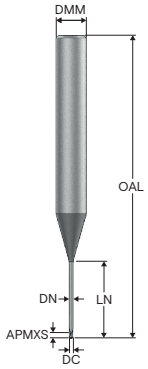
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	13,69	2	Cylindrical	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	13,13	2	Cylindrical	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	12,6	2	Cylindrical	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	2	Cylindrical	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	2	Cylindrical	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	2	Cylindrical	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	9,61	2	Cylindrical	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	2	Cylindrical	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	2	Cylindrical	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	2	Cylindrical	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	11,7	2	Cylindrical	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	11,1	2	Cylindrical	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	10,02	2	Cylindrical	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	2	Cylindrical	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	2	Cylindrical	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	2	Cylindrical	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	2	Cylindrical	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	2	Cylindrical	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	10,54	2	Cylindrical	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,85	2	Cylindrical	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,64	2	Cylindrical	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	2	Cylindrical	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	6,77	2	Cylindrical	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	5,68	2	Cylindrical	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	4,32	2	Cylindrical	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2,5	2	Cylindrical	■

■ **Stoc standard.**

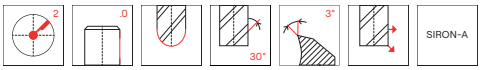
JMB562

Miniatură – Universale – Cap sferic – 2 Caneluri – DMM 6 – Cilindrică





G



—Toleranţe:
—Bătaie radială=<0,007 mm
—DMM= h5
—DC= 0,-0,01 mm
—RE= ±0,005 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JMB562010G6B.0Z2-SIRA	03171290	6	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	6,04	2	Cylindrical	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	5,24	2	Cylindrical	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	4,28	2	Cylindrical	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	3,14	2	Cylindrical	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	1,74	2	Cylindrical	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	2	Cylindrical	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	4,27	2	Cylindrical	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	3,43	2	Cylindrical	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2,47	2	Cylindrical	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	1,34	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JMB562 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100 — 1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920 — 1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860 — 1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140 — 170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110 — 150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90 — 120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300 — 1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830 — 1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200 — 1500)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JMB562 Frezare de canal

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (300 — 390)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (990 — 1200)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	105 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*345 (310 — 390)*
H3	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 390)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1200)*

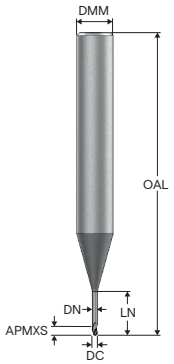
Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JMB563

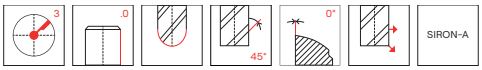
Miniatură – Universale – Cap sferic – 3 Caneluri – DMM 6 – Cilindrică





G

—Toleranţe:
—Bătaie radială=<0,007 mm
—DMM= h5
—DC= 0,-0,02 mm
—RE= ±0,01 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JMB563010G2B.0Z3-SIRA	03171307	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	3	Cylindrical	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	3	Cylindrical	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	3	Cylindrical	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	3	Cylindrical	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	3	Cylindrical	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	3	Cylindrical	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	3	Cylindrical	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	3	Cylindrical	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	3	Cylindrical	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	3	Cylindrical	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	3	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JMB563 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z						v_c
				1	1.2	1.5	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	460 (410 — 500) *1500 (1400 — 1600)*
P2	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	445 (400 — 490) *1450 (1400 — 1600)*
P3	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P4	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 370) *1125 (1100 — 1200)*
P5	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P6	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P7	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 380) *1125 (1100 — 1200)*
P8	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P11	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	230 (190 — 270) *750 (630 — 880)*
P12	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
M1	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (230 — 320) *890 (760 — 1000)*
M2	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M3	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M4	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	165 (140 — 190) *540 (460 — 620)*
M5	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N2	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N3	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (350 — 440) *1300 (1200 — 1400)*
N11	E/M/A	0.100 *0,100*	0.65 *0,65*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	520 (450 — 590) *1700 (1500 — 1900)*
S11	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (300 — 390) *1125 (990 — 1200)*
S12	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (230 — 300) *870 (760 — 980)*
S13	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (180 — 230) *670 (600 — 750)*
H3	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H7	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	375 (330 — 420) *1225 (1100 — 1300)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (310 — 380) *1125 (1100 — 1200)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	450 (390 — 510) *1475 (1300 — 1600)*

Tabel bazat pe LV1, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



OȚEL ȘI FONTĂ

Seco oferă o gamă completă de freze cilindro-frontale din carbură solidă de înaltă performanţă pentru frezare cilindro-frontală, freze cu cap rotund și freze cilindro-frontale de finisare pentru productivitate ridicată în oţel și fontă.

- ST5541, JHP993, JHP951 și JH142 pentru tip șanfren sau rază.
- ST5341, JHB970, JH112, JH150, JH160 pentru tip cu cap rotund.

Alegerea uneltei - Oţel și fontă

							
Nume		ST5541	JHP993	JHP951	JH142	ST5341	JHB970
Pag.		276	293	299	303, 514	306	228, 311
Familia		Stabilizer	HPM	HPM	HSM/TORNADO	Stabilizer	HSM/TORNADO
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon	□	■	■		□	
Numărul de dinţi		4	3,4,5	3,4,5	2-4-5-6	4	2
CSP							
	Metric	3-25	4-25	3-20	2-12	6-20	2-16
	Inch	1/8-1				1/4-1	
Lungimi disponibile		1,2,3,4	2,3	2	2,3,6	2.3	1,2,3
Operaţiune							
							
							
SMG							
P1		●	●	●	●	●	●
P2		●	●	●	●	●	●
P3		●	●	●	●	●	●
P4		●	●	●	●	●	●
P5		●	●	●	●	●	●
P6		●	●	●	●	●	●
P7		●	●	●	●	●	●
P8		●	●	●	●	●	●
P11-12		●	○	○	●	●	○
K1		●	●	●	●	●	
K2		●	●	●	●	●	
K3		●	●	●	●	●	
K4		●	●	●	●	●	
K5		●	●	●	●	●	
K6		●	●	●	●	●	
K7		●	●	●	●	●	

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Oţel și fontă

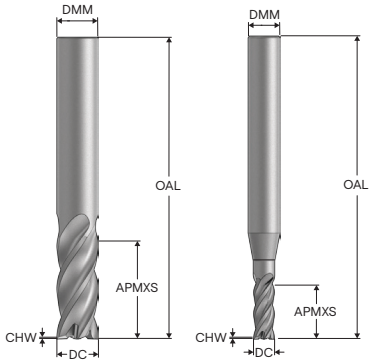
				
Nume		JH112	JH150	JH160
Pag.		313, 517	520	522
Familia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipul frezei				
Coada	Cilindrică	■	■	■
	Weldon			
Numărul de dinţi		2	4	4
CSP				
	Metric	2-12	6-12	3-12
	Inch			
Lungimi disponibile		1,2,3,4,5,6	2	2
Operaţiune				
				
SMG				
P1				●
P2				●
P3				●
P4				●
P5				●
P6				●
P7				●
P8				●
P11-12				○
K1		●	●	
K2		●	●	
K3		●	●	
K4		●	●	
K5		●	●	
K6		●	●	
K7		●	●	

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

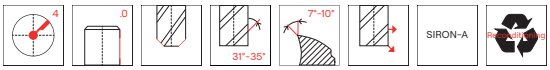
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Șanfren





- Toleranţe:
- DMM=h5
- DC=e7
- Reascuţire posibilă dacă DC este ≥ Ø6



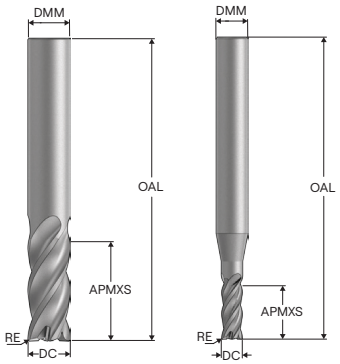
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5541-030F2C.0Z4	SIRA	10302942	2	F	3,0	6,0	7,0	58,0	0,035	4	Cylindrical	■
ST5541-040F2C.0Z4	SIRA	10302943	2	F	4,0	6,0	10,0	58,0	0,045	4	Cylindrical	■
ST5541-050F2C.0Z4	SIRA	10302944	2	F	5,0	6,0	12,0	58,0	0,055	4	Cylindrical	■
ST5541-060D2C.0Z4	SIRA	10302945	2	D	6,0	6,0	14,0	58,0	0,075	4	Cylindrical	■
ST5541-080D2C.0Z4	SIRA	10302946	2	D	8,0	8,0	18,0	64,0	0,1	4	Cylindrical	■
ST5541-100D2C.0Z4	SIRA	10302947	2	D	10,0	10,0	22,0	73,0	0,125	4	Cylindrical	■
ST5541-120D2C.0Z4	SIRA	10302948	2	D	12,0	12,0	26,0	84,0	0,15	4	Cylindrical	■
ST5541-160D2C.0Z4	SIRA	10302949	2	D	16,0	16,0	34,0	95,0	0,2	4	Cylindrical	■
ST5541-200D2C.0Z4	SIRA	10302950	2	D	20,0	20,0	42,0	109,0	0,25	4	Cylindrical	■
ST5541-250D2C.0Z4	SIRA	10302951	2	D	25,0	25,0	52,0	125,0	0,3	4	Cylindrical	■
ST5541-030F3C.0Z4	SIRA	10302952	3	F	3,0	6,0	9,0	58,0	0,035	4	Cylindrical	■
ST5541-040F3C.0Z4	SIRA	10302953	3	F	4,0	6,0	12,0	58,0	0,045	4	Cylindrical	■
ST5541-050F3C.0Z4	SIRA	10302954	3	F	5,0	6,0	15,0	58,0	0,055	4	Cylindrical	■
ST5541-060D3C.0Z4	SIRA	10302955	3	D	6,0	6,0	18,0	64,0	0,075	4	Cylindrical	■
ST5541-080D3C.0Z4	SIRA	10302956	3	D	8,0	8,0	24,0	73,0	0,1	4	Cylindrical	■
ST5541-100D3C.0Z4	SIRA	10302957	3	D	10,0	10,0	30,0	85,0	0,125	4	Cylindrical	■
ST5541-120D3C.0Z4	SIRA	10302958	3	D	12,0	12,0	36,0	100,0	0,15	4	Cylindrical	■
ST5541-160D3C.0Z4	SIRA	10302959	3	D	16,0	16,0	48,0	115,0	0,2	4	Cylindrical	■
ST5541-200D3C.0Z4	SIRA	10302960	3	D	20,0	20,0	60,0	125,0	0,25	4	Cylindrical	■
ST5541-250D3C.0Z4	SIRA	10302961	3	D	25,0	25,0	75,0	155,0	0,3	4	Cylindrical	■

■ **Stoc standard.**

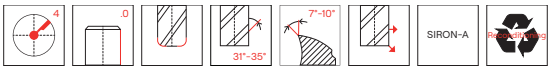
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



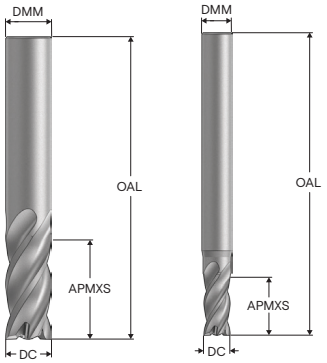
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5541-030F2R020.0Z4	SIRA	10302962	2	F	3,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
ST5541-040F2R020.0Z4	SIRA	10302963	2	F	4,0	6,0	10,0	58,0	0,2	4	Cylindrical	■
ST5541-050F2R020.0Z4	SIRA	10302964	2	F	5,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-060D2R050.0Z4	SIRA	10302965	2	D	6,0	6,0	14,0	58,0	0,5	4	Cylindrical	■
ST5541-080D2R050.0Z4	SIRA	10302966	2	D	8,0	8,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-100D2R050.0Z4	SIRA	10302967	2	D	10,0	10,0	22,0	73,0	0,5	4	Cylindrical	■
ST5541-120D2R050.0Z4	SIRA	10302968	2	D	12,0	12,0	26,0	84,0	0,5	4	Cylindrical	■
ST5541-120D2R100.0Z4	SIRA	10302969	2	D	12,0	12,0	26,0	84,0	1,0	4	Cylindrical	■
ST5541-160D2R050.0Z4	SIRA	10302970	2	D	16,0	16,0	34,0	95,0	0,5	4	Cylindrical	■
ST5541-160D2R100.0Z4	SIRA	10302972	2	D	16,0	16,0	34,0	95,0	1,0	4	Cylindrical	■
ST5541-160D2R300.0Z4	SIRA	10302971	2	D	16,0	16,0	34,0	95,0	3,0	4	Cylindrical	■
ST5541-200D2R050.0Z4	SIRA	10302973	2	D	20,0	20,0	42,0	109,0	0,5	4	Cylindrical	■
ST5541-200D2R100.0Z4	SIRA	10302975	2	D	20,0	20,0	42,0	109,0	1,0	4	Cylindrical	■
ST5541-200D2R300.0Z4	SIRA	10302974	2	D	20,0	20,0	42,0	109,0	3,0	4	Cylindrical	■
ST5541-250D2R050.0Z4	SIRA	10302976	2	D	25,0	25,0	52,0	125,0	0,5	4	Cylindrical	■
ST5541-250D2R100.0Z4	SIRA	10302978	2	D	25,0	25,0	52,0	125,0	1,0	4	Cylindrical	■
ST5541-250D2R300.0Z4	SIRA	10302977	2	D	25,0	25,0	52,0	125,0	3,0	4	Cylindrical	■
ST5541-030F3R020.0Z4	SIRA	10302979	3	F	3,0	6,0	9,0	58,0	0,2	4	Cylindrical	■
ST5541-040F3R020.0Z4	SIRA	10302980	3	F	4,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-050F3R020.0Z4	SIRA	10302981	3	F	5,0	6,0	15,0	58,0	0,2	4	Cylindrical	■
ST5541-060D3R050.0Z4	SIRA	10302982	3	D	6,0	6,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-080D3R050.0Z4	SIRA	10302983	3	D	8,0	8,0	24,0	73,0	0,5	4	Cylindrical	■
ST5541-100D3R050.0Z4	SIRA	10302984	3	D	10,0	10,0	30,0	85,0	0,5	4	Cylindrical	■
ST5541-120D3R050.0Z4	SIRA	10302985	3	D	12,0	12,0	36,0	100,0	0,5	4	Cylindrical	■
ST5541-120D3R100.0Z4	SIRA	10302986	3	D	12,0	12,0	36,0	100,0	1,0	4	Cylindrical	■
ST5541-160D3R050.0Z4	SIRA	10302987	3	D	16,0	16,0	48,0	115,0	0,5	4	Cylindrical	■
ST5541-160D3R100.0Z4	SIRA	10302989	3	D	16,0	16,0	48,0	115,0	1,0	4	Cylindrical	■
ST5541-160D3R300.0Z4	SIRA	10302988	3	D	16,0	16,0	48,0	115,0	3,0	4	Cylindrical	■
ST5541-200D3R050.0Z4	SIRA	10302990	3	D	20,0	20,0	60,0	125,0	0,5	4	Cylindrical	■
ST5541-200D3R100.0Z4	SIRA	10302992	3	D	20,0	20,0	60,0	125,0	1,0	4	Cylindrical	■
ST5541-200D3R300.0Z4	SIRA	10302991	3	D	20,0	20,0	60,0	125,0	3,0	4	Cylindrical	■
ST5541-250D3R050.0Z4	SIRA	10302993	3	D	25,0	25,0	75,0	155,0	0,5	4	Cylindrical	■
ST5541-250D3R100.0Z4	SIRA	10302995	3	D	25,0	25,0	75,0	155,0	1,0	4	Cylindrical	■
ST5541-250D3R300.0Z4	SIRA	10302994	3	D	25,0	25,0	75,0	155,0	3,0	4	Cylindrical	■

■ **Stoc standard.**

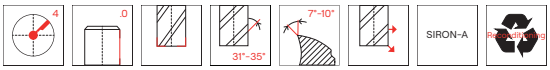
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Reascuţire posibilă dacă DC este ≥ Ø.250



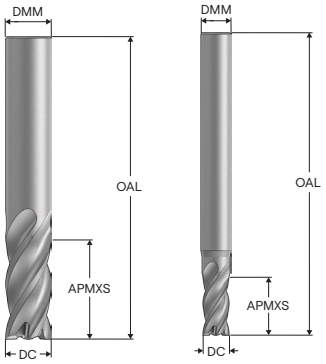
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
ST5541-.125D1S.0Z4	SIRA	10302742	1	D	0.125	0.125	0.125	1.500	4	Cylindrical	■
ST5541-.156F1S.0Z4	SIRA	10302743	1	F	0.156	0.188	0.156	2.000	4	Cylindrical	■
ST5541-.188D1S.0Z4	SIRA	10302744	1	D	0.188	0.188	0.188	2.000	4	Cylindrical	■
ST5541-.219F1S.0Z4	SIRA	10302745	1	F	0.219	0.250	0.219	2.000	4	Cylindrical	■
ST5541-.250D1S.0Z4	SIRA	10302746	1	D	0.250	0.250	0.250	2.000	4	Cylindrical	■
ST5541-.281F1S.0Z4	SIRA	10302747	1	F	0.281	0.313	0.281	2.000	4	Cylindrical	■
ST5541-.313D1S.0Z4	SIRA	10302748	1	D	0.313	0.313	0.313	2.000	4	Cylindrical	■
ST5541-.375D1S.0Z4	SIRA	10302749	1	D	0.375	0.375	0.375	2.000	4	Cylindrical	■
ST5541-.438D1S.0Z4	SIRA	10302750	1	D	0.438	0.438	0.438	2.750	4	Cylindrical	■
ST5541-.500D1S.0Z4	SIRA	10302751	1	D	0.500	0.500	0.500	2.500	4	Cylindrical	■
ST5541-.625D1S.0Z4	SIRA	10302752	1	D	0.625	0.625	0.625	3.000	4	Cylindrical	■
ST5541-.750D1S.0Z4	SIRA	10302753	1	D	0.750	0.750	0.750	3.000	4	Cylindrical	■
ST5541-.875D1S.0Z4	SIRA	10302754	1	D	0.875	0.875	0.875	4.000	4	Cylindrical	■
ST5541-1.00D1S.0Z4	SIRA	10302755	1	D	1.000	1.000	1.000	4.000	4	Cylindrical	■
ST5541-.125D2S.0Z4	SIRA	10302756	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
ST5541-.156F2S.0Z4	SIRA	10302757	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
ST5541-.188D2S.0Z4	SIRA	10302758	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
ST5541-.219F2S.0Z4	SIRA	10302759	2	F	0.219	0.250	0.438	2.500	4	Cylindrical	■
ST5541-.250D2S.0Z4	SIRA	10302760	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
ST5541-.281F2S.0Z4	SIRA	10302761	2	F	0.281	0.313	0.563	2.500	4	Cylindrical	■
ST5541-.313D2S.0Z4	SIRA	10302762	2	D	0.313	0.313	0.625	2.500	4	Cylindrical	■
ST5541-.375D2S.0Z4	SIRA	10302763	2	D	0.375	0.375	0.750	2.500	4	Cylindrical	■
ST5541-.438D2S.0Z4	SIRA	10302764	2	D	0.438	0.438	0.875	2.750	4	Cylindrical	■
ST5541-.500D2S.0Z4	SIRA	10302765	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
ST5541-.625D2S.0Z4	SIRA	10302766	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
ST5541-.750D2S.0Z4	SIRA	10302767	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
ST5541-.875D2S.0Z4	SIRA	10302768	2	D	0.875	0.875	1.750	4.000	4	Cylindrical	■
ST5541-1.00D2S.0Z4	SIRA	10302769	2	D	1.000	1.000	2.000	5.000	4	Cylindrical	■

■ **Stoc standard.**

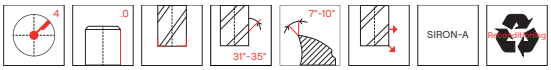
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Reascuţire posibilă dacă DC este ≥ Ø.250



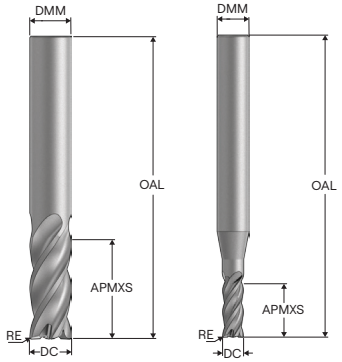
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
ST5541-.125D3S.0Z4	SIRA	10302770	3	D	0.125	0.125	0.375	1.500	4	Cylindrical	■
ST5541-.156F3S.0Z4	SIRA	10302771	3	F	0.156	0.188	0.469	2.000	4	Cylindrical	■
ST5541-.188D3S.0Z4	SIRA	10302772	3	D	0.188	0.188	0.563	2.000	4	Cylindrical	■
ST5541-.219F3S.0Z4	SIRA	10302773	3	F	0.219	0.250	0.656	2.500	4	Cylindrical	■
ST5541-.250D3S.0Z4	SIRA	10302774	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
ST5541-.281F3S.0Z4	SIRA	10302775	3	F	0.281	0.313	0.844	2.500	4	Cylindrical	■
ST5541-.313D3S.0Z4	SIRA	10302776	3	D	0.313	0.313	0.938	2.500	4	Cylindrical	■
ST5541-.375D3S.0Z4	SIRA	10302777	3	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
ST5541-.438D3S.0Z4	SIRA	10302778	3	D	0.438	0.438	1.313	4.000	4	Cylindrical	■
ST5541-.500D3S.0Z4	SIRA	10302779	3	D	0.500	0.500	1.250	3.000	4	Cylindrical	■
ST5541-.625D3S.0Z4	SIRA	10302780	3	D	0.625	0.625	1.875	4.000	4	Cylindrical	■
ST5541-.750D3S.0Z4	SIRA	10302781	3	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
ST5541-.875D3S.0Z4	SIRA	10302782	3	D	0.875	0.875	2.625	5.000	4	Cylindrical	■
ST5541-1.00D3S.0Z4	SIRA	10302783	3	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
ST5541-.500D4S.0Z4	SIRA	10302784	4	D	0.500	0.500	1.500	4.000	4	Cylindrical	■

■ **Stoc standard.**

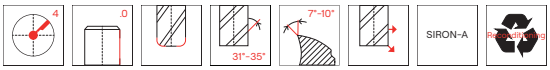
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă dacă DC este ≥ Ø.250



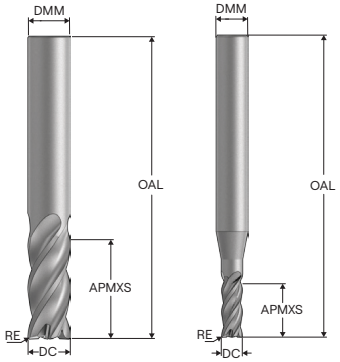
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5541-.125D1R010.0Z4	SIRA	10302785	1	D	0.125	0.125	0.125	1.500	0.010	4	Cylindrical	■
ST5541-.156F1R010.0Z4	SIRA	10302786	1	F	0.156	0.188	0.156	2.000	0.010	4	Cylindrical	■
ST5541-.188D1R010.0Z4	SIRA	10302787	1	D	0.188	0.188	0.188	2.000	0.010	4	Cylindrical	■
ST5541-.219F1R020.0Z4	SIRA	10302788	1	F	0.219	0.250	0.219	2.000	0.020	4	Cylindrical	■
ST5541-.250D1R020.0Z4	SIRA	10302789	1	D	0.250	0.250	0.250	2.000	0.020	4	Cylindrical	■
ST5541-.281F1R020.0Z4	SIRA	10302790	1	F	0.281	0.313	0.281	2.000	0.020	4	Cylindrical	■
ST5541-.313D1R020.0Z4	SIRA	10302791	1	D	0.313	0.313	0.313	2.000	0.020	4	Cylindrical	■
ST5541-.375D1R020.0Z4	SIRA	10302792	1	D	0.375	0.375	0.375	2.000	0.020	4	Cylindrical	■
ST5541-.438D1R020.0Z4	SIRA	10302793	1	D	0.438	0.438	0.438	2.750	0.020	4	Cylindrical	■
ST5541-.500D1R030.0Z4	SIRA	10302794	1	D	0.500	0.500	0.500	2.500	0.030	4	Cylindrical	■
ST5541-.625D1R030.0Z4	SIRA	10302795	1	D	0.625	0.625	0.625	3.000	0.030	4	Cylindrical	■
ST5541-.750D1R030.0Z4	SIRA	10302796	1	D	0.750	0.750	0.750	3.000	0.030	4	Cylindrical	■
ST5541-.875D1R030.0Z4	SIRA	10302797	1	D	0.875	0.875	0.875	4.000	0.030	4	Cylindrical	■
ST5541-1.00D1R030.0Z4	SIRA	10302798	1	D	1.000	1.000	1.000	4.000	0.030	4	Cylindrical	■
ST5541-.125D2R010.0Z4	SIRA	10302799	2	D	0.125	0.125	0.250	1.500	0.010	4	Cylindrical	■
ST5541-.156F2R010.0Z4	SIRA	10302800	2	F	0.156	0.188	0.313	2.000	0.010	4	Cylindrical	■
ST5541-.188D2R010.0Z4	SIRA	10302801	2	D	0.188	0.188	0.375	2.000	0.010	4	Cylindrical	■
ST5541-.219F2R020.0Z4	SIRA	10302802	2	F	0.219	0.250	0.438	2.500	0.020	4	Cylindrical	■
ST5541-.250D2R020.0Z4	SIRA	10302803	2	D	0.250	0.250	0.500	2.500	0.020	4	Cylindrical	■
ST5541-.281F2R020.0Z4	SIRA	10302805	2	F	0.281	0.313	0.563	2.500	0.020	4	Cylindrical	■
ST5541-.313D2R020.0Z4	SIRA	10302806	2	D	0.313	0.313	0.625	2.500	0.020	4	Cylindrical	■
ST5541-.375D2R020.0Z4	SIRA	10302808	2	D	0.375	0.375	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.438D2R020.0Z4	SIRA	10302810	2	D	0.438	0.438	0.875	2.750	0.020	4	Cylindrical	■
ST5541-.500D2R030.0Z4	SIRA	10302812	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
ST5541-.500D2R060.0Z4	SIRA	10302813	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
ST5541-.500D2R120.0Z4	SIRA	10302814	2	D	0.500	0.500	1.000	3.000	0.120	4	Cylindrical	■
ST5541-.625D2R030.0Z4	SIRA	10302816	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
ST5541-.625D2R060.0Z4	SIRA	10302817	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
ST5541-.625D2R090.0Z4	SIRA	10302818	2	D	0.625	0.625	1.250	3.500	0.090	4	Cylindrical	■
ST5541-.625D2R120.0Z4	SIRA	10302819	2	D	0.625	0.625	1.250	3.500	0.120	4	Cylindrical	■
ST5541-.750D2R030.0Z4	SIRA	10302821	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
ST5541-.750D2R060.0Z4	SIRA	10302822	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
ST5541-.750D2R090.0Z4	SIRA	10302823	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
ST5541-.750D2R120.0Z4	SIRA	10302824	2	D	0.750	0.750	1.500	4.000	0.120	4	Cylindrical	■
ST5541-.750D2R250.0Z4	SIRA	10302825	2	D	0.750	0.750	1.500	4.000	0.250	4	Cylindrical	■
ST5541-.875D2R030.0Z4	SIRA	10302827	2	D	0.875	0.875	1.750	4.000	0.030	4	Cylindrical	■
ST5541-1.00D2R030.0Z4	SIRA	10302828	2	D	1.000	1.000	2.000	5.000	0.030	4	Cylindrical	■

■ **Stoc standard.**

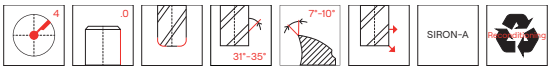
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă dacă DC este ≥ Ø.250



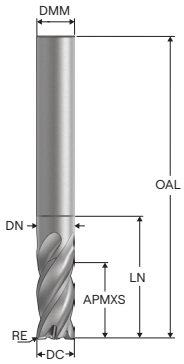
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5541-.125D3R010.0Z4	SIRA	10302830	3	D	0.125	0.125	0.375	1.500	0.010	4	Cylindrical	■
ST5541-.156F3R010.0Z4	SIRA	10302831	3	F	0.156	0.188	0.469	2.000	0.010	4	Cylindrical	■
ST5541-.188D3R010.0Z4	SIRA	10302832	3	D	0.188	0.188	0.563	2.000	0.010	4	Cylindrical	■
ST5541-.219F3R020.0Z4	SIRA	10302833	3	F	0.219	0.250	0.656	2.500	0.020	4	Cylindrical	■
ST5541-.250D3R020.0Z4	SIRA	10302834	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.281F3R020.0Z4	SIRA	10302835	3	F	0.281	0.313	0.844	2.500	0.020	4	Cylindrical	■
ST5541-.313D3R020.0Z4	SIRA	10302836	3	D	0.313	0.313	0.938	2.500	0.020	4	Cylindrical	■
ST5541-.375D3R020.0Z4	SIRA	10302837	3	D	0.375	0.375	1.125	3.000	0.020	4	Cylindrical	■
ST5541-.438D3R020.0Z4	SIRA	10302838	3	D	0.438	0.438	1.313	4.000	0.020	4	Cylindrical	■
ST5541-.500D3R030.0Z4	SIRA	10302839	3	D	0.500	0.500	1.250	3.000	0.030	4	Cylindrical	■
ST5541-.500D3R060.0Z4	SIRA	10302840	3	D	0.500	0.500	1.250	3.000	0.060	4	Cylindrical	■
ST5541-.500D3R120.0Z4	SIRA	10302841	3	D	0.500	0.500	1.250	3.000	0.120	4	Cylindrical	■
ST5541-.625D3R030.0Z4	SIRA	10302842	3	D	0.625	0.625	1.875	4.000	0.030	4	Cylindrical	■
ST5541-.625D3R060.0Z4	SIRA	10302843	3	D	0.625	0.625	1.875	4.000	0.060	4	Cylindrical	■
ST5541-.625D3R090.0Z4	SIRA	10302844	3	D	0.625	0.625	1.875	4.000	0.090	4	Cylindrical	■
ST5541-.625D3R120.0Z4	SIRA	10302845	3	D	0.625	0.625	1.875	4.000	0.120	4	Cylindrical	■
ST5541-.750D3R030.0Z4	SIRA	10302846	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
ST5541-.750D3R060.0Z4	SIRA	10302847	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■
ST5541-.750D3R090.0Z4	SIRA	10302848	3	D	0.750	0.750	2.250	5.000	0.090	4	Cylindrical	■
ST5541-.750D3R120.0Z4	SIRA	10302849	3	D	0.750	0.750	2.250	5.000	0.120	4	Cylindrical	■
ST5541-.750D3R250.0Z4	SIRA	10302850	3	D	0.750	0.750	2.250	5.000	0.250	4	Cylindrical	■
ST5541-.875D3R030.0Z4	SIRA	10302851	3	D	0.875	0.875	2.625	5.000	0.030	4	Cylindrical	■
ST5541-1.00D3R030.0Z4	SIRA	10302852	3	D	1.000	1.000	3.000	6.000	0.030	4	Cylindrical	■
ST5541-.500D4R030.0Z4	SIRA	10302853	4	D	0.500	0.500	1.500	4.000	0.030	4	Cylindrical	■

■ **Stoc standard.**

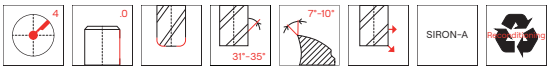
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf – Inci





- Toleranţe:
- DMM= -.0001"/-.0004"
- DC= + .000" / - .002"
- RE= ±.0008"
- Reascuţire posibilă



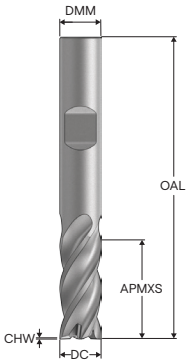
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5541-.250E2R020.0Z4	SIRA	10302804	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Cylindrical	■
ST5541-.313E2R020.0Z4	SIRA	10302807	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Cylindrical	■
ST5541-.375E2R020.0Z4	SIRA	10302809	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Cylindrical	■
ST5541-.438E2R020.0Z4	SIRA	10302811	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Cylindrical	■
ST5541-.500E2R030.0Z4	SIRA	10302815	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Cylindrical	■
ST5541-.625E2R030.0Z4	SIRA	10302820	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Cylindrical	■
ST5541-.750E2R030.0Z4	SIRA	10302826	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Cylindrical	■
ST5541-1.00E2R030.0Z4	SIRA	10302829	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Cylindrical	■

■ **Stoc standard.**

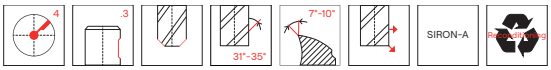
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Șanfren





—Toleranţe:
—DMM=h5
—DC=e7
—Reascuţire posibilă



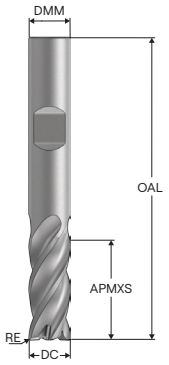
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5541-060D2C.3Z4	SIRA	10302996	2	D	6,0	6,0	14,0	58,0	0,075	4	Weldon	□
ST5541-080D2C.3Z4	SIRA	10302997	2	D	8,0	8,0	18,0	64,0	0,1	4	Weldon	□
ST5541-100D2C.3Z4	SIRA	10302998	2	D	10,0	10,0	22,0	73,0	0,125	4	Weldon	□
ST5541-120D2C.3Z4	SIRA	10302999	2	D	12,0	12,0	26,0	84,0	0,15	4	Weldon	□
ST5541-160D2C.3Z4	SIRA	10303000	2	D	16,0	16,0	34,0	95,0	0,2	4	Weldon	□
ST5541-200D2C.3Z4	SIRA	10303001	2	D	20,0	20,0	42,0	109,0	0,25	4	Weldon	□
ST5541-250D2C.3Z4	SIRA	10303002	2	D	25,0	25,0	52,0	125,0	0,3	4	Weldon	□
ST5541-060D3C.3Z4	SIRA	10303003	3	D	6,0	6,0	18,0	64,0	0,075	4	Weldon	□
ST5541-080D3C.3Z4	SIRA	10303004	3	D	8,0	8,0	24,0	73,0	0,1	4	Weldon	□
ST5541-100D3C.3Z4	SIRA	10303005	3	D	10,0	10,0	30,0	85,0	0,125	4	Weldon	□
ST5541-120D3C.3Z4	SIRA	10303006	3	D	12,0	12,0	36,0	100,0	0,15	4	Weldon	□
ST5541-160D3C.3Z4	SIRA	10303007	3	D	16,0	16,0	48,0	115,0	0,2	4	Weldon	□
ST5541-200D3C.3Z4	SIRA	10303008	3	D	20,0	20,0	60,0	125,0	0,25	4	Weldon	□
ST5541-250D3C.3Z4	SIRA	10303009	3	D	25,0	25,0	75,0	155,0	0,3	4	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

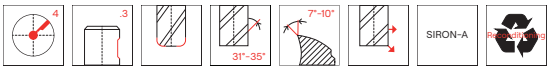
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă



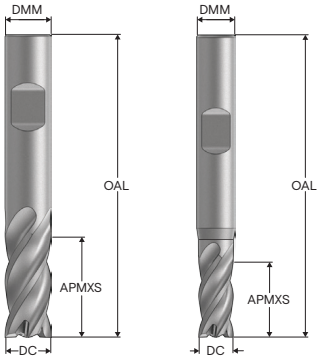
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5541-060D2R050.3Z4	SIRA	10303010	2	D	6,0	6,0	14,0	58,0	0,5	4	Weldon	☐
ST5541-080D2R050.3Z4	SIRA	10303011	2	D	8,0	8,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-100D2R050.3Z4	SIRA	10303012	2	D	10,0	10,0	22,0	73,0	0,5	4	Weldon	☐
ST5541-120D2R050.3Z4	SIRA	10303013	2	D	12,0	12,0	26,0	84,0	0,5	4	Weldon	☐
ST5541-120D2R100.3Z4	SIRA	10303014	2	D	12,0	12,0	26,0	84,0	1,0	4	Weldon	☐
ST5541-160D2R050.3Z4	SIRA	10303015	2	D	16,0	16,0	34,0	95,0	0,5	4	Weldon	☐
ST5541-160D2R100.3Z4	SIRA	10303017	2	D	16,0	16,0	34,0	95,0	1,0	4	Weldon	☐
ST5541-160D2R300.3Z4	SIRA	10303016	2	D	16,0	16,0	34,0	95,0	3,0	4	Weldon	☐
ST5541-200D2R050.3Z4	SIRA	10303018	2	D	20,0	20,0	42,0	109,0	0,5	4	Weldon	☐
ST5541-200D2R100.3Z4	SIRA	10303020	2	D	20,0	20,0	42,0	109,0	1,0	4	Weldon	☐
ST5541-200D2R300.3Z4	SIRA	10303019	2	D	20,0	20,0	42,0	109,0	3,0	4	Weldon	☐
ST5541-250D2R050.3Z4	SIRA	10303021	2	D	25,0	25,0	52,0	125,0	0,5	4	Weldon	☐
ST5541-250D2R100.3Z4	SIRA	10303023	2	D	25,0	25,0	52,0	125,0	1,0	4	Weldon	☐
ST5541-250D2R300.3Z4	SIRA	10303022	2	D	25,0	25,0	52,0	125,0	3,0	4	Weldon	☐
ST5541-060D3R050.3Z4	SIRA	10303024	3	D	6,0	6,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-080D3R050.3Z4	SIRA	10303025	3	D	8,0	8,0	24,0	73,0	0,5	4	Weldon	☐
ST5541-100D3R050.3Z4	SIRA	10303026	3	D	10,0	10,0	30,0	85,0	0,5	4	Weldon	☐
ST5541-120D3R050.3Z4	SIRA	10303027	3	D	12,0	12,0	36,0	100,0	0,5	4	Weldon	☐
ST5541-120D3R100.3Z4	SIRA	10303028	3	D	12,0	12,0	36,0	100,0	1,0	4	Weldon	☐
ST5541-160D3R050.3Z4	SIRA	10303029	3	D	16,0	16,0	48,0	115,0	0,5	4	Weldon	☐
ST5541-160D3R100.3Z4	SIRA	10303031	3	D	16,0	16,0	48,0	115,0	1,0	4	Weldon	☐
ST5541-160D3R300.3Z4	SIRA	10303030	3	D	16,0	16,0	48,0	115,0	3,0	4	Weldon	☐
ST5541-200D3R050.3Z4	SIRA	10303032	3	D	20,0	20,0	60,0	125,0	0,5	4	Weldon	☐
ST5541-200D3R100.3Z4	SIRA	10303034	3	D	20,0	20,0	60,0	125,0	1,0	4	Weldon	☐
ST5541-200D3R300.3Z4	SIRA	10303033	3	D	20,0	20,0	60,0	125,0	3,0	4	Weldon	☐
ST5541-250D3R050.3Z4	SIRA	10303035	3	D	25,0	25,0	75,0	155,0	0,5	4	Weldon	☐
ST5541-250D3R100.3Z4	SIRA	10303037	3	D	25,0	25,0	75,0	155,0	1,0	4	Weldon	☐
ST5541-250D3R300.3Z4	SIRA	10303036	3	D	25,0	25,0	75,0	155,0	3,0	4	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

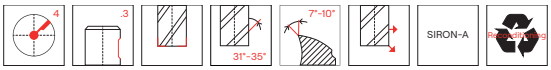
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Ascuţit – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Reascuţire posibilă



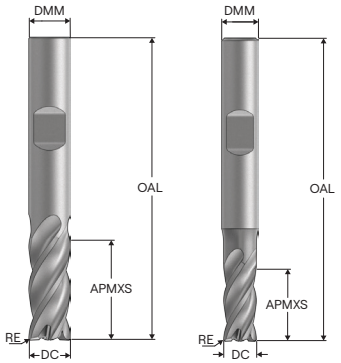
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
ST5541-.250D1S.3Z4	SIRA	10302854	1	D	0.250	0.250	0.250	2.000	4	Weldon	□
ST5541-.281F1S.3Z4	SIRA	10302855	1	F	0.281	0.313	0.281	2.000	4	Weldon	□
ST5541-.313D1S.3Z4	SIRA	10302856	1	D	0.313	0.313	0.313	2.000	4	Weldon	□
ST5541-.375D1S.3Z4	SIRA	10302857	1	D	0.375	0.375	0.375	2.000	4	Weldon	■
ST5541-.438D1S.3Z4	SIRA	10302858	1	D	0.438	0.438	0.438	2.750	4	Weldon	■
ST5541-.500D1S.3Z4	SIRA	10302859	1	D	0.500	0.500	0.500	2.500	4	Weldon	■
ST5541-.625D1S.3Z4	SIRA	10302860	1	D	0.625	0.625	0.625	3.000	4	Weldon	■
ST5541-.750D1S.3Z4	SIRA	10302861	1	D	0.750	0.750	0.750	3.000	4	Weldon	■
ST5541-.875D1S.3Z4	SIRA	10302862	1	D	0.875	0.875	0.875	4.000	4	Weldon	□
ST5541-1.00D1S.3Z4	SIRA	10302863	1	D	1.000	1.000	1.000	4.000	4	Weldon	■
ST5541-.250D2S.3Z4	SIRA	10302864	2	D	0.250	0.250	0.500	2.500	4	Weldon	□
ST5541-.281F2S.3Z4	SIRA	10302865	2	F	0.281	0.313	0.563	2.500	4	Weldon	□
ST5541-.313D2S.3Z4	SIRA	10302866	2	D	0.313	0.313	0.625	2.500	4	Weldon	□
ST5541-.375D2S.3Z4	SIRA	10302867	2	D	0.375	0.375	0.750	2.500	4	Weldon	■
ST5541-.438D2S.3Z4	SIRA	10302868	2	D	0.438	0.438	0.875	2.750	4	Weldon	■
ST5541-.500D2S.3Z4	SIRA	10302869	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
ST5541-.625D2S.3Z4	SIRA	10302870	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
ST5541-.750D2S.3Z4	SIRA	10302871	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
ST5541-.875D2S.3Z4	SIRA	10302872	2	D	0.875	0.875	1.750	4.000	4	Weldon	□
ST5541-1.00D2S.3Z4	SIRA	10302873	2	D	1.000	1.000	2.000	5.000	4	Weldon	■
ST5541-.250D3S.3Z4	SIRA	10302874	3	D	0.250	0.250	0.750	2.500	4	Weldon	□
ST5541-.281F3S.3Z4	SIRA	10302875	3	F	0.281	0.313	0.844	2.500	4	Weldon	□
ST5541-.313D3S.3Z4	SIRA	10302876	3	D	0.313	0.313	0.938	2.500	4	Weldon	□
ST5541-.375D3S.3Z4	SIRA	10302877	3	D	0.375	0.375	1.125	3.000	4	Weldon	■
ST5541-.438D3S.3Z4	SIRA	10302878	3	D	0.438	0.438	1.313	4.000	4	Weldon	■
ST5541-.500D3S.3Z4	SIRA	10302879	3	D	0.500	0.500	1.250	3.000	4	Weldon	■
ST5541-.625D3S.3Z4	SIRA	10302880	3	D	0.625	0.625	1.875	4.000	4	Weldon	■
ST5541-.750D3S.3Z4	SIRA	10302881	3	D	0.750	0.750	2.250	5.000	4	Weldon	■
ST5541-.875D3S.3Z4	SIRA	10302882	3	D	0.875	0.875	2.625	5.000	4	Weldon	□
ST5541-1.00D3S.3Z4	SIRA	10302883	3	D	1.000	1.000	3.000	6.000	4	Weldon	■
ST5541-.500D4S.3Z4	SIRA	10302884	4	D	0.500	0.500	1.500	4.000	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

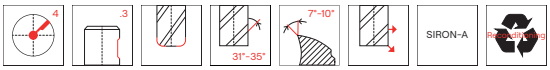
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă



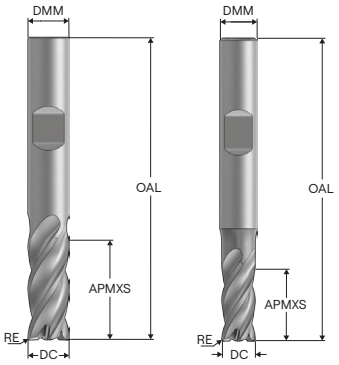
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5541-.250D1R020.3Z4	SIRA	10302885	1	D	0.250	0.250	0.250	2.000	0.020	4	Weldon	□
ST5541-.281F1R020.3Z4	SIRA	10302886	1	F	0.281	0.313	0.281	2.000	0.020	4	Weldon	□
ST5541-.313D1R020.3Z4	SIRA	10302887	1	D	0.313	0.313	0.313	2.000	0.020	4	Weldon	□
ST5541-.375D1R020.3Z4	SIRA	10302888	1	D	0.375	0.375	0.375	2.000	0.020	4	Weldon	■
ST5541-.438D1R020.3Z4	SIRA	10302889	1	D	0.438	0.438	0.438	2.750	0.020	4	Weldon	□
ST5541-.500D1R030.3Z4	SIRA	10302890	1	D	0.500	0.500	0.500	2.500	0.030	4	Weldon	■
ST5541-.625D1R030.3Z4	SIRA	10302891	1	D	0.625	0.625	0.625	3.000	0.030	4	Weldon	■
ST5541-.750D1R030.3Z4	SIRA	10302892	1	D	0.750	0.750	0.750	3.000	0.030	4	Weldon	■
ST5541-.875D1R030.3Z4	SIRA	10302893	1	D	0.875	0.875	0.875	4.000	0.030	4	Weldon	□
ST5541-1.00D1R030.3Z4	SIRA	10302894	1	D	1.000	1.000	1.000	4.000	0.030	4	Weldon	■
ST5541-.250D2R020.3Z4	SIRA	10302895	2	D	0.250	0.250	0.500	2.500	0.020	4	Weldon	□
ST5541-.281F2R020.3Z4	SIRA	10302897	2	F	0.281	0.313	0.563	2.500	0.020	4	Weldon	□
ST5541-.313D2R020.3Z4	SIRA	10302898	2	D	0.313	0.313	0.625	2.500	0.020	4	Weldon	□
ST5541-.375D2R020.3Z4	SIRA	10302900	2	D	0.375	0.375	0.750	2.500	0.020	4	Weldon	■
ST5541-.438D2R020.3Z4	SIRA	10302902	2	D	0.438	0.438	0.875	2.750	0.020	4	Weldon	□
ST5541-.500D2R030.3Z4	SIRA	10302904	2	D	0.500	0.500	1.000	3.000	0.030	4	Weldon	■
ST5541-.500D2R060.3Z4	SIRA	10302905	2	D	0.500	0.500	1.000	3.000	0.060	4	Weldon	□
ST5541-.500D2R120.3Z4	SIRA	10302907	2	D	0.500	0.500	1.000	3.000	0.120	4	Weldon	□
ST5541-.625D2R030.3Z4	SIRA	10302908	2	D	0.625	0.625	1.250	3.500	0.030	4	Weldon	■
ST5541-.625D2R060.3Z4	SIRA	10302909	2	D	0.625	0.625	1.250	3.500	0.060	4	Weldon	□
ST5541-.625D2R090.3Z4	SIRA	10302910	2	D	0.625	0.625	1.250	3.500	0.090	4	Weldon	□
ST5541-.625D2R120.3Z4	SIRA	10302911	2	D	0.625	0.625	1.250	3.500	0.120	4	Weldon	□
ST5541-.750D2R030.3Z4	SIRA	10302913	2	D	0.750	0.750	1.500	4.000	0.030	4	Weldon	■
ST5541-.750D2R060.3Z4	SIRA	10302914	2	D	0.750	0.750	1.500	4.000	0.060	4	Weldon	□
ST5541-.750D2R090.3Z4	SIRA	10302915	2	D	0.750	0.750	1.500	4.000	0.090	4	Weldon	□
ST5541-.750D2R120.3Z4	SIRA	10302916	2	D	0.750	0.750	1.500	4.000	0.120	4	Weldon	□
ST5541-.750D2R250.3Z4	SIRA	10302917	2	D	0.750	0.750	1.500	4.000	0.250	4	Weldon	□
ST5541-.875D2R030.3Z4	SIRA	10302919	2	D	0.875	0.875	1.750	4.000	0.030	4	Weldon	□
ST5541-1.00D2R030.3Z4	SIRA	10302920	2	D	1.000	1.000	2.000	5.000	0.030	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

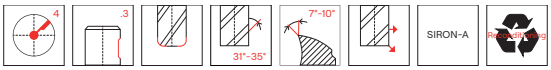
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă



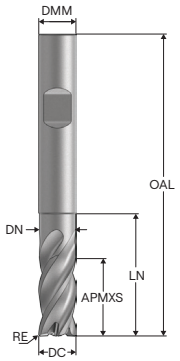
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
ST5541-.250D3R020.3Z4	SIRA	10302922	3	D	0.250	0.250	0.750	2.500	0.020	4	Weldon	□
ST5541-.281F3R020.3Z4	SIRA	10302923	3	F	0.281	0.313	0.844	2.500	0.020	4	Weldon	□
ST5541-.313D3R020.3Z4	SIRA	10302924	3	D	0.313	0.313	0.938	2.500	0.020	4	Weldon	□
ST5541-.375D3R020.3Z4	SIRA	10302925	3	D	0.375	0.375	1.125	3.000	0.020	4	Weldon	■
ST5541-.438D3R020.3Z4	SIRA	10302926	3	D	0.438	0.438	1.313	4.000	0.020	4	Weldon	□
ST5541-.500D3R030.3Z4	SIRA	10302927	3	D	0.500	0.500	1.250	3.000	0.030	4	Weldon	■
ST5541-.500D3R060.3Z4	SIRA	10302928	3	D	0.500	0.500	1.250	3.000	0.060	4	Weldon	□
ST5541-.500D3R120.3Z4	SIRA	10302929	3	D	0.500	0.500	1.250	3.000	0.120	4	Weldon	□
ST5541-.625D3R030.3Z4	SIRA	10302930	3	D	0.625	0.625	1.875	4.000	0.030	4	Weldon	■
ST5541-.625D3R060.3Z4	SIRA	10302931	3	D	0.625	0.625	1.875	4.000	0.060	4	Weldon	□
ST5541-.625D3R090.3Z4	SIRA	10302932	3	D	0.625	0.625	1.875	4.000	0.090	4	Weldon	□
ST5541-.625D3R120.3Z4	SIRA	10302933	3	D	0.625	0.625	1.875	4.000	0.120	4	Weldon	□
ST5541-.750D3R030.3Z4	SIRA	10302934	3	D	0.750	0.750	2.250	5.000	0.030	4	Weldon	■
ST5541-.750D3R060.3Z4	SIRA	10302935	3	D	0.750	0.750	2.250	5.000	0.060	4	Weldon	□
ST5541-.750D3R090.3Z4	SIRA	10302936	3	D	0.750	0.750	2.250	5.000	0.090	4	Weldon	□
ST5541-.750D3R120.3Z4	SIRA	10302937	3	D	0.750	0.750	2.250	5.000	0.120	4	Weldon	□
ST5541-.750D3R250.3Z4	SIRA	10302938	3	D	0.750	0.750	2.250	5.000	0.250	4	Weldon	□
ST5541-.875D3R030.3Z4	SIRA	10302939	3	D	0.875	0.875	2.625	5.000	0.030	4	Weldon	□
ST5541-1.00D3R030.3Z4	SIRA	10302940	3	D	1.000	1.000	3.000	6.000	0.030	4	Weldon	■
ST5541-.500D4R030.3Z4	SIRA	10302941	4	D	0.500	0.500	1.500	4.000	0.030	4	Weldon	■

■ **Stoc standard.**□ Weldon disponibil. Intervalul de livrare este de 3 zile.

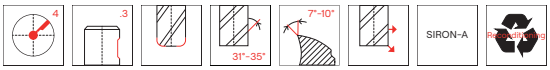
ST5541

Înaltă performanţă – Oţel – Pătrat – 4 Caneluri – Weldon – Rază la vârf – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Reascuţire posibilă



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5541-.250E2R020.3Z4	SIRA	10302896	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Weldon	☐
ST5541-.313E2R020.3Z4	SIRA	10302899	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Weldon	☐
ST5541-.375E2R020.3Z4	SIRA	10302901	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Weldon	☐
ST5541-.438E2R020.3Z4	SIRA	10302903	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Weldon	☐
ST5541-.500E2R030.3Z4	SIRA	10302906	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Weldon	☐
ST5541-.625E2R030.3Z4	SIRA	10302912	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Weldon	☐
ST5541-.750E2R030.3Z4	SIRA	10302918	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Weldon	☐
ST5541-1.00E2R030.3Z4	SIRA	10302921	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – ST5541 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,3 *0.012*	220 (170 — 230) *720 (560 — 750)*
P2	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (160 — 220) *710 (530 — 720)*
P3	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	190 (140 — 200) *620 (460 — 650)*
P4	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P5	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 170) *520 (400 — 550)*
P6	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	180 (140 — 190) *590 (460 — 620)*
P7	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	170 (130 — 180) *560 (430 — 590)*
P8	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
P11	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P12	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,03 *0.0012*	0,038 *0.0015*	0,048 *0.0019*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	110 (80 — 110) *360 (270 — 360)*
K1	E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (170 — 230) *710 (560 — 750)*
K2	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	195 (150 — 200) *640 (500 — 650)*
K3	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
K4	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
K5	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	95 (71 — 100) *310 (240 — 320)*
K6	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	140 (110 — 140) *460 (370 — 450)*
K7	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	120 (91 — 130) *395 (300 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5541 Frezare de canal

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	195 (150 — 200) *640 (500 — 650)*
P2	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (140 — 200) *620 (460 — 650)*
P3	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	165 (130 — 170) *540 (430 — 550)*
P4	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P5	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (110 — 140) *445 (370 — 450)*
P6	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	155 (120 — 160) *510 (400 — 520)*
P7	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P8	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 140) *445 (370 — 450)*
P11	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 150) *460 (370 — 490)*
P12	M/A/D/E	1,5 *1.5*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	85 (64 — 92) *280 (210 — 300)*
K1	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (150 — 200) *620 (500 — 650)*
K2	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	165 (130 — 170) *540 (430 — 550)*
K3	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 140) *460 (370 — 450)*
K4	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (99 — 140) *445 (330 — 450)*
K5	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (59 — 85) *260 (200 — 270)*
K6	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	120 (87 — 120) *395 (290 — 390)*
K7	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	100 (76 — 100) *330 (250 — 320)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – ST5541 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,06 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,1 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,3 *0.012*	220 (170 — 230) *720 (560 — 750)*
P2	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,3 *0.012*	215 (160 — 220) *710 (530 — 720)*
P3	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	190 (140 — 200) *620 (460 — 650)*
P4	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,095 *0.0038*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P5	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	160 (120 — 170) *520 (400 — 550)*
P6	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	180 (140 — 190) *590 (460 — 620)*
P7	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	170 (130 — 180) *560 (430 — 590)*
P8	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
P11	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P12	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,03 *0.0012*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	110 (80 — 110) *360 (270 — 360)*
K1	E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,3 *0.012*	215 (170 — 230) *710 (560 — 750)*
K2	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (150 — 200) *640 (500 — 650)*
K3	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
K4	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
K5	E	0,25 *0.25*	1,5 *1.5*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	95 (71 — 100) *310 (240 — 320)*
K6	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	140 (110 — 140) *460 (370 — 450)*
K7	E	0,25 *0.25*	1,5 *1.5*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	120 (91 — 130) *395 (300 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5541 Frezare de canal – Inci

SMG		a_p/DC	f_z														v_c
			1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	195 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*640 (500 — 650)*
P2	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (140 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (460 — 650)*
P3	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*540 (430 — 550)*
P4	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P5	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (370 — 450)*
P6	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	155 (120 — 160)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*510 (400 — 520)*
P7	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P8	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*445 (370 — 450)*
P11	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 490)*
P12	M/A/D/E	1,5	0,017	0,022	0,025	0,030	0,034	0,038	0,042	0,050	0,060	0,065	0,080	0,085	0,095	0,10	85 (64 — 92)
		1.5	*0.00065*	*0.00085*	*0.0010*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*0.0034*	*0.0038*	*0.0040*	*280 (210 — 300)*
K1	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (500 — 650)*
K2	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*540 (430 — 550)*
K3	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 450)*
K4	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (99 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (330 — 450)*
K5	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	80 (59 — 85)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*260 (200 — 270)*
K6	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	120 (87 — 120)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*395 (290 — 390)*
K7	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	100 (76 — 100)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*330 (250 — 320)*

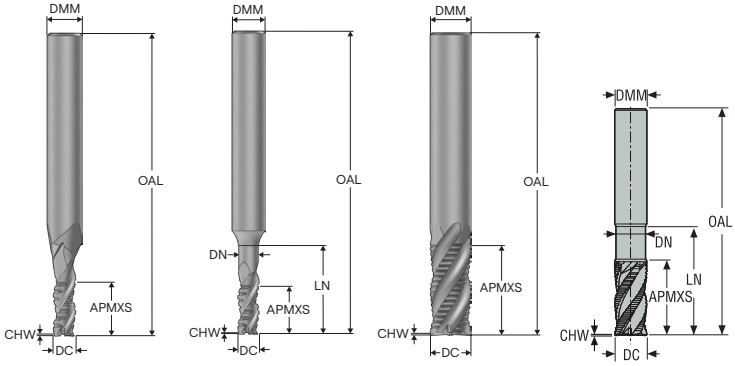
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

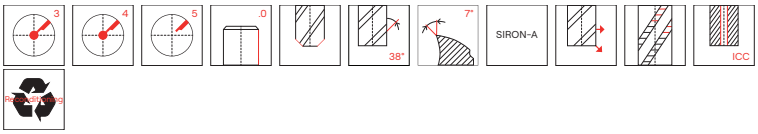
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP993

Înaltă performanţă – Oţel – Pătrat – 3-5 Caneluri – Cilindrică – Șanfren







—Toleranţe:
—DMM=h5
—DC=-0,02/-0,1 mm
—CHW= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

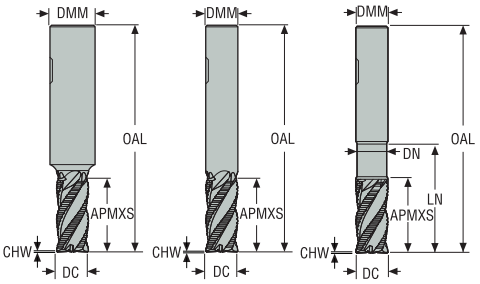
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmen-tator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm			
JHP993040F2C.0Z3-SIRA	02826806	2	F	■	–	4,0	6,0	10,0	50,0	–	–	0,15	3	Cylindrical	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	■	–	5,0	6,0	12,0	55,0	–	–	0,15	4	Cylindrical	■
JHP993060D2C.0Z4-SIRA	02826809	2	D	■	–	6,0	6,0	14,0	55,0	–	–	0,2	4	Cylindrical	■
JHP993075F2C.0Z4-SIRA	02826811	2	F	■	–	7,5	8,0	17,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993080D2C.0Z4A-SIRA	02826814	2	D	■	■	8,0	8,0	18,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993080D2C.0Z4-SIRA	02826812	2	D	■	–	8,0	8,0	18,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993095F2C.0Z4-SIRA	02826816	2	F	■	–	9,5	10,0	20,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993100D2C.0Z4A-SIRA	02826818	2	D	■	■	10,0	10,0	22,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993100D2C.0Z4-SIRA	02826817	2	D	■	–	10,0	10,0	22,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993115F2C.0Z4-SIRA	02826820	2	F	■	–	11,5	12,0	25,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993120D2C.0Z4A-SIRA	02826822	2	D	■	■	12,0	12,0	26,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993120D2C.0Z4-SIRA	02826821	2	D	■	–	12,0	12,0	26,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993140D2C.0Z4-SIRA	02826824	2	D	■	–	14,0	14,0	30,0	80,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z4A-SIRA	02856501	2	D	■	■	16,0	16,0	34,0	90,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z4-SIRA	02856499	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z5-SIRA	02826825	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	5	Cylindrical	■
JHP993200D2C.0Z4A-SIRA	02856506	2	D	■	■	20,0	20,0	42,0	100,0	–	–	0,5	4	Cylindrical	■
JHP993200D2C.0Z4-SIRA	02856505	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	4	Cylindrical	■
JHP993200D2C.0Z5-SIRA	02826828	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	5	Cylindrical	■
JHP993250D2C.0Z4A-SIRA	02856510	2	D	■	■	25,0	25,0	52,0	125,0	–	–	0,5	4	Cylindrical	■
JHP993040G3C.0Z3-SIRA	02826807	3	G	■	–	4,0	6,0	10,0	55,0	15,0	3,7	0,15	3	Cylindrical	■
JHP993060E3C.0Z4-SIRA	02826810	3	E	■	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	Cylindrical	■
JHP993080E3C.0Z4-SIRA	02826815	3	E	■	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	Cylindrical	■
JHP993100E3C.0Z4-SIRA	02826819	3	E	■	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	Cylindrical	■
JHP993120E3C.0Z4-SIRA	02826823	3	E	■	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	Cylindrical	■
JHP993160E3C.0Z4-SIRA	02856502	3	E	■	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	Cylindrical	■
JHP993200E3C.0Z4-SIRA	02856507	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	Cylindrical	■

■ **Stoc standard.**

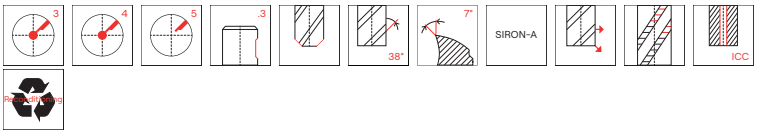
JHP993

Înaltă performanţă – Oţel – Pătrat – 3-5 Caneluri – Weldon – Șanfren





- Toleranţe:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm			
JHP993040F2C.3Z3-SIRA	02828150	2	F	■	–	4,0	6,0	10,0	50,0	–	–	0,15	3	Weldon	■
JHP993050F2C.3Z4-SIRA	02828152	2	F	■	–	5,0	6,0	12,0	55,0	–	–	0,15	4	Weldon	■
JHP993060D2C.3Z4-SIRA	02828153	2	D	■	–	6,0	6,0	14,0	55,0	–	–	0,2	4	Weldon	■
JHP993075F2C.3Z4-SIRA	02828155	2	F	■	–	7,5	8,0	17,0	60,0	–	–	0,2	4	Weldon	■
JHP993080D2C.3Z4A-SIRA	02828246	2	D	■	■	8,0	8,0	18,0	60,0	–	–	0,2	4	Weldon	□
JHP993080D2C.3Z4-SIRA	02828156	2	D	■	–	8,0	8,0	18,0	60,0	–	–	0,2	4	Weldon	■
JHP993095F2C.3Z4-SIRA	02828158	2	F	■	–	9,5	10,0	20,0	70,0	–	–	0,2	4	Weldon	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	■	10,0	10,0	22,0	70,0	–	–	0,2	4	Weldon	□
JHP993100D2C.3Z4-SIRA	02828159	2	D	■	–	10,0	10,0	22,0	70,0	–	–	0,2	4	Weldon	■
JHP993120D2C.3Z4A-SIRA	02828248	2	D	■	■	12,0	12,0	26,0	80,0	–	–	0,2	4	Weldon	□
JHP993120D2C.3Z4-SIRA	02828162	2	D	■	–	12,0	12,0	26,0	80,0	–	–	0,2	4	Weldon	■
JHP993140D2C.3Z4-SIRA	02828164	2	D	■	–	14,0	14,0	30,0	80,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z4A-SIRA	02856512	2	D	■	■	16,0	16,0	34,0	90,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z4-SIRA	02856500	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z5-SIRA	02828165	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	5	Weldon	■
JHP993200D2C.3Z4A-SIRA	02856513	2	D	■	■	20,0	20,0	42,0	100,0	–	–	0,5	4	Weldon	■
JHP993200D2C.3Z4-SIRA	02856504	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	4	Weldon	■
JHP993200D2C.3Z5-SIRA	02828167	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	5	Weldon	■
JHP993250D2C.3Z4A-SIRA	02856514	2	D	■	■	25,0	25,0	52,0	125,0	–	–	0,5	4	Weldon	■
JHP993250D2C.3Z4-SIRA	02856509	2	D	■	–	25,0	25,0	52,0	125,0	–	–	0,5	4	Weldon	■
JHP993060E3C.3Z4-SIRA	02828154	3	E	■	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	Weldon	■
JHP993080E3C.3Z4-SIRA	02828157	3	E	■	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	Weldon	■
JHP993100E3C.3Z4-SIRA	02828160	3	E	■	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	Weldon	■
JHP993120E3C.3Z4-SIRA	02828163	3	E	■	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	Weldon	■
JHP993160E3C.3Z4-SIRA	02856503	3	E	■	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	Weldon	■
JHP993200E3C.3Z4-SIRA	02856508	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	Weldon	■
JHP993200E3C.3Z5-SIRA	02828168	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	5	Weldon	■
JHP993250E3C.3Z4-SIRA	02856511	3	E	■	–	25,0	25,0	52,0	150,0	90,0	24,0	0,5	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – JHP993 Frezare laterală PCEDC=3 și PCEDC=4

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 190) *570 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	110 (95 — 120) *360 (320 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	100 (86 — 110) *330 (290 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	125 (110 — 140) *410 (370 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JHP993 Frezare laterală PCEDC=5

SMG		a_e/DC	a_p/DC	f_z		v_c
				16	20	
P1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.22 *0,0085*	205 (180 — 230) *670 (600 — 750)*
P2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 180) *540 (500 — 590)*
P7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P8	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A	0.376 *0,376*	1.0 *1,0*	0.11 *0,0044*	0.13 *0,0050*	100 (85 — 110) *330 (280 — 360)*
K1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	175 (160 — 200) *570 (530 — 650)*
K3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
K4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	85 (75 — 99) *280 (250 — 320)*
K6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	110 (96 — 120) *360 (320 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JHP993 Frezare de canal PCEDC=3 și PCEDC=4

SMG		a_p/DC	f_z										v_c
			4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (76 — 100) *295 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	135 (120 — 150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	80 (70 — 93) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	105 (90 — 110) *345 (300 — 360)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JHP993 Frezare de canal PCEDC=5

SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (99 — 130) *375 (330 — 420)*
P6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	130 (120 — 140) *425 (400 — 450)*
P7	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P8	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	115 (99 — 130) *375 (330 — 420)*
P11	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P12	E/M/A	0.44 *0,44*	0.11 *0,0044*	0.13 *0,0050*	80 (68 — 89) *260 (230 — 290)*
K1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	140 (120 — 150) *460 (400 — 490)*
K3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	70 (60 — 79) *230 (200 — 250)*
K6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	90 (77 — 100) *295 (260 — 320)*

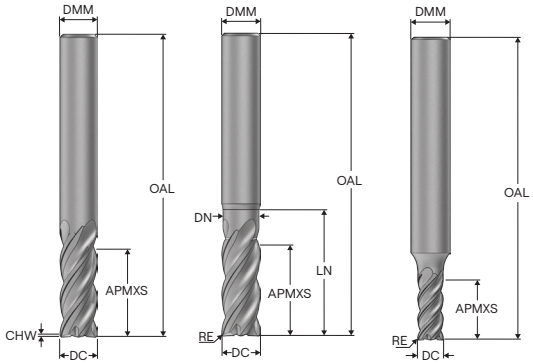
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

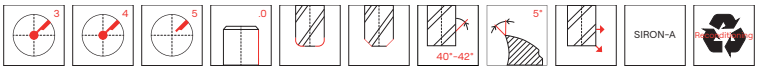
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP951

Înaltă performanţă – Pătrat – Oţel – 3-5 Caneluri – Cilindrică – Raza la colţ sau șanfrenul







—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

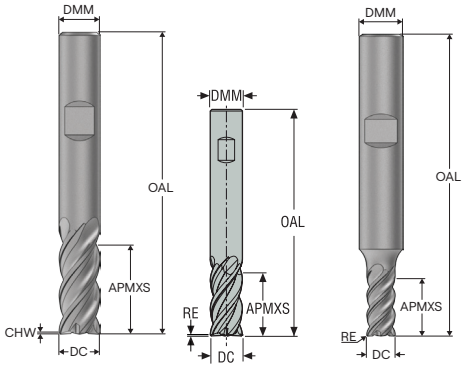
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm			
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	–	–	0,1	–	3	Cylindrical	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	–	–	–	0,2	3	Cylindrical	■
JHP951030F2R050.0Z3-SIRA	02828190	2	F	3,0	6,0	8,0	50,0	–	–	–	0,5	3	Cylindrical	■
JHP951040F2C.0Z4-SIRA	02828197	2	F	4,0	6,0	10,0	55,0	–	–	0,15	–	4	Cylindrical	■
JHP951040F2R020.0Z4-SIRA	02828194	2	F	4,0	6,0	10,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951040F2R050.0Z4-SIRA	02828195	2	F	4,0	6,0	10,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951050F2C.0Z4-SIRA	02828201	2	F	5,0	6,0	12,0	55,0	–	–	0,2	–	4	Cylindrical	■
JHP951050F2R020.0Z4-SIRA	02828199	2	F	5,0	6,0	12,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951050F2R050.0Z4-SIRA	02828198	2	F	5,0	6,0	12,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951060D2C.0Z4-SIRA	02828205	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	Cylindrical	■
JHP951060D2R020.0Z4-SIRA	02828203	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951060D2R050.0Z4-SIRA	02828202	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951080D2C.0Z4-SIRA	02828212	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	Cylindrical	■
JHP951080D2R020.0Z4-SIRA	02828209	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	Cylindrical	■
JHP951080D2R050.0Z4-SIRA	02828207	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	Cylindrical	■
JHP951080D2R100.0Z4-SIRA	02828208	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	Cylindrical	■
JHP951100E2C.0Z4-SIRA	02828218	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	Cylindrical	■
JHP951100E2R050.0Z4-SIRA	02828216	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	Cylindrical	■
JHP951100E2R100.0Z4-SIRA	02828214	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	Cylindrical	■
JHP951120E2C.0Z4-SIRA	02828226	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	Cylindrical	■
JHP951120E2R050.0Z4-SIRA	02828224	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	Cylindrical	■
JHP951120E2R100.0Z4-SIRA	02828222	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	Cylindrical	■
JHP951160E2C.0Z4-SIRA	02927873	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	Cylindrical	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	Cylindrical	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	Cylindrical	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	Cylindrical	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	Cylindrical	■
JHP951160E2R100.0Z5-SIRA	02828231	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	Cylindrical	■

■ **Stoc standard.**

JHP951

Înaltă performanţă – Pătrat – Oţel – 3-5 Caneluri – Weldon – Raza la colţ sau șanfrenul





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm			
JHP951030F2C.3Z3-SIRA	02828193	2	F	3,0	6,0	8,0	50,0	–	–	0,1	–	3	Weldon	■
JHP951030F2R020.3Z3-SIRA	02828260	2	F	3,0	6,0	8,0	50,0	–	–	–	0,2	3	Weldon	■
JHP951030F2R050.3Z3-SIRA	02828259	2	F	3,0	6,0	8,0	50,0	–	–	–	0,5	3	Weldon	□
JHP951040F2C.3Z4-SIRA	02828196	2	F	4,0	6,0	10,0	55,0	–	–	0,15	–	4	Weldon	■
JHP951040F2R020.3Z4-SIRA	02828261	2	F	4,0	6,0	10,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951040F2R050.3Z4-SIRA	02828262	2	F	4,0	6,0	10,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951050F2C.3Z4-SIRA	02828200	2	F	5,0	6,0	12,0	55,0	–	–	0,2	–	4	Weldon	■
JHP951050F2R020.3Z4-SIRA	02828264	2	F	5,0	6,0	12,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951050F2R050.3Z4-SIRA	02828263	2	F	5,0	6,0	12,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951060D2C.3Z4-SIRA	02828206	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	Weldon	■
JHP951060D2R020.3Z4-SIRA	02828266	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951060D2R050.3Z4-SIRA	02828265	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951080D2C.3Z4-SIRA	02828210	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	Weldon	■
JHP951080D2R020.3Z4-SIRA	02828269	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	Weldon	□
JHP951080D2R050.3Z4-SIRA	02828267	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	Weldon	■
JHP951080D2R100.3Z4-SIRA	02828268	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	Weldon	□
JHP951100E2C.3Z4-SIRA	02828220	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	Weldon	■
JHP951100E2R050.3Z4-SIRA	02828271	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	Weldon	■
JHP951100E2R100.3Z4-SIRA	02828270	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	Weldon	□
JHP951120E2C.3Z4-SIRA	02828228	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	Weldon	■
JHP951120E2R050.3Z4-SIRA	02828273	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	Weldon	■
JHP951120E2R100.3Z4-SIRA	02828272	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	Weldon	■
JHP951160E2C.3Z4-SIRA	02927874	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	Weldon	■
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	Weldon	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	Weldon	■
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	Weldon	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	Weldon	□
JHP951160E2R100.3Z5-SIRA	02828276	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	Weldon	□
JHP951200E2R050.3Z4-SIRA	02927877	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	0,5	4	Weldon	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	Weldon	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	Weldon	■
JHP951200E2R100.3Z5-SIRA	02828234	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	1,0	5	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – JHP951 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z									v_c
				3	4	5	6	8	10	12	16	20	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	220 (200 — 250) *720 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	170 (150 — 190) *560 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	175 (150 — 190) *570 (500 — 620)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	110 (94 — 120) *360 (310 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	100 (85 — 110) *330 (280 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	125 (110 — 140) *410 (370 — 450)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JHP951 Frezare de canal

SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	195 (170 — 220)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*640 (560 — 720)*
P2	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	190 (170 — 210)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*620 (560 — 680)*
P3	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	165 (150 — 180)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*540 (500 — 590)*
P4	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P5	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (400 — 490)*
P6	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	155 (140 — 170)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*510 (460 — 550)*
P7	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P8	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (400 — 490)*
P11	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P12	E/M/A	1.5	0.020	0.028	0.034	0.040	0.055	0.070	0.080	0.10	0.12	85 (75 — 99)
		1,5	*0,00080*	*0,0011*	*0,0013*	*0,0016*	*0,0022*	*0,0028*	*0,0032*	*0,0040*	*0,0048*	*280 (250 — 320)*
K1	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	195 (170 — 220)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*640 (560 — 720)*
K2	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	170 (150 — 190)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*560 (500 — 620)*
K3	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (430 — 520)*
K4	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	135 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*445 (400 — 490)*
K5	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.15	80 (70 — 92)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0060*	*260 (230 — 300)*
K6	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	120 (110 — 130)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*395 (370 — 420)*
K7	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.15	105 (89 — 110)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0060*	*345 (300 — 360)*

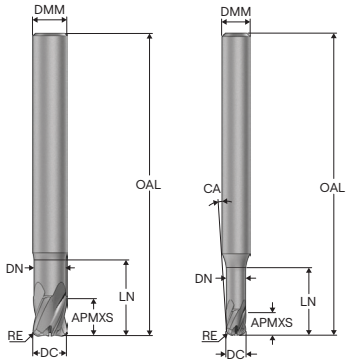
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

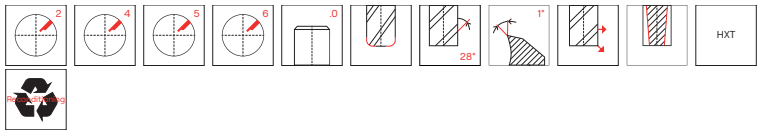
JH142

Viteză mare – Precizie ridicată – Toric – Oţel călit – 2-6 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



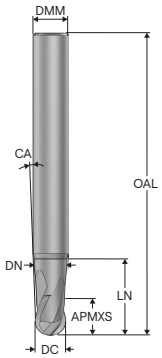
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	Cylindrical	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	Cylindrical	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	Cylindrical	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	Cylindrical	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	Cylindrical	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	Cylindrical	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	Cylindrical	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	Cylindrical	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	Cylindrical	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	Cylindrical	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	Cylindrical	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	Cylindrical	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	Cylindrical	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	Cylindrical	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	Cylindrical	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	Cylindrical	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	Cylindrical	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	Cylindrical	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	Cylindrical	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	Cylindrical	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	Cylindrical	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	Cylindrical	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	Cylindrical	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	Cylindrical	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	Cylindrical	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	Cylindrical	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	Cylindrical	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	Cylindrical	■

■ **Stoc standard.**

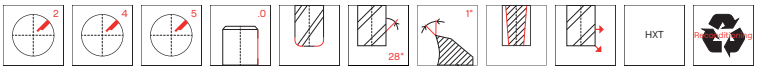
JH142

Viteză mare – Precizie ridicată – Toric – Oţel călit – 2-5 Caneluri – Cilindrică – Rază la vârf





J



- Toleranţe:
- Bătaie radială= <0,005 mm
- DMM= h5
- DC 0-0,01 mm
- RE= ±0,005 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	2	Cylindrical	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	4	Cylindrical	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	2	Cylindrical	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	4	Cylindrical	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	2	Cylindrical	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	4	Cylindrical	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	2	Cylindrical	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	4	Cylindrical	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	2	Cylindrical	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	4	Cylindrical	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	2	Cylindrical	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	4	Cylindrical	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	2	Cylindrical	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	4	Cylindrical	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	4	Cylindrical	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	5	Cylindrical	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	4	Cylindrical	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	5	Cylindrical	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	0,9	5	Cylindrical	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	0,9	5	Cylindrical	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	0,9	5	Cylindrical	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	0,9	5	Cylindrical	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	0,9	5	Cylindrical	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	0,9	5	Cylindrical	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	0,9	5	Cylindrical	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	0,9	5	Cylindrical	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	0,9	5	Cylindrical	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	0,9	4	Cylindrical	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	0,9	4	Cylindrical	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	0,9	4	Cylindrical	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	0,9	4	Cylindrical	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	0,9	4	Cylindrical	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	0,9	4	Cylindrical	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	0,9	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH142 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

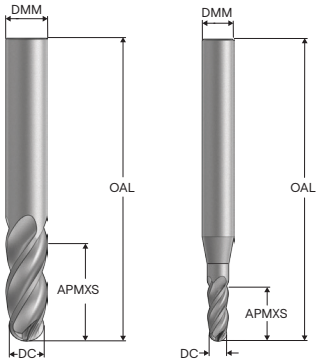
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

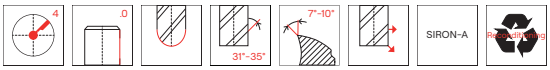
ST5341

Înaltă performanţă – Oţel – Cap sferic – 4 Caneluri – Cilindrică





– Toleranţe:
– DMM=h5
– DC=e7
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



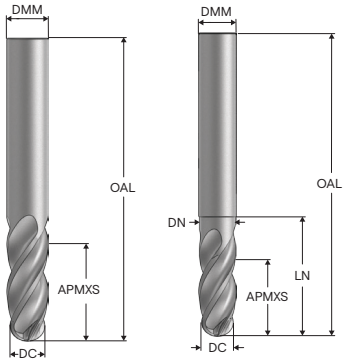
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5341-030F2B.0Z4	SIRA	10302669	2	F	3,0	6,0	7,0	58,0	1,5	4	Cylindrical	■
ST5341-040F2B.0Z4	SIRA	10302670	2	F	4,0	6,0	10,0	58,0	2,0	4	Cylindrical	■
ST5341-050F2B.0Z4	SIRA	10302671	2	F	5,0	6,0	12,0	58,0	2,5	4	Cylindrical	■
ST5341-060D2B.0Z4	SIRA	10302672	2	D	6,0	6,0	14,0	58,0	3,0	4	Cylindrical	■
ST5341-080D2B.0Z4	SIRA	10302673	2	D	8,0	8,0	18,0	64,0	4,0	4	Cylindrical	■
ST5341-100D2B.0Z4	SIRA	10302674	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
ST5341-120D2B.0Z4	SIRA	10302675	2	D	12,0	12,0	26,0	84,0	6,0	4	Cylindrical	■
ST5341-160D2B.0Z4	SIRA	10302676	2	D	16,0	16,0	34,0	95,0	8,0	4	Cylindrical	■
ST5341-200D2B.0Z4	SIRA	10302677	2	D	20,0	20,0	42,0	109,0	10,0	4	Cylindrical	■
ST5341-030F3B.0Z4	SIRA	10302678	3	F	3,0	6,0	9,0	58,0	1,5	4	Cylindrical	■
ST5341-040F3B.0Z4	SIRA	10302679	3	F	4,0	6,0	12,0	58,0	2,0	4	Cylindrical	■
ST5341-050F3B.0Z4	SIRA	10302680	3	F	5,0	6,0	15,0	58,0	2,5	4	Cylindrical	■
ST5341-060D3B.0Z4	SIRA	10302681	3	D	6,0	6,0	18,0	64,0	3,0	4	Cylindrical	■
ST5341-080D3B.0Z4	SIRA	10302682	3	D	8,0	8,0	24,0	73,0	4,0	4	Cylindrical	■
ST5341-100D3B.0Z4	SIRA	10302683	3	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
ST5341-120D3B.0Z4	SIRA	10302684	3	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■
ST5341-160D3B.0Z4	SIRA	10302685	3	D	16,0	16,0	48,0	115,0	8,0	4	Cylindrical	■
ST5341-200D3B.0Z4	SIRA	10302686	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■

■ **Stoc standard.**

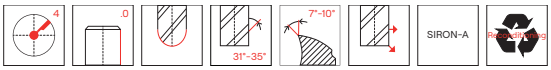
ST5341

Înaltă performanţă – Oţel – Cap sferic – 4 Caneluri – Cilindrică – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Reascuţire posibilă dacă DC este ≥ Ø.250



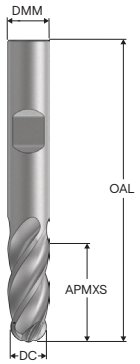
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci	inci	inci			
ST5341-.125D2B.0Z4	SIRA	10302637	2	D	0.125	0.125	0.250	1.500	–	–	0.063	4	Cylindrical	■
ST5341-.188D2B.0Z4	SIRA	10302638	2	D	0.188	0.188	0.375	2.000	–	–	0.094	4	Cylindrical	■
ST5341-.250D2B.0Z4	SIRA	10302639	2	D	0.250	0.250	0.500	2.500	–	–	0.125	4	Cylindrical	■
ST5341-.250E2B.0Z4	SIRA	10302640	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.125	4	Cylindrical	■
ST5341-.313D2B.0Z4	SIRA	10302641	2	D	0.313	0.313	0.625	2.500	–	–	0.156	4	Cylindrical	■
ST5341-.313E2B.0Z4	SIRA	10302642	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.156	4	Cylindrical	■
ST5341-.375D2B.0Z4	SIRA	10302643	2	D	0.375	0.375	0.750	2.500	–	–	0.188	4	Cylindrical	■
ST5341-.375E2B.0Z4	SIRA	10302644	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.188	4	Cylindrical	■
ST5341-.438D2B.0Z4	SIRA	10302645	2	D	0.438	0.438	0.875	2.750	–	–	0.219	4	Cylindrical	■
ST5341-.500D2B.0Z4	SIRA	10302646	2	D	0.500	0.500	1.000	3.000	–	–	0.250	4	Cylindrical	■
ST5341-.500E2B.0Z4	SIRA	10302647	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.250	4	Cylindrical	■
ST5341-.625D2B.0Z4	SIRA	10302648	2	D	0.625	0.625	1.250	3.500	–	–	0.313	4	Cylindrical	■
ST5341-.625E2B.0Z4	SIRA	10302649	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.313	4	Cylindrical	■
ST5341-.750D2B.0Z4	SIRA	10302650	2	D	0.750	0.750	1.500	4.000	–	–	0.375	4	Cylindrical	■
ST5341-.750E2B.0Z4	SIRA	10302651	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.375	4	Cylindrical	■
ST5341-1.00D2B.0Z4	SIRA	10302652	2	D	1.000	1.000	2.000	5.000	–	–	0.500	4	Cylindrical	■
ST5341-1.00E2B.0Z4	SIRA	10302653	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.500	4	Cylindrical	■

■ **Stoc standard.**

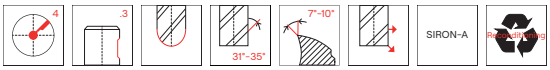
ST5341

Înaltă performanţă – Oţel – Cap sferic – 4 Caneluri – Weldon





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Reascuţire posibilă



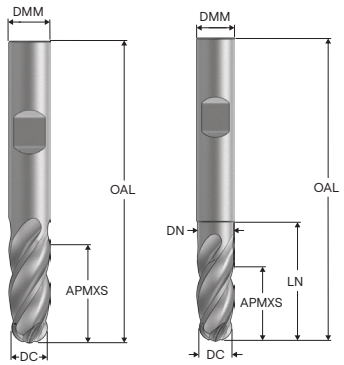
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
ST5341-060D2B.3Z4	SIRA	10302687	2	D	6,0	6,0	14,0	58,0	3,0	4	Weldon	☐
ST5341-080D2B.3Z4	SIRA	10302688	2	D	8,0	8,0	18,0	64,0	4,0	4	Weldon	☐
ST5341-100D2B.3Z4	SIRA	10302689	2	D	10,0	10,0	22,0	73,0	5,0	4	Weldon	☐
ST5341-120D2B.3Z4	SIRA	10302690	2	D	12,0	12,0	26,0	84,0	6,0	4	Weldon	☐
ST5341-160D2B.3Z4	SIRA	10302691	2	D	16,0	16,0	34,0	95,0	8,0	4	Weldon	☐
ST5341-200D2B.3Z4	SIRA	10302692	2	D	20,0	20,0	42,0	109,0	10,0	4	Weldon	☐
ST5341-060D3B.3Z4	SIRA	10302693	3	D	6,0	6,0	18,0	64,0	3,0	4	Weldon	☐
ST5341-080D3B.3Z4	SIRA	10302694	3	D	8,0	8,0	24,0	73,0	4,0	4	Weldon	☐
ST5341-100D3B.3Z4	SIRA	10302695	3	D	10,0	10,0	30,0	85,0	5,0	4	Weldon	☐
ST5341-120D3B.3Z4	SIRA	10302696	3	D	12,0	12,0	36,0	100,0	6,0	4	Weldon	☐
ST5341-160D3B.3Z4	SIRA	10302697	3	D	16,0	16,0	48,0	115,0	8,0	4	Weldon	☐
ST5341-200D3B.3Z4	SIRA	10302698	3	D	20,0	20,0	60,0	125,0	10,0	4	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

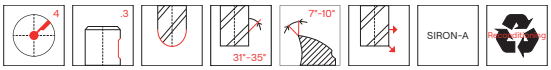
ST5341

Înaltă performanţă – Oţel – Cap sferic – 4 Caneluri – Weldon – Inci





—Toleranţe:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Reascuţire posibilă
☐ Weldon disponibil. Intervalul de livrare este de 3 zile.



Parametri de aşchiere – ST5341 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – ST5341 Degroşare pentru frezare prin copiere – Inci

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

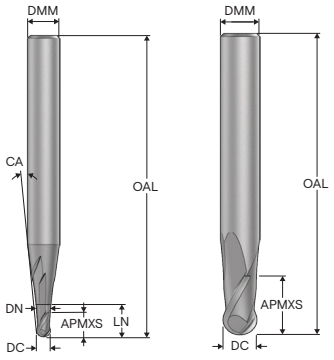
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHB970

Viteză mare – Universale – Cap sferic – 2 Caneluri – Cilindrică





G D

– Toleranţe:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JHB970 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

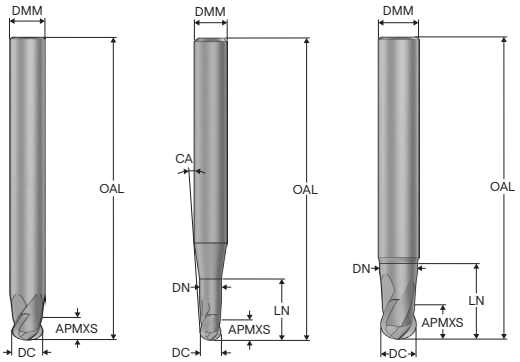
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

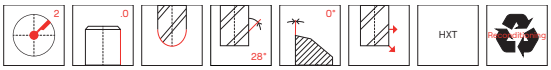
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH112

Viteză mare – Precizie ridicată – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

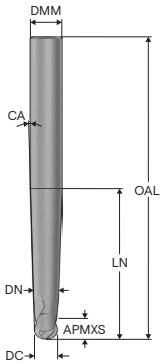
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Stoc standard.**

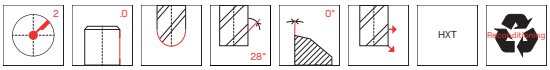
JH112

Viteză mare – Precizie ridicată – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică





J



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH112 Finisare frezare prin copiere

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JH112 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

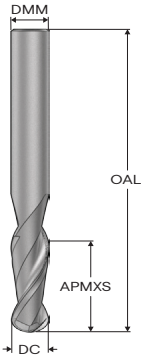
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH150

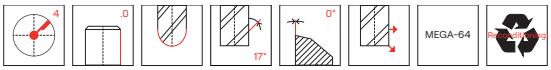
Viteză mare – Oţel călit – Cap sferic – 4 Caneluri – Cilindrică





D

- Toleranţe:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH150 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

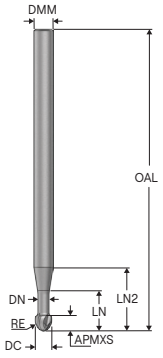
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH160

Viteză mare – Oţel călit – Cap sferic – 4 Caneluri – Cilindrică





E

—Toleranţe:
—DMM= h5
—DC= 0,02/-0,06 mm
—SA=250°



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH160 Finisare frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



INOX ȘI MATERIALE ISO S

Seco oferă o gamă completă de freze cilindro-frontale din carbură solidă de înaltă performanţă pentru frezare cilindro-frontală, freze cu cap rotund și freze cilindro-frontale de finisare pentru productivitate ridicată în oţel inox și materiale ISO S.

- JS754, JS755, JS720, JHP751, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994, SHF712, SME714, SME716 and JCO710 pentru tip șanfren sau rază.
- JS730, JH780, JHB720, JH721, JH722, SMB713, SMB714 și SMB716 pentru tipul cu cap rotund.
- JH724, JH726, JH734, JH736, JH744, JH746 pentru tip butoi.

Alegerea uneltei - Oţel inoxidabil și materiale S.

								
Nume		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Pag.		326	343	354	374	378	381	385
Familia		SOLID²	SOLID²	SOLID²	SOLID²	HPM	HPM	HPM
Tipul frezei								
Coada	Cilindrică	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safelock	□	□	□	□			□
Numărul de dinţi		4	5	6-9	6	2-4	2,3,4	4-5
CSP		■					■	■
	Metric	3-25	6-25	6-25	6-25	2-20	4-25	6-25
	Inch							
Lungimi disponibile		2,3	2,3	2,3	2,3	1,2	2,3	2
Operaţiune								
								
								
								
SMG								
M1		•	•	•	•		•	
M2		•	•	•	•		•	
M3		•	•	•	•		•	
M4		•	•	•	•		•	
M5		•	•	•	•		•	
S1		•	•	•	•	•		
S2		•	•	•	•	•		
S3		•	•	•	•	•		
S11		•	•	•	•	•		•
S12		•	•	•	•	•		•
S13		•	•	•	•	•		•

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile. □ Safe-Lock disponibil, intervalul de livrare este de 6 zile
• Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Oţel inoxidabil și materiale S.

										
Nume		JHP780	JHP794	JCG790	JH724	JH726	JH734	JH736	JH744	JH746
Pag.		392	381	399	431	431	405	407	409	411
Familia		HPM	HPM	Ceramic	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO
Tipul frezei										
Coada	Cilindrică	■		■	■	■	■	■	■	■
	Weldon	■	■							
	Safelock	□								
Numărul de dinţi		4	4	5-6	6	6	4	6	4	6
CSP		■	■						■	■
	Metric	6-25	6-25	6-25	10	10	6-16	10-16	4-16	10-16
	Inch									
Lungimi disponibile		2	2	2	2	2	2	2	2,4	2
Operaţiune										
										
										
SMG										
M1			•		•	•	•	•	•	•
M2			•		•	•	•	•	•	•
M3			•		•	•	•	•	•	•
M4			•		•	•				
M5			•		•	•				
S1		•		•	•	•				
S2		•		•	•	•				
S3		•		•	•	•				
S11					•	•	•	•	•	•
S12					•	•	•	•	•	•
S13					•	•	•	•	•	•

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile. □ Safe-Lock disponibil, intervalul de livrare este de 6 zile
• Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Oţel inoxidabil și materiale S.

								
Nume		JH770	JH740	JH710	JH790	JH730	JHP994	JH780
Pag.		413	415	417	419	421	423	425
Familia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HPM	HSM/TORNADO
Tipul frezei								
Coada	Cilindrică	■	■	■	■	■	■	■
	Weldon							
	Safelock							
Numărul de dinţi		3,4,5,6	4-5	5	6	5,6,7	4	4
CSP								
	Metric	3-10	6-10	6-8	9,5	6-10	6-10	1,83-4,89
	Inch							
Lungimi disponibile		2	2	2	2,3	2	3	2
Operaţiune								
								
								
SMG								
M1								
M2								
M3								
M4								
M5								
S1								
S2		●	●	●	●	●	●	●
S3								
S11		●	●	●	●	●	●	
S12		●	●	●	●	●	●	●
S13								

■ Stoc standard ☐ Weldon disponibil, intervalul de livrare este de 3 zile. ☐ Safe-Lock disponibil, intervalul de livrare este de 6 zile
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Oţel inoxidabil și materiale S.

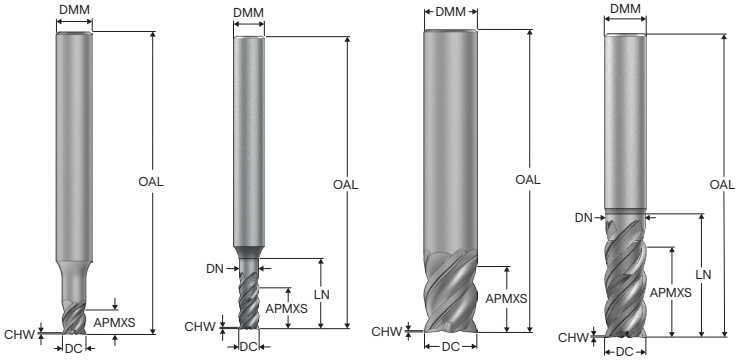
							
Nume		JHB720	JH721	JH722	SHF712	SME714/716	SMB713/714/416
Pag.		427	429	431	504	504	261
Familia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM	MINI	MINI
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon						
	Safelock						
Numărul de dinţi		3	6	6	3-4-5	3-4-5	4
CSP							
	Metric	2-16	6-8	10	1-10	1-10	0,5-3,0
	Inch						
Lungimi disponibile		2	2	2	1,2,3,4	1,2,3,4	2,4
Operaţiune							
							
							
SMG							
M1		●					
M2		●					
M3		●					
M4		●					
M5		●					
S1		○					
S2		○	●	●	●	●	●
S3		○					
S11		●	●	●			
S12		●	●	●	●	●	●
S13		●					

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Cilindrică – Șanfren







—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă dacă DC este ≥ Ø6

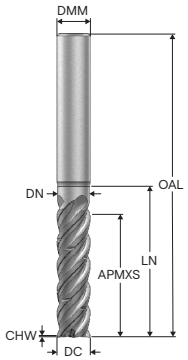
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.0Z4-HXT	10165556	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Cylindrical	■
JS754040F1C.0Z4-HXT	10164855	1	F	4,0	6,0	6,0	50,0	–	–	0,045	–	4	Cylindrical	■
JS754050F1C.0Z4-HXT	10165557	1	F	5,0	6,0	7,0	50,0	–	–	0,055	–	4	Cylindrical	■
JS754060D1C.0Z4-HXT	10164856	1	D	6,0	6,0	8,0	50,0	–	–	0,075	–	4	Cylindrical	■
JS754080D1C.0Z4-HXT	10164857	1	D	8,0	8,0	11,0	58,0	–	–	0,1	–	4	Cylindrical	■
JS754100D1C.0Z4-HXT	10164858	1	D	10,0	10,0	13,0	58,0	–	–	0,125	–	4	Cylindrical	■
JS754120D1C.0Z4-HXT	10164859	1	D	12,0	12,0	15,0	67,0	–	–	0,15	–	4	Cylindrical	■
JS754160D1C.0Z4-HXT	10164860	1	D	16,0	16,0	19,0	73,0	–	–	0,2	–	4	Cylindrical	■
JS754030G2C.0Z4-HXT	03186807	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	7,0	4	Cylindrical	■
JS754040G2C.0Z4-HXT	03186808	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4,0	4	Cylindrical	■
JS754050G2C.0Z4-HXT	03186809	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	2,0	4	Cylindrical	■
JS754060E2C.0Z4-HXT	03186810	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	–	4	Cylindrical	■
JS754080E2C.0Z4-HXT	03186811	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	–	4	Cylindrical	■
JS754100E2C.0Z4-HXT	03186812	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	–	4	Cylindrical	■
JS754120E2C.0Z4-HXT	03186813	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	–	4	Cylindrical	■
JS754160E2C.0Z4-HXT	03186814	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	–	4	Cylindrical	■
JS754200E2C.0Z4-HXT	03186815	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	–	4	Cylindrical	■
JS754060E3C.0Z4-HXT	03186823	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	–	4	Cylindrical	■
JS754080E3C.0Z4-HXT	03186824	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	–	4	Cylindrical	■
JS754100E3C.0Z4-HXT	03186825	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	–	4	Cylindrical	■
JS754120E3C.0Z4-HXT	03186826	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	–	4	Cylindrical	■
JS754160E3C.0Z4-HXT	03186827	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	–	4	Cylindrical	■
JS754200E3C.0Z4-HXT	03186828	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	–	4	Cylindrical	■
JS754250E3C.0Z4-HXT	03186829	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	–	4	Cylindrical	■

■ **Stoc standard.**

JS754

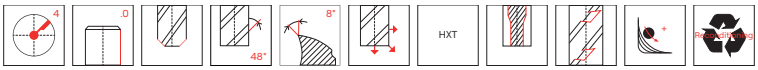
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Cilindrică – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



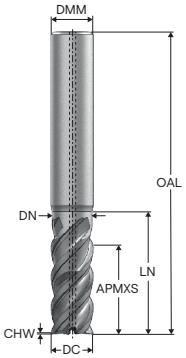
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
JS754120E2C.0Z4C-HXT	03186818	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
JS754060E3C.0Z4C-HXT	03200550	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Cylindrical	■
JS754080E3C.0Z4C-HXT	03200551	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Cylindrical	■
JS754100E3C.0Z4C-HXT	03186830	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Cylindrical	■
JS754120E3C.0Z4C-HXT	03186831	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Cylindrical	■
JS754160E3C.0Z4C-HXT	03186832	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Cylindrical	■
JS754200E3C.0Z4C-HXT	03186833	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Cylindrical	■

■ **Stoc standard.**

JS754

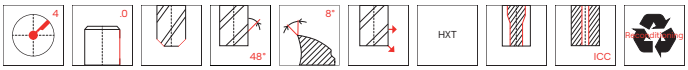
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Cilindrică – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă

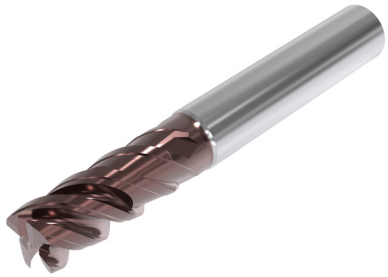


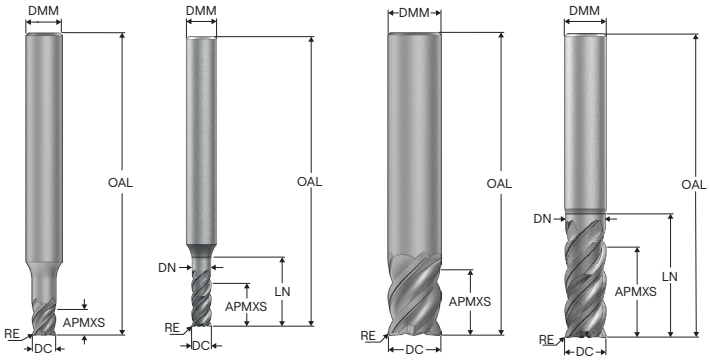
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Cylindrical	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Cylindrical	■
JS754100E2C.0Z4A-HXT	03186836	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
JS754120E2C.0Z4A-HXT	03186837	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
JS754160E2C.0Z4A-HXT	03186838	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Cylindrical	■
JS754200E2C.0Z4A-HXT	03186839	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Cylindrical	■

■ **Stoc standard.**

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

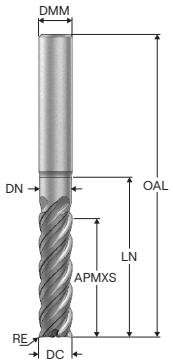
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.0Z4-HXT	10165558	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754040F1R020.0Z4-HXT	10164867	1	F	4,0	6,0	6,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754050F1R020.0Z4-HXT	10165559	1	F	5,0	6,0	7,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754060D1R020.0Z4-HXT	10164868	1	D	6,0	6,0	8,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754060D1R050.0Z4-HXT	10164869	1	D	6,0	6,0	8,0	50,0	–	–	0,5	–	4	Cylindrical	■
JS754080D1R050.0Z4-HXT	10164871	1	D	8,0	8,0	11,0	58,0	–	–	0,5	–	4	Cylindrical	■
JS754100D1R050.0Z4-HXT	10164873	1	D	10,0	10,0	13,0	58,0	–	–	0,5	–	4	Cylindrical	■
JS754100D1R100.0Z4-HXT	10164874	1	D	10,0	10,0	13,0	58,0	–	–	1,0	–	4	Cylindrical	■
JS754120D1R050.0Z4-HXT	10164875	1	D	12,0	12,0	15,0	67,0	–	–	0,5	–	4	Cylindrical	■
JS754120D1R100.0Z4-HXT	10164876	1	D	12,0	12,0	15,0	67,0	–	–	1,0	–	4	Cylindrical	■
JS754160D1R050.0Z4-HXT	10164877	1	D	16,0	16,0	19,0	73,0	–	–	0,5	–	4	Cylindrical	■
JS754160D1R100.0Z4-HXT	10164878	1	D	16,0	16,0	19,0	73,0	–	–	1,0	–	4	Cylindrical	■
JS754030G2R020.0Z4-HXT	03186840	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	7,0	4	Cylindrical	■
JS754040G2R020.0Z4-HXT	03186841	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4,0	4	Cylindrical	■
JS754050G2R020.0Z4-HXT	03186842	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	2,0	4	Cylindrical	■
JS754060E2R020.0Z4-HXT	03186843	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	–	4	Cylindrical	■
JS754060E2R050.0Z4-HXT	03186844	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	–	4	Cylindrical	■
JS754060E2R100.0Z4-HXT	03186845	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	–	4	Cylindrical	■
JS754080E2R050.0Z4-HXT	03186846	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	–	4	Cylindrical	■
JS754080E2R100.0Z4-HXT	03186847	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	–	4	Cylindrical	■
JS754100E2R050.0Z4-HXT	03186848	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	–	4	Cylindrical	■
JS754100E2R100.0Z4-HXT	03186849	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	–	4	Cylindrical	■
JS754100E2R150.0Z4-HXT	03200552	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	–	4	Cylindrical	■
JS754100E2R200.0Z4-HXT	03186850	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	–	4	Cylindrical	■
JS754100E2R300.0Z4-HXT	03186851	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	–	4	Cylindrical	■
JS754120E2R050.0Z4-HXT	03186852	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	–	4	Cylindrical	■
JS754120E2R100.0Z4-HXT	03186853	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	–	4	Cylindrical	■
JS754120E2R150.0Z4-HXT	03200553	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	–	4	Cylindrical	■
JS754120E2R200.0Z4-HXT	03186854	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	–	4	Cylindrical	■
JS754120E2R300.0Z4-HXT	03186855	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	–	4	Cylindrical	■
JS754160E2R050.0Z4-HXT	03186856	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	–	4	Cylindrical	■
JS754160E2R100.0Z4-HXT	03186857	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	–	4	Cylindrical	■
JS754160E2R200.0Z4-HXT	03186858	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	–	4	Cylindrical	■

■ **Stoc standard.**

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Cilindrică – Rază la vârf





E



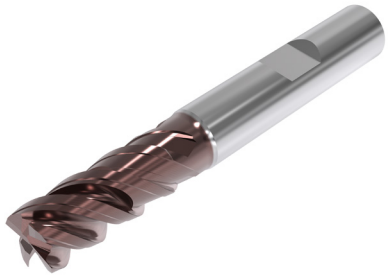
- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

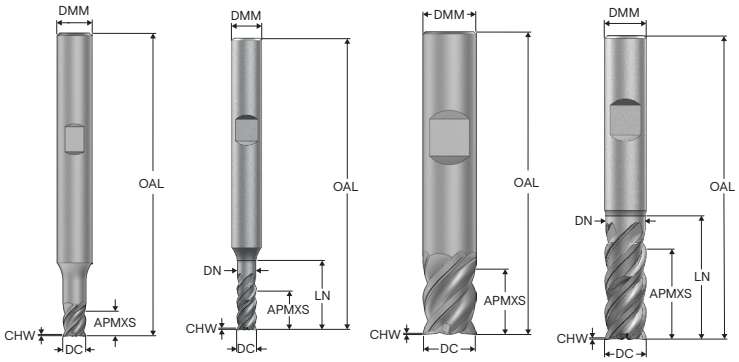
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	Cylindrical	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	Cylindrical	■
JS754160E2R600.0Z4-HXT	03186861	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	Cylindrical	■
JS754200E2R050.0Z4-HXT	03186862	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Cylindrical	■
JS754200E2R100.0Z4-HXT	03186863	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Cylindrical	■
JS754200E2R200.0Z4-HXT	03186864	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Cylindrical	■
JS754200E2R300.0Z4-HXT	03186865	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Cylindrical	■
JS754200E2R600.0Z4-HXT	03186867	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Cylindrical	■
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Cylindrical	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Cylindrical	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Cylindrical	■
JS754080E3R050.0Z4-HXT	03186876	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Cylindrical	■
JS754080E3R100.0Z4-HXT	03186877	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Cylindrical	■
JS754100E3R050.0Z4-HXT	03186878	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Cylindrical	■
JS754100E3R100.0Z4-HXT	03186879	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Cylindrical	■
JS754100E3R200.0Z4-HXT	03186880	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Cylindrical	■
JS754100E3R300.0Z4-HXT	03186881	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Cylindrical	■
JS754120E3R050.0Z4-HXT	03186882	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Cylindrical	■
JS754120E3R100.0Z4-HXT	03186883	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Cylindrical	■
JS754120E3R200.0Z4-HXT	03186884	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Cylindrical	■
JS754120E3R300.0Z4-HXT	03186885	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Cylindrical	■
JS754160E3R050.0Z4-HXT	03186886	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Cylindrical	■
JS754160E3R100.0Z4-HXT	03186887	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Cylindrical	■
JS754160E3R200.0Z4-HXT	03186888	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Cylindrical	■
JS754160E3R300.0Z4-HXT	03186889	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Cylindrical	■
JS754160E3R400.0Z4-HXT	03186890	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Cylindrical	■
JS754160E3R600.0Z4-HXT	03186891	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Cylindrical	■
JS754200E3R050.0Z4-HXT	03186892	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Cylindrical	■
JS754200E3R100.0Z4-HXT	03186893	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Cylindrical	■
JS754200E3R200.0Z4-HXT	03186894	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Cylindrical	■
JS754200E3R300.0Z4-HXT	03186895	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Cylindrical	■
JS754200E3R400.0Z4-HXT	03186896	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Cylindrical	■
JS754200E3R600.0Z4-HXT	03186897	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Cylindrical	■

■ **Stoc standard.**

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Weldon – Șanfren







—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă dacă DC este ≥ Ø6

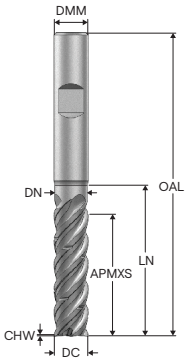
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.3Z4-HXT	10165658	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Weldon	□
JS754040F1C.3Z4-HXT	10164861	1	F	4,0	6,0	6,0	50,0	–	–	0,045	–	4	Weldon	□
JS754050F1C.3Z4-HXT	10165660	1	F	5,0	6,0	7,0	50,0	–	–	0,055	–	4	Weldon	□
JS754060D1C.3Z4-HXT	10164862	1	D	6,0	6,0	8,0	50,0	–	–	0,075	–	4	Weldon	□
JS754080D1C.3Z4-HXT	10164863	1	D	8,0	8,0	11,0	58,0	–	–	0,1	–	4	Weldon	□
JS754100D1C.3Z4-HXT	10164864	1	D	10,0	10,0	13,0	58,0	–	–	0,125	–	4	Weldon	□
JS754120D1C.3Z4-HXT	10164865	1	D	12,0	12,0	15,0	67,0	–	–	0,15	–	4	Weldon	□
JS754160D1C.3Z4-HXT	10164866	1	D	16,0	16,0	19,0	73,0	–	–	0,2	–	4	Weldon	□
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	7,0	4	Weldon	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4,0	4	Weldon	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	2,0	4	Weldon	□
JS754060E2C.3Z4-HXT	03186978	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	–	4	Weldon	■
JS754080E2C.3Z4-HXT	03186979	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	–	4	Weldon	■
JS754100E2C.3Z4-HXT	03186980	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	–	4	Weldon	■
JS754120E2C.3Z4-HXT	03186981	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	–	4	Weldon	■
JS754160E2C.3Z4-HXT	03186982	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	–	4	Weldon	■
JS754200E2C.3Z4-HXT	03186983	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	–	4	Weldon	■
JS754060E3C.3Z4-HXT	03186990	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	–	4	Weldon	■
JS754080E3C.3Z4-HXT	03186991	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	–	4	Weldon	■
JS754100E3C.3Z4-HXT	03186992	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	–	4	Weldon	■
JS754120E3C.3Z4-HXT	03186993	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	–	4	Weldon	■
JS754160E3C.3Z4-HXT	03186994	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	–	4	Weldon	■
JS754200E3C.3Z4-HXT	03186995	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	–	4	Weldon	■
JS754250E3C.3Z4-HXT	03186996	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	–	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

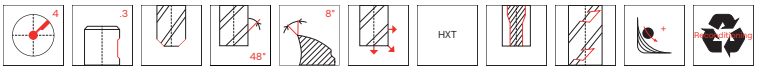
JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Weldon – Șanfren





E



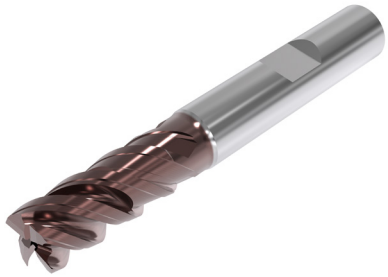
—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă

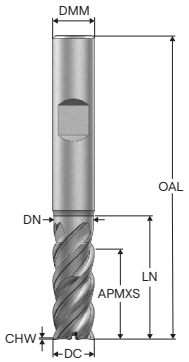
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Weldon	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Weldon	■
JS754060E3C.3Z4C-HXT	03200562	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Weldon	■
JS754080E3C.3Z4C-HXT	03200563	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Weldon	■
JS754100E3C.3Z4C-HXT	03186997	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Weldon	■
JS754120E3C.3Z4C-HXT	03186998	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Weldon	■
JS754160E3C.3Z4C-HXT	03186999	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Weldon	■
JS754200E3C.3Z4C-HXT	03187000	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Weldon	■

■ **Stoc standard.**

JS754

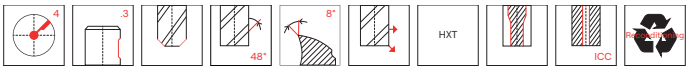
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Weldon – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă

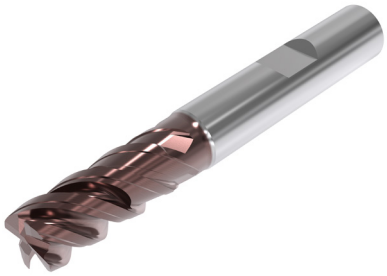


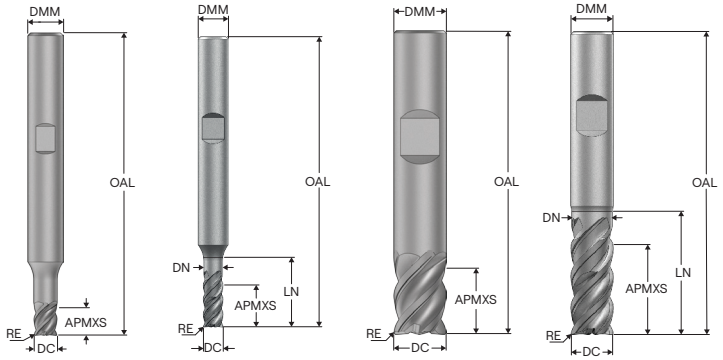
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Weldon	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Weldon	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Weldon	■
JS754120E2C.3Z4A-HXT	03187004	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Weldon	■
JS754160E2C.3Z4A-HXT	03187005	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Weldon	■
JS754200E2C.3Z4A-HXT	03187006	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Weldon	■

■ **Stoc standard.**

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Weldon – Rază la vârf







– Toleranţe:
– DMM= h5
– DC e7
– RE= ±0,02 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

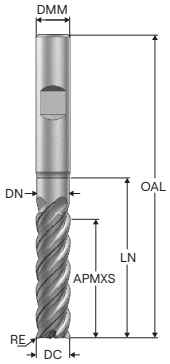
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.3Z4-HXT	10165560	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Weldon	□
JS754040F1R020.3Z4-HXT	10164879	1	F	4,0	6,0	6,0	50,0	–	–	0,2	–	4	Weldon	□
JS754050F1R020.3Z4-HXT	10165561	1	F	5,0	6,0	7,0	50,0	–	–	0,2	–	4	Weldon	□
JS754060D1R020.3Z4-HXT	10164880	1	D	6,0	6,0	8,0	50,0	–	–	0,2	–	4	Weldon	□
JS754060D1R050.3Z4-HXT	10164881	1	D	6,0	6,0	8,0	50,0	–	–	0,5	–	4	Weldon	□
JS754080D1R050.3Z4-HXT	10164883	1	D	8,0	8,0	11,0	58,0	–	–	0,5	–	4	Weldon	□
JS754100D1R050.3Z4-HXT	10164885	1	D	10,0	10,0	13,0	58,0	–	–	0,5	–	4	Weldon	□
JS754100D1R100.3Z4-HXT	10164886	1	D	10,0	10,0	13,0	58,0	–	–	1,0	–	4	Weldon	□
JS754120D1R050.3Z4-HXT	10164887	1	D	12,0	12,0	15,0	67,0	–	–	0,5	–	4	Weldon	□
JS754120D1R100.3Z4-HXT	10164888	1	D	12,0	12,0	15,0	67,0	–	–	1,0	–	4	Weldon	□
JS754160D1R050.3Z4-HXT	10164889	1	D	16,0	16,0	19,0	73,0	–	–	0,5	–	4	Weldon	□
JS754160D1R100.3Z4-HXT	10164890	1	D	16,0	16,0	19,0	73,0	–	–	1,0	–	4	Weldon	□
JS754030G2R020.3Z4-HXT	03187007	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	7,0	4	Weldon	□
JS754040G2R020.3Z4-HXT	03187008	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4,0	4	Weldon	□
JS754050G2R020.3Z4-HXT	03187009	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	2,0	4	Weldon	□
JS754060E2R020.3Z4-HXT	03187010	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	–	4	Weldon	■
JS754060E2R050.3Z4-HXT	03187011	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	–	4	Weldon	■
JS754060E2R100.3Z4-HXT	03187012	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	–	4	Weldon	■
JS754080E2R050.3Z4-HXT	03187013	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	–	4	Weldon	■
JS754080E2R100.3Z4-HXT	03187014	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	–	4	Weldon	■
JS754100E2R050.3Z4-HXT	03187015	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	–	4	Weldon	■
JS754100E2R100.3Z4-HXT	03187016	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	–	4	Weldon	■
JS754100E2R150.3Z4-HXT	03200564	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	–	4	Weldon	■
JS754100E2R200.3Z4-HXT	03187017	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	–	4	Weldon	■
JS754100E2R300.3Z4-HXT	03187018	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	–	4	Weldon	■
JS754120E2R050.3Z4-HXT	03187019	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	–	4	Weldon	■
JS754120E2R100.3Z4-HXT	03187020	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	–	4	Weldon	■
JS754120E2R150.3Z4-HXT	03200565	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	–	4	Weldon	■
JS754120E2R200.3Z4-HXT	03187021	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	–	4	Weldon	■
JS754120E2R300.3Z4-HXT	03187022	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	–	4	Weldon	■
JS754160E2R050.3Z4-HXT	03187023	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	–	4	Weldon	■
JS754160E2R100.3Z4-HXT	03187024	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	–	4	Weldon	■
JS754160E2R200.3Z4-HXT	03187025	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	–	4	Weldon	■
JS754160E2R300.3Z4-HXT	03187026	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	–	4	Weldon	■
JS754160E2R400.3Z4-HXT	03187027	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	–	4	Weldon	■
JS754160E2R600.3Z4-HXT	03187028	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	–	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Weldon – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

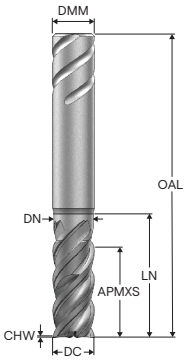
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Weldon	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Weldon	■
JS754200E2R200.3Z4-HXT	03187031	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Weldon	■
JS754200E2R300.3Z4-HXT	03187032	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Weldon	■
JS754200E2R600.3Z4-HXT	03187034	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Weldon	■
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Weldon	□
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Weldon	□
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Weldon	□
JS754080E3R050.3Z4-HXT	03187043	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Weldon	□
JS754080E3R100.3Z4-HXT	03187044	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Weldon	□
JS754100E3R050.3Z4-HXT	03187045	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Weldon	□
JS754100E3R100.3Z4-HXT	03187046	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Weldon	□
JS754100E3R200.3Z4-HXT	03187047	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Weldon	□
JS754100E3R300.3Z4-HXT	03187049	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Weldon	□
JS754120E3R050.3Z4-HXT	03187050	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Weldon	□
JS754120E3R100.3Z4-HXT	03187051	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Weldon	□
JS754120E3R200.3Z4-HXT	03187052	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Weldon	□
JS754120E3R300.3Z4-HXT	03187053	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Weldon	□
JS754160E3R050.3Z4-HXT	03187054	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Weldon	■
JS754160E3R100.3Z4-HXT	03187055	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Weldon	□
JS754160E3R200.3Z4-HXT	03187056	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Weldon	□
JS754160E3R300.3Z4-HXT	03187057	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Weldon	□
JS754160E3R400.3Z4-HXT	03187058	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Weldon	□
JS754160E3R600.3Z4-HXT	03187059	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Weldon	□
JS754200E3R050.3Z4-HXT	03187060	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Weldon	□
JS754200E3R100.3Z4-HXT	03187061	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Weldon	□
JS754200E3R200.3Z4-HXT	03187062	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Weldon	□
JS754200E3R300.3Z4-HXT	03187063	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Weldon	□
JS754200E3R400.3Z4-HXT	03187064	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Weldon	□
JS754200E3R600.3Z4-HXT	03187065	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Safelock – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



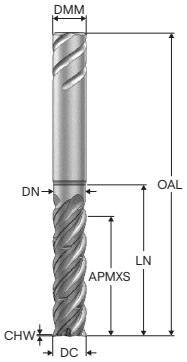
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Safe-lock	☐
JS754100E2C.9Z4-HXT	03187146	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	☐
JS754120E2C.9Z4-HXT	03187147	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	☐
JS754160E2C.9Z4-HXT	03187148	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Safe-lock	☐
JS754200E2C.9Z4-HXT	03187149	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Safe-lock	☐
JS754250E2C.9Z4-HXT	03187150	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	Safe-lock	☐
JS754060E3C.9Z4-HXT	03187153	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Safe-lock	☐
JS754080E3C.9Z4-HXT	03187154	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Safe-lock	☐
JS754100E3C.9Z4-HXT	03187155	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Safe-lock	☐
JS754120E3C.9Z4-HXT	03187156	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Safe-lock	☐
JS754160E3C.9Z4-HXT	03187157	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Safe-lock	☐
JS754200E3C.9Z4-HXT	03187158	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Safe-lock	☐
JS754250E3C.9Z4-HXT	03187159	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

JS754

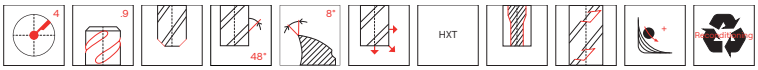
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Safelock – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



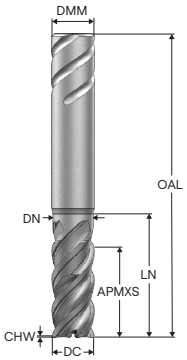
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	□
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	□
JS754060E3C.9Z4C-HXT	03200571	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Safe-lock	□
JS754080E3C.9Z4C-HXT	03200572	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Safe-lock	□
JS754100E3C.9Z4C-HXT	03187160	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Safe-lock	□
JS754120E3C.9Z4C-HXT	03187161	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Safe-lock	□
JS754160E3C.9Z4C-HXT	03187162	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Safe-lock	□
JS754200E3C.9Z4C-HXT	03187163	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.

JS754

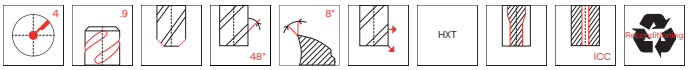
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Safelock – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



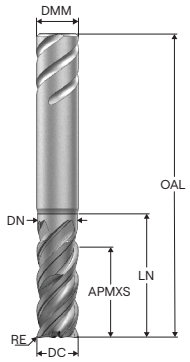
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	□
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Safe-lock	□
JS754100E2C.9Z4A-HXT	03187166	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	□
JS754120E2C.9Z4A-HXT	03187167	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	□
JS754160E2C.9Z4A-HXT	03187168	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Safe-lock	□
JS754200E2C.9Z4A-HXT	03187169	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.
ICC = Canal de agent de răcire complet

JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Safelock – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

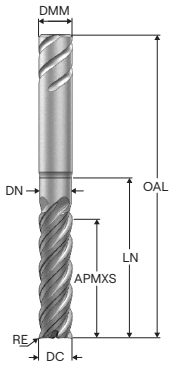
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	Safe-lock	□
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Safe-lock	□
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Safe-lock	□
JS754080E2R050.9Z4-HXT	03187173	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Safe-lock	□
JS754080E2R100.9Z4-HXT	03187174	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Safe-lock	□
JS754100E2R050.9Z4-HXT	03187175	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Safe-lock	□
JS754100E2R100.9Z4-HXT	03187176	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Safe-lock	□
JS754100E2R150.9Z4-HXT	03200573	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	Safe-lock	□
JS754100E2R200.9Z4-HXT	03187177	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	Safe-lock	□
JS754100E2R300.9Z4-HXT	03187178	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	Safe-lock	□
JS754120E2R050.9Z4-HXT	03187179	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Safe-lock	□
JS754120E2R100.9Z4-HXT	03187180	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Safe-lock	□
JS754120E2R150.9Z4-HXT	03200832	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	Safe-lock	□
JS754120E2R200.9Z4-HXT	03187181	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	Safe-lock	□
JS754120E2R300.9Z4-HXT	03187182	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	Safe-lock	□
JS754160E2R050.9Z4-HXT	03187183	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Safe-lock	□
JS754160E2R100.9Z4-HXT	03187184	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Safe-lock	□
JS754160E2R200.9Z4-HXT	03187185	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	Safe-lock	□
JS754160E2R300.9Z4-HXT	03187186	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	Safe-lock	□
JS754160E2R400.9Z4-HXT	03187187	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	Safe-lock	■
JS754160E2R600.9Z4-HXT	03187188	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	Safe-lock	□
JS754200E2R050.9Z4-HXT	03187189	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Safe-lock	□
JS754200E2R100.9Z4-HXT	03187190	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Safe-lock	□
JS754200E2R200.9Z4-HXT	03187191	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Safe-lock	□
JS754200E2R300.9Z4-HXT	03187192	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Safe-lock	□
JS754200E2R400.9Z4-HXT	03187193	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	Safe-lock	□
JS754200E2R600.9Z4-HXT	03187194	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.

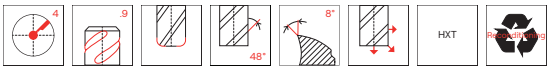
JS754

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 4 Caneluri – Safelock – Rază la vârf





E



– Toleranţe:
– DMM= h5
– DC e7
– RE= ±0,02 mm
– Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E3R020.9Z4-HXT	03187197	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Safe-lock	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Safe-lock	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Safe-lock	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Safe-lock	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Safe-lock	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Safe-lock	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Safe-lock	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Safe-lock	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Safe-lock	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Safe-lock	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Safe-lock	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Safe-lock	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Safe-lock	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Safe-lock	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Safe-lock	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Safe-lock	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Safe-lock	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Safe-lock	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Safe-lock	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Safe-lock	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Safe-lock	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Safe-lock	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Safe-lock	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Safe-lock	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

Parametri de așchiere – JS754 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (130 — 180) *540 (430 — 590)*
P12	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	105 (83 — 120) *345 (280 — 390)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 130) *360 (320 — 420)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 110) *295 (260 — 360)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (44 — 76) *195 (150 — 240)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	46 (34 — 59) *150 (120 — 190)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	39 (29 — 49) *130 (96 — 160)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	50 (26 — 68) *165 (86 — 220)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	41 (21 — 55) *135 (69 — 180)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	36 (19 — 48) *120 (63 — 150)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (73 — 140) *360 (240 — 450)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (56 — 110) *280 (190 — 360)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (44 — 87) *215 (150 — 280)*

Parametri de așchiere – JS754 Frezare de canal

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	150 (120 — 170) *490 (400 — 550)*
P12	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	90 (69 — 100) *295 (230 — 320)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85 — 120) *310 (280 — 390)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 97) *260 (230 — 310)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	55 (39 — 67) *180 (130 — 210)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	40 (29 — 50) *130 (96 — 160)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (25 — 42) *110 (83 — 130)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	41 (21 — 54) *135 (69 — 170)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (17 — 43) *110 (56 — 140)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	28 (15 — 37) *90 (50 — 120)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (63 — 120) *310 (210 — 390)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (48 — 95) *230 (160 — 310)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (38 — 74) *180 (130 — 240)*

Dacă raza depășește cu 15% valoarea DC, reduceţi fz cu 20%

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS754-2C Degroșare avansată a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P11	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.15 *0,0060*	0.17 *0,0065*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M1	E	0.100 *0,100*	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	205 (180 — 230) *670 (600 — 750)*
M2	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M3	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	130 (120 — 150) *425 (400 — 490)*
M4	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	60 (35 — 80) *195 (120 — 260)*
S3	E	0.0500 *0,0500*	2.0 *2,0*	0.080 *0,0032*	0.095 *0,0038*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	2.0 *2,0*	0.060 *0,0024*	0.070 *0,0028*	100 (84 — 110) *330 (280 — 360)*

Parametri de așchiere – JS754-3C Degroșare avansată a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 230) *670 (560 — 750)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 190) *560 (460 — 620)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 150) *425 (370 — 490)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (30 — 70) *165 (99 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (84 — 110) *330 (280 — 360)*

Dacă raza depășește cu 15% valoarea DC, reduceţi fz cu 20%

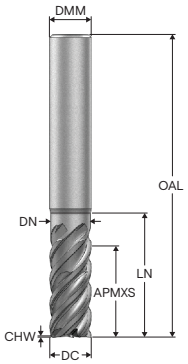
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Cilindrică – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



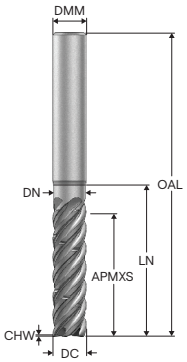
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Cylindrical	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Cylindrical	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Cylindrical	■
JS755120E2C.0Z5-HXT	03186910	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Cylindrical	■
JS755160E2C.0Z5-HXT	03186911	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Cylindrical	■
JS755200E2C.0Z5-HXT	03186912	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Cylindrical	■
JS755250E2C.0Z5-HXT	03186913	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Cylindrical	■
JS755060E3C.0Z5-HXT	03186914	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Cylindrical	■
JS755080E3C.0Z5-HXT	03186915	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Cylindrical	■
JS755100E3C.0Z5-HXT	03186916	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Cylindrical	■
JS755120E3C.0Z5-HXT	03186917	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Cylindrical	■
JS755160E3C.0Z5-HXT	03186918	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Cylindrical	■
JS755200E3C.0Z5-HXT	03186919	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Cylindrical	■
JS755250E3C.0Z5-HXT	03186920	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Cylindrical	■

■ **Stoc standard.**

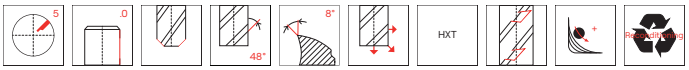
JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Cilindrică – Șanfren





E



- Toleranţe:
- DMM= h5
- DC e7
- Reascuţire posibilă

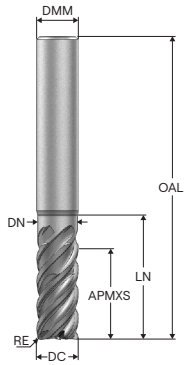
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Cylindrical	■
JS755120E3C.0Z5C-HXT	03186922	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Cylindrical	■
JS755160E3C.0Z5C-HXT	03186923	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Cylindrical	■
JS755200E3C.0Z5C-HXT	03186924	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Cylindrical	■

■ **Stoc standard.**

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Cilindrică – Rază la vârf





E

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



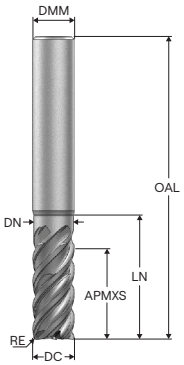
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Cylindrical	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Cylindrical	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Cylindrical	■
JS755080E2R050.0Z5-HXT	03186928	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Cylindrical	■
JS755080E2R100.0Z5-HXT	03186929	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Cylindrical	■
JS755100E2R050.0Z5-HXT	03186930	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Cylindrical	■
JS755100E2R100.0Z5-HXT	03186931	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Cylindrical	■
JS755100E2R200.0Z5-HXT	03186932	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Cylindrical	■
JS755100E2R300.0Z5-HXT	03186933	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Cylindrical	■
JS755120E2R050.0Z5-HXT	03186934	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Cylindrical	■
JS755120E2R100.0Z5-HXT	03186935	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Cylindrical	■
JS755120E2R200.0Z5-HXT	03186936	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Cylindrical	■
JS755120E2R300.0Z5-HXT	03186937	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Cylindrical	■
JS755160E2R050.0Z5-HXT	03186938	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Cylindrical	■
JS755160E2R100.0Z5-HXT	03186939	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Cylindrical	■
JS755200E2R050.0Z5-HXT	03186941	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Cylindrical	■
JS755200E2R100.0Z5-HXT	03186942	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Cylindrical	■

■ **Stoc standard.**

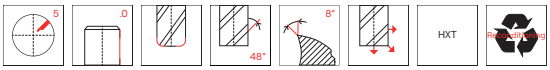
JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Cilindrică – Rază la vârf





E



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

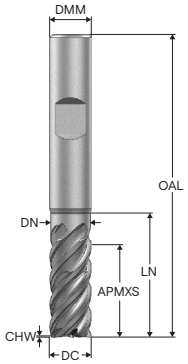
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Cylindrical	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Cylindrical	■
JS755060E3R100.0Z5-HXT	03186948	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Cylindrical	■
JS755080E3R050.0Z5-HXT	03186949	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Cylindrical	■
JS755080E3R100.0Z5-HXT	03186950	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Cylindrical	■
JS755100E3R050.0Z5-HXT	03186951	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Cylindrical	■
JS755100E3R100.0Z5-HXT	03186952	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Cylindrical	■
JS755100E3R200.0Z5-HXT	03186953	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Cylindrical	■
JS755100E3R300.0Z5-HXT	03186954	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Cylindrical	■
JS755120E3R050.0Z5-HXT	03186955	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Cylindrical	■
JS755120E3R100.0Z5-HXT	03186956	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Cylindrical	■
JS755120E3R200.0Z5-HXT	03186957	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Cylindrical	■
JS755120E3R300.0Z5-HXT	03186958	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Cylindrical	■
JS755160E3R050.0Z5-HXT	03186959	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Cylindrical	■
JS755160E3R600.0Z5-HXT	03186960	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Cylindrical	■
JS755200E3R050.0Z5-HXT	03186961	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Cylindrical	■
JS755200E3R600.0Z5-HXT	03186962	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Cylindrical	■

■ **Stoc standard.**

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Weldon – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



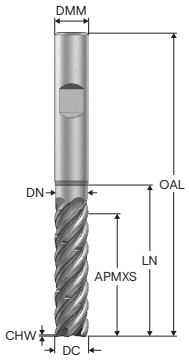
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Weldon	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Weldon	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Weldon	■
JS755120E2C.3Z5-HXT	03187086	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Weldon	■
JS755160E2C.3Z5-HXT	03187087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Weldon	■
JS755200E2C.3Z5-HXT	03187088	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Weldon	■
JS755250E2C.3Z5-HXT	03187089	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Weldon	■
JS755060E3C.3Z5-HXT	03187090	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Weldon	■
JS755080E3C.3Z5-HXT	03187091	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Weldon	■
JS755100E3C.3Z5-HXT	03187092	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Weldon	■
JS755120E3C.3Z5-HXT	03187093	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Weldon	■
JS755160E3C.3Z5-HXT	03187094	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Weldon	■
JS755200E3C.3Z5-HXT	03187095	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Weldon	■
JS755250E3C.3Z5-HXT	03187096	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Weldon	■

■ **Stoc standard.**

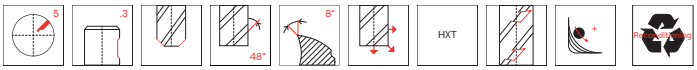
JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Weldon – Șanfren





E



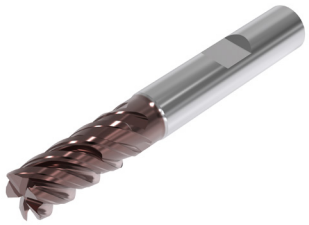
- Toleranţe:
- DMM= h5
- DC e7
- Reascuţire posibilă

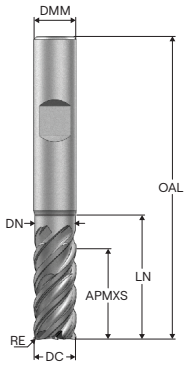
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Weldon	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Weldon	■
JS755160E3C.3Z5C-HXT	03187099	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Weldon	■
JS755200E3C.3Z5C-HXT	03187100	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Weldon	■

■ **Stoc standard.**

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Weldon – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

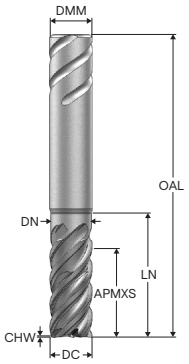
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Weldon	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Weldon	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Weldon	■
JS755080E2R050.3Z5-HXT	03187104	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Weldon	■
JS755080E2R100.3Z5-HXT	03187105	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Weldon	■
JS755100E2R050.3Z5-HXT	03187106	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Weldon	■
JS755100E2R100.3Z5-HXT	03187107	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Weldon	■
JS755100E2R200.3Z5-HXT	03187108	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Weldon	■
JS755100E2R300.3Z5-HXT	03187109	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Weldon	■
JS755120E2R050.3Z5-HXT	03187110	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Weldon	■
JS755120E2R100.3Z5-HXT	03187111	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Weldon	■
JS755120E2R200.3Z5-HXT	03187112	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Weldon	■
JS755120E2R300.3Z5-HXT	03187113	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Weldon	■
JS755160E2R050.3Z5-HXT	03187114	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Weldon	■
JS755160E2R100.3Z5-HXT	03187115	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Weldon	■
JS755160E2R600.3Z5-HXT	03187116	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	Weldon	■
JS755200E2R050.3Z5-HXT	03187117	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Weldon	■
JS755200E2R100.3Z5-HXT	03187118	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Weldon	■
JS755200E2R600.3Z5-HXT	03187119	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	Weldon	■
JS755060E3R020.3Z5-HXT	03187122	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Weldon	□
JS755060E3R050.3Z5-HXT	03187123	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Weldon	□
JS755060E3R100.3Z5-HXT	03187124	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Weldon	□
JS755080E3R050.3Z5-HXT	03187125	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Weldon	□
JS755080E3R100.3Z5-HXT	03187126	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Weldon	□
JS755100E3R050.3Z5-HXT	03187127	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Weldon	□
JS755100E3R100.3Z5-HXT	03187128	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Weldon	□
JS755100E3R200.3Z5-HXT	03187129	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Weldon	□
JS755100E3R300.3Z5-HXT	03187130	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Weldon	□
JS755120E3R050.3Z5-HXT	03187131	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Weldon	□
JS755120E3R100.3Z5-HXT	03187132	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Weldon	□
JS755120E3R200.3Z5-HXT	03187133	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Weldon	□
JS755120E3R300.3Z5-HXT	03187134	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Weldon	□
JS755160E3R050.3Z5-HXT	03187135	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Weldon	□
JS755160E3R600.3Z5-HXT	03187136	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Weldon	□
JS755200E3R050.3Z5-HXT	03187137	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Weldon	□
JS755200E3R600.3Z5-HXT	03187138	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Safelock – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



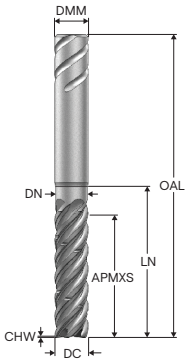
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Safe-lock	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Safe-lock	☐
JS755100E2C.9Z5-HXT	03187237	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Safe-lock	☐
JS755120E2C.9Z5-HXT	03187238	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Safe-lock	☐
JS755160E2C.9Z5-HXT	03187239	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Safe-lock	☐
JS755200E2C.9Z5-HXT	03187240	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Safe-lock	☐
JS755250E2C.9Z5-HXT	03187241	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Safe-lock	☐
JS755060E3C.9Z5-HXT	03187242	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Safe-lock	☐
JS755080E3C.9Z5-HXT	03187243	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Safe-lock	☐
JS755100E3C.9Z5-HXT	03187244	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Safe-lock	☐
JS755120E3C.9Z5-HXT	03187245	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Safe-lock	☐
JS755160E3C.9Z5-HXT	03187246	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Safe-lock	☐
JS755200E3C.9Z5-HXT	03187247	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Safe-lock	☐
JS755250E3C.9Z5-HXT	03187248	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

JS755

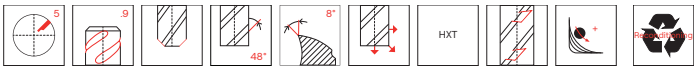
Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Safelock – Șanfren





E

—Toleranţe:
—DMM= h5
—DC e7
—Reascuţire posibilă



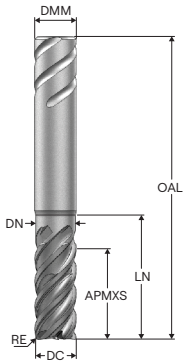
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Safe-lock	□
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Safe-lock	□
JS755160E3C.9Z5C-HXT	03187252	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Safe-lock	□
JS755200E3C.9Z5C-HXT	03187253	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.

JS755

Înaltă performanţă – Pătrat – ISO– M și ISO– S – 5 Caneluri – Safelock – Rază la vârf





E



– Toleranţe:
– DMM= h5
– DC e7
– RE= ±0,02 mm
– Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.9Z5-HXT	03187254	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Safe-lock	☐
JS755060E2R050.9Z5-HXT	03187255	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Safe-lock	☐
JS755060E2R100.9Z5-HXT	03187256	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Safe-lock	☐
JS755080E2R050.9Z5-HXT	03187257	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Safe-lock	☐
JS755080E2R100.9Z5-HXT	03187258	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Safe-lock	☐
JS755100E2R050.9Z5-HXT	03187259	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Safe-lock	☐
JS755100E2R100.9Z5-HXT	03187260	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Safe-lock	☐
JS755100E2R200.9Z5-HXT	03187261	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Safe-lock	☐
JS755100E2R300.9Z5-HXT	03187262	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Safe-lock	☐
JS755120E2R050.9Z5-HXT	03187263	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Safe-lock	☐
JS755120E2R100.9Z5-HXT	03187264	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Safe-lock	☐
JS755120E2R200.9Z5-HXT	03187265	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Safe-lock	☐
JS755120E2R300.9Z5-HXT	03187266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Safe-lock	☐
JS755160E2R050.9Z5-HXT	03187267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Safe-lock	☐
JS755160E2R100.9Z5-HXT	03187269	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Safe-lock	☐
JS755160E2R600.9Z5-HXT	03187270	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	Safe-lock	☐
JS755200E2R050.9Z5-HXT	03187271	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Safe-lock	☐
JS755200E2R100.9Z5-HXT	03187272	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Safe-lock	☐
JS755200E2R600.9Z5-HXT	03187273	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	Safe-lock	☐
JS755060E3R020.9Z5-HXT	03187276	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Safe-lock	☐
JS755060E3R050.9Z5-HXT	03187277	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Safe-lock	☐
JS755060E3R100.9Z5-HXT	03187279	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Safe-lock	☐
JS755080E3R050.9Z5-HXT	03187280	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Safe-lock	☐
JS755080E3R100.9Z5-HXT	03187281	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Safe-lock	☐
JS755100E3R050.9Z5-HXT	03187282	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Safe-lock	☐
JS755100E3R100.9Z5-HXT	03187283	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Safe-lock	☐
JS755100E3R200.9Z5-HXT	03187284	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Safe-lock	☐
JS755100E3R300.9Z5-HXT	03187285	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Safe-lock	☐
JS755120E3R050.9Z5-HXT	03187286	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Safe-lock	☐
JS755120E3R100.9Z5-HXT	03187287	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Safe-lock	☐
JS755120E3R200.9Z5-HXT	03187288	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Safe-lock	☐
JS755120E3R300.9Z5-HXT	03187289	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Safe-lock	☐
JS755160E3R050.9Z5-HXT	03187290	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Safe-lock	☐
JS755160E3R600.9Z5-HXT	03187291	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Safe-lock	☐
JS755200E3R050.9Z5-HXT	03187292	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Safe-lock	☐
JS755200E3R600.9Z5-HXT	03187293	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

Parametri de așchiere – JS755 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	135 (97 — 150) *445 (320 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	85 (63 — 99) *280 (210 — 320)*
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 150) *460 (400 — 490)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (92 — 120) *360 (310 — 390)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (71 — 95) *280 (240 — 310)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	70 (59 — 79) *230 (200 — 250)*
S1	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	70 (48 — 110) *230 (160 — 360)*
S2	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	60 (39 — 89) *195 (130 — 290)*
S3	E	0.0300 *0,0300*	2.0 *2,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (34 — 78) *165 (120 — 250)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 160) *460 (400 — 520)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (91 — 120) *360 (300 — 390)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (73 — 100) *280 (240 — 320)*

Parametri de așchiere – JS755_3C Degroșare avansată a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 220) *670 (560 — 720)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (85 — 110) *330 (280 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 190) *520 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (83 — 110) *330 (280 — 360)*

Dacă raza depășește cu 15% valoarea DC, reduceţi fz cu 20%

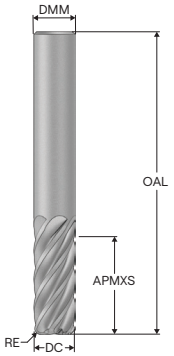
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

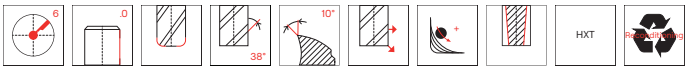
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Cilindrică – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

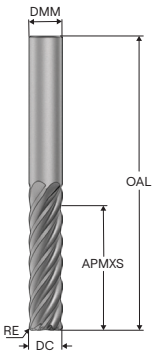
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	Cylindrical	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	Cylindrical	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	Cylindrical	■
JS720080D2R100.0Z6-HXT	03061294	2	D	8,0	8,0	23,0	63,0	1,0	6	Cylindrical	■
JS720100D2R050.0Z6-HXT	03060296	2	D	10,0	10,0	26,0	72,0	0,5	6	Cylindrical	■
JS720100D2R100.0Z6-HXT	03060298	2	D	10,0	10,0	26,0	72,0	1,0	6	Cylindrical	■
JS720100D2R200.0Z6-HXT	03060299	2	D	10,0	10,0	26,0	72,0	2,0	6	Cylindrical	■
JS720100D2R300.0Z6-HXT	03060300	2	D	10,0	10,0	26,0	72,0	3,0	6	Cylindrical	■
JS720120D2R050.0Z6-HXT	03060301	2	D	12,0	12,0	30,0	83,0	0,5	6	Cylindrical	■
JS720120D2R100.0Z6-HXT	03060304	2	D	12,0	12,0	30,0	83,0	1,0	6	Cylindrical	■
JS720120D2R200.0Z6-HXT	03060305	2	D	12,0	12,0	30,0	83,0	2,0	6	Cylindrical	■
JS720120D2R300.0Z6-HXT	03060306	2	D	12,0	12,0	30,0	83,0	3,0	6	Cylindrical	■
JS720160D2R050.0Z6-HXT	03060307	2	D	16,0	16,0	44,0	99,0	0,5	6	Cylindrical	■
JS720160D2R100.0Z6-HXT	03060309	2	D	16,0	16,0	44,0	99,0	1,0	6	Cylindrical	■
JS720160D2R200.0Z6-HXT	03060310	2	D	16,0	16,0	44,0	99,0	2,0	6	Cylindrical	■
JS720160D2R300.0Z6-HXT	03060311	2	D	16,0	16,0	44,0	99,0	3,0	6	Cylindrical	■
JS720160D2R400.0Z6-HXT	03060312	2	D	16,0	16,0	44,0	99,0	4,0	6	Cylindrical	■
JS720160D2R600.0Z6-HXT	03060313	2	D	16,0	16,0	44,0	99,0	6,0	6	Cylindrical	■
JS720200D2R050.0Z6-HXT	10228426	2	D	20,0	20,0	45,0	105,0	0,5	6	Cylindrical	■
JS720200D2R100.0Z6-HXT	10228427	2	D	20,0	20,0	45,0	105,0	1,0	6	Cylindrical	■
JS720200D2R200.0Z6-HXT	10228428	2	D	20,0	20,0	45,0	105,0	2,0	6	Cylindrical	■
JS720200D2R300.0Z6-HXT	10228429	2	D	20,0	20,0	45,0	105,0	3,0	6	Cylindrical	■
JS720250D2R100.0Z6-HXT	10228431	2	D	25,0	25,0	50,0	125,0	1,0	6	Cylindrical	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	6	Cylindrical	■

■ **Stoc standard.**

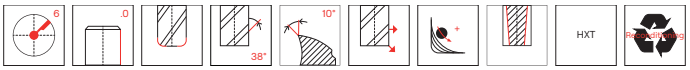
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Cilindrică – Rază la vârf





D



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

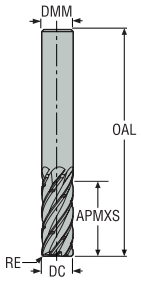
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720080D3R050.0Z6-HXT	10228433	3	D	8,0	8,0	32,0	80,0	0,5	6	Cylindrical	■
JS720080D3R100.0Z6-HXT	10228434	3	D	8,0	8,0	32,0	80,0	1,0	6	Cylindrical	■
JS720100D3R050.0Z6-HXT	10228435	3	D	10,0	10,0	40,0	89,0	0,5	6	Cylindrical	■
JS720100D3R100.0Z6-HXT	10228436	3	D	10,0	10,0	40,0	89,0	1,0	6	Cylindrical	■
JS720100D3R200.0Z6-HXT	10228437	3	D	10,0	10,0	40,0	89,0	2,0	6	Cylindrical	■
JS720120D3R050.0Z6-HXT	10228438	3	D	12,0	12,0	45,0	100,0	0,5	6	Cylindrical	■
JS720120D3R100.0Z6-HXT	10228439	3	D	12,0	12,0	45,0	100,0	1,0	6	Cylindrical	■
JS720120D3R200.0Z6-HXT	10228440	3	D	12,0	12,0	45,0	100,0	2,0	6	Cylindrical	■
JS720160D3R050.0Z6-HXT	10228441	3	D	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6-HXT	10228442	3	D	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6-HXT	10228443	3	D	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	Cylindrical	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	Cylindrical	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	Cylindrical	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	Cylindrical	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Stoc standard.**

JS720

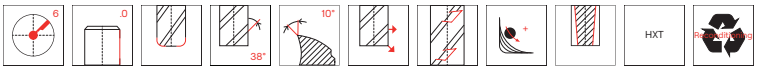
Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Cilindrică – Rază la vârf





D

- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă



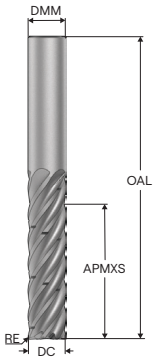
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720080D2R050.0Z6C-HXT	10228513	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Cylindrical	■
JS720080D2R100.0Z6C-HXT	10228514	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Cylindrical	■
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Cylindrical	■
JS720100D2R100.0Z6C-HXT	10228515	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Cylindrical	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Cylindrical	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Cylindrical	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Cylindrical	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Cylindrical	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Cylindrical	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Cylindrical	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Cylindrical	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Cylindrical	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Cylindrical	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Cylindrical	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Cylindrical	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Cylindrical	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Cylindrical	■

■ **Stoc standard.**

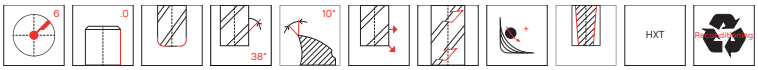
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Cilindrică – Rază la vârf





D



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

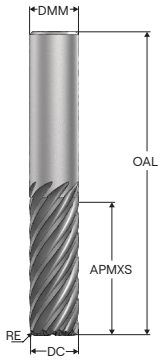
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720160D3R050.0Z6C-HXT	10228516	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6C-HXT	10228517	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6C-HXT	10228518	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6C-HXT	10228519	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Stoc standard.**

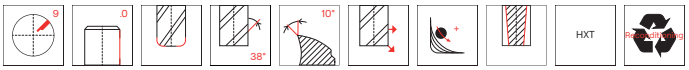
JS720

Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Cilindrică – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

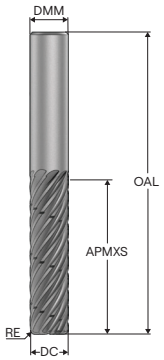
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	Cylindrical	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	Cylindrical	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	Cylindrical	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	Cylindrical	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	Cylindrical	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	Cylindrical	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	Cylindrical	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	Cylindrical	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	Cylindrical	■
JS720200D2R100.0Z9-HXT	10228393	2	D	20,0	20,0	45,0	105,0	1,0	9	Cylindrical	■
JS720200D2R200.0Z9-HXT	10228394	2	D	20,0	20,0	45,0	105,0	2,0	9	Cylindrical	■
JS720200D2R300.0Z9-HXT	10228395	2	D	20,0	20,0	45,0	105,0	3,0	9	Cylindrical	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	Cylindrical	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	Cylindrical	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	Cylindrical	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	Cylindrical	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	Cylindrical	■

■ **Stoc standard.**

JS720

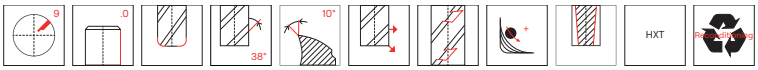
Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Cilindrică – Rază la vârf





D

- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă



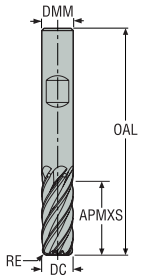
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■

■ **Stoc standard.**

JS720

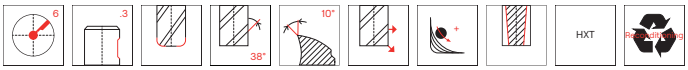
Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Weldon – Rază la vârf





D

- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă



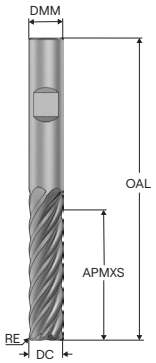
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	Weldon	□
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	Weldon	□
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	Weldon	□
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	Weldon	□
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	Weldon	□
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	Weldon	□
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	Weldon	□
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	Weldon	□
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	Weldon	□
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	Weldon	□
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	Weldon	□
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	Weldon	□
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	Weldon	□
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	Weldon	□
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	Weldon	□
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	Weldon	□
JS720200D2R050.3Z6-HXT	10228444	2	D	20,0	20,0	45,0	105,0	0,5	6	Weldon	□
JS720200D2R100.3Z6-HXT	10228445	2	D	20,0	20,0	45,0	105,0	1,0	6	Weldon	□
JS720200D2R200.3Z6-HXT	10228446	2	D	20,0	20,0	45,0	105,0	2,0	6	Weldon	□
JS720200D2R300.3Z6-HXT	10228447	2	D	20,0	20,0	45,0	105,0	3,0	6	Weldon	□
JS720250D2R050.3Z6-HXT	10228448	2	D	25,0	25,0	50,0	125,0	0,5	6	Weldon	□
JS720250D2R100.3Z6-HXT	10228449	2	D	25,0	25,0	50,0	125,0	1,0	6	Weldon	□
JS720250D2R200.3Z6-HXT	10228450	2	D	25,0	25,0	50,0	125,0	2,0	6	Weldon	□
JS720250D2R300.3Z6-HXT	10228451	2	D	25,0	25,0	50,0	125,0	3,0	6	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

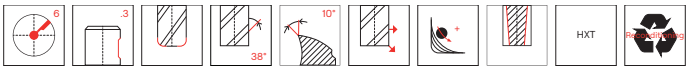
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Weldon – Rază la vârf





D



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

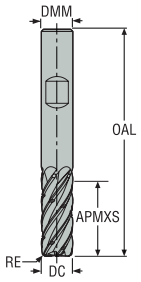
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720080D3R050.3Z6-HXT	10228452	3	D	8,0	8,0	32,0	80,0	0,5	6	Weldon	□
JS720080D3R100.3Z6-HXT	10228453	3	D	8,0	8,0	32,0	80,0	1,0	6	Weldon	□
JS720100D3R050.3Z6-HXT	10228454	3	D	10,0	10,0	40,0	89,0	0,5	6	Weldon	□
JS720100D3R100.3Z6-HXT	10228455	3	D	10,0	10,0	40,0	89,0	1,0	6	Weldon	□
JS720100D3R200.3Z6-HXT	10228456	3	D	10,0	10,0	40,0	89,0	2,0	6	Weldon	□
JS720120D3R050.3Z6-HXT	10228457	3	D	12,0	12,0	45,0	100,0	0,5	6	Weldon	□
JS720120D3R100.3Z6-HXT	10228458	3	D	12,0	12,0	45,0	100,0	1,0	6	Weldon	□
JS720120D3R200.3Z6-HXT	10228459	3	D	12,0	12,0	45,0	100,0	2,0	6	Weldon	□
JS720160D3R050.3Z6-HXT	10228460	3	D	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6-HXT	10228461	3	D	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6-HXT	10228462	3	D	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6-HXT	10228463	3	D	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	Weldon	□
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	Weldon	□
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	Weldon	□
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	Weldon	□
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	Weldon	□
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	Weldon	□
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	Weldon	□
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	Weldon	□
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	Weldon	□
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS720

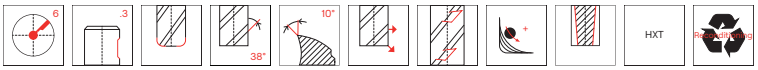
Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Weldon – Rază la vârf





D

– Toleranţe:
– DMM= h5
– DC e7
– RE= ±0,02 mm
– Reascuţire posibilă



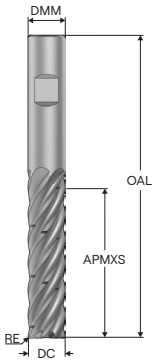
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720080D2R050.3Z6C-HXT	10228520	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Weldon	□
JS720080D2R100.3Z6C-HXT	10228521	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Weldon	□
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Weldon	□
JS720100D2R100.3Z6C-HXT	10228522	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Weldon	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Weldon	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Weldon	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Weldon	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Weldon	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Weldon	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Weldon	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Weldon	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Weldon	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Weldon	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Weldon	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Weldon	■

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS720

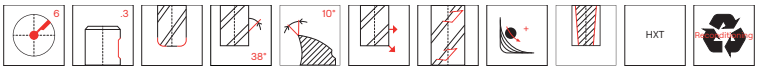
Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Weldon – Rază la vârf





D

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



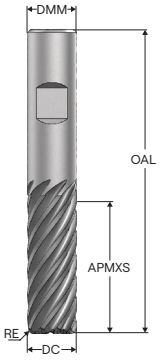
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720160D3R050.3Z6C-HXT	10228523	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6C-HXT	10228524	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6C-HXT	10228525	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6C-HXT	10228526	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Weldon	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Weldon	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Weldon	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Weldon	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Weldon	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Weldon	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Weldon	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Weldon	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Weldon	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Weldon	■

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

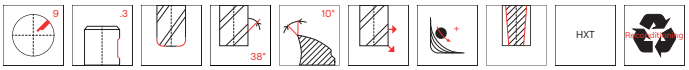
JS720

Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Weldon – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

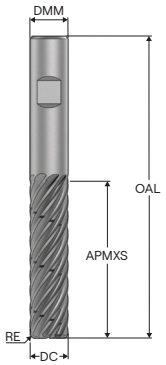
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	Weldon	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	Weldon	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	Weldon	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	Weldon	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	Weldon	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	Weldon	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	Weldon	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	Weldon	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	Weldon	☐
JS720200D2R100.3Z9-HXT	10228396	2	D	20,0	20,0	45,0	105,0	1,0	9	Weldon	☐
JS720200D2R200.3Z9-HXT	10228397	2	D	20,0	20,0	45,0	105,0	2,0	9	Weldon	☐
JS720200D2R300.3Z9-HXT	10228398	2	D	20,0	20,0	45,0	105,0	3,0	9	Weldon	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	Weldon	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	Weldon	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	Weldon	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	Weldon	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	Weldon	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	Weldon	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	Weldon	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	Weldon	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	Weldon	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	Weldon	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	Weldon	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	Weldon	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	Weldon	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	Weldon	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	Weldon	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	Weldon	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	Weldon	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

JS720

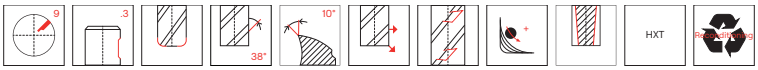
Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Weldon – Rază la vârf





D

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



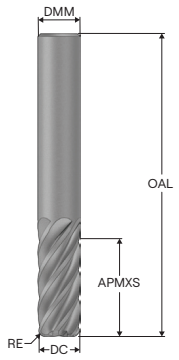
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Weldon	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Weldon	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Weldon	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Weldon	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Weldon	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Weldon	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Weldon	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Weldon	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Weldon	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Weldon	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Weldon	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Weldon	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Weldon	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Weldon	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

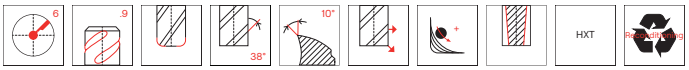
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Safelock – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

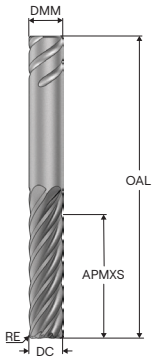
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	Safe-lock	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	Safe-lock	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	Safe-lock	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	Safe-lock	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	☐
JS720200D2R050.9Z6-HXT	10228464	2	D	20,0	20,0	45,0	105,0	0,5	6	Safe-lock	☐
JS720200D2R100.9Z6-HXT	10228465	2	D	20,0	20,0	45,0	105,0	1,0	6	Safe-lock	☐
JS720200D2R200.9Z6-HXT	10228467	2	D	20,0	20,0	45,0	105,0	2,0	6	Safe-lock	☐
JS720200D2R300.9Z6-HXT	10228468	2	D	20,0	20,0	45,0	105,0	3,0	6	Safe-lock	☐
JS720250D2R050.9Z6-HXT	10228469	2	D	25,0	25,0	50,0	125,0	0,5	6	Safe-lock	☐
JS720250D2R100.9Z6-HXT	10228470	2	D	25,0	25,0	50,0	125,0	1,0	6	Safe-lock	☐
JS720250D2R200.9Z6-HXT	10228471	2	D	25,0	25,0	50,0	125,0	2,0	6	Safe-lock	☐
JS720250D2R300.9Z6-HXT	10228472	2	D	25,0	25,0	50,0	125,0	3,0	6	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

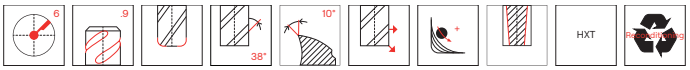
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Safelock – Rază la vârf





D



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

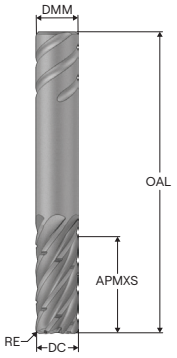
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720080D3R050.9Z6-HXT	10228473	3	D	8,0	8,0	32,0	80,0	0,5	6	Safe-lock	☐
JS720080D3R100.9Z6-HXT	10228474	3	D	8,0	8,0	32,0	80,0	1,0	6	Safe-lock	☐
JS720100D3R050.9Z6-HXT	10228475	3	D	10,0	10,0	40,0	89,0	0,5	6	Safe-lock	☐
JS720100D3R100.9Z6-HXT	10228476	3	D	10,0	10,0	40,0	89,0	1,0	6	Safe-lock	☐
JS720100D3R200.9Z6-HXT	10228477	3	D	10,0	10,0	40,0	89,0	2,0	6	Safe-lock	☐
JS720120D3R050.9Z6-HXT	10228478	3	D	12,0	12,0	45,0	100,0	0,5	6	Safe-lock	☐
JS720120D3R100.9Z6-HXT	10228479	3	D	12,0	12,0	45,0	100,0	1,0	6	Safe-lock	☐
JS720120D3R200.9Z6-HXT	10228480	3	D	12,0	12,0	45,0	100,0	2,0	6	Safe-lock	☐
JS720160D3R050.9Z6-HXT	10228481	3	D	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	☐
JS720160D3R100.9Z6-HXT	10228482	3	D	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	☐
JS720160D3R200.9Z6-HXT	10228483	3	D	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	☐
JS720160D3R300.9Z6-HXT	10228484	3	D	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

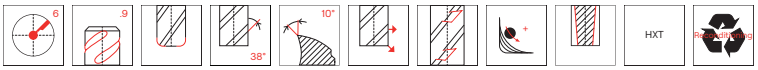
JS720

Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Safelock – Rază la vârf





D



– Toleranţe:
– DMM= h5
– DC e7
– RE= ±0,02 mm
– Reascuţire posibilă

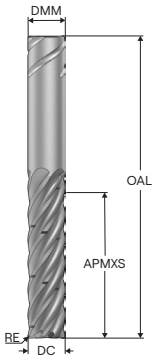
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720080D2R050.9Z6C-HXT	10228527	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	□
JS720080D2R100.9Z6C-HXT	10228528	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	□
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	□
JS720100D2R100.9Z6C-HXT	10228529	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Safe-lock	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Safe-lock	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	■
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Safe-lock	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	Safe-lock	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile. ■ **Stoc standard.**

JS720

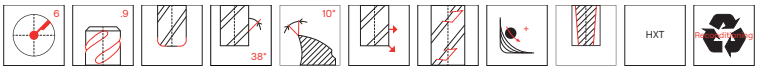
Înaltă performanţă – Titan – Pătrat – 6 Caneluri – Safelock – Rază la vârf





D

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



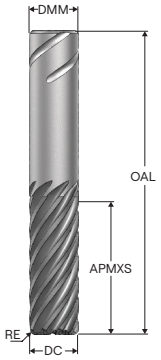
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720160D3R050.9Z6C-HXT	10228530	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	□
JS720160D3R100.9Z6C-HXT	10228531	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	□
JS720160D3R200.9Z6C-HXT	10228532	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	□
JS720160D3R300.9Z6C-HXT	10228533	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	□
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	□
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	□
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	□
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Safe-lock	□
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	□
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	Safe-lock	□
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	□
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	□
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	□
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	□
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	□
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	□
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	□
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	□
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.

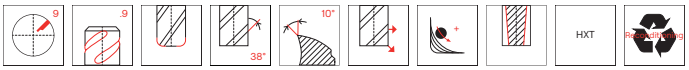
JS720

Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Safelock – Rază la vârf





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Reascuţire posibilă

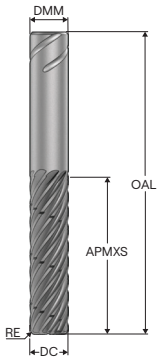
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	Safe-lock	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	Safe-lock	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	Safe-lock	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	Safe-lock	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	Safe-lock	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	Safe-lock	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	Safe-lock	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	Safe-lock	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	Safe-lock	☐
JS720200D2R100.9Z9-HXT	10228399	2	D	20,0	20,0	45,0	105,0	1,0	9	Safe-lock	☐
JS720200D2R200.9Z9-HXT	10228400	2	D	20,0	20,0	45,0	105,0	2,0	9	Safe-lock	☐
JS720200D2R300.9Z9-HXT	10228401	2	D	20,0	20,0	45,0	105,0	3,0	9	Safe-lock	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	Safe-lock	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	Safe-lock	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	Safe-lock	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

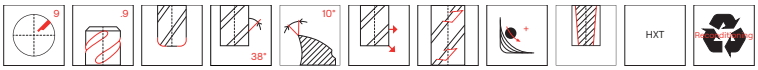
JS720

Înaltă performanţă – Titan – Pătrat – 9 Caneluri – Safelock – Rază la vârf





—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	□
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	□
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	□
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	□
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	□
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	□
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	□
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	□
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	□
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	□
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	□
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	□
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	□
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	□
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.

Parametri de așchiere – JS720 Frezare laterală PCEDC =6

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	110 (85 — 140) *360 (280 — 450)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	90 (70 — 110) *295 (230 — 360)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	70 (55 — 99) *230 (190 — 320)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	65 (50 — 83) *215 (170 — 270)*
S1	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	43 (29 — 71) *140 (96 — 230)*
S2	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.0500 *0,0500*	2.6 *2,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	105 (78 — 120) *345 (260 — 390)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*

Parametri de așchiere – JS720 Frezare laterală degroșare avansată a_e/DC=0,07

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	140 (110 — 180) *460 (370 — 590)*
M2	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	115 (91 — 150) *375 (300 — 490)*
M3	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	90 (72 — 120) *295 (240 — 390)*
M4	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
M5	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	85 (65 — 100) *280 (220 — 320)*
S1	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	41 (28 — 68) *135 (92 — 220)*
S2	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	33 (22 — 54) *110 (73 — 170)*
S3	E	2.6 *2,6*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	29 (20 — 47) *95 (66 — 150)*
S11	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	135 (110 — 160) *445 (370 — 520)*
S12	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
S13	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JS720 Frezare laterală degroșare avansată a_e/DC=0,07

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
M1	E	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98 — 160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82 — 130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64 — 110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S1	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	37 (25 — 61) *120 (83 — 200)*
S2	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	30 (20 — 49) *100 (66 — 160)*
S3	E	2.8 *2,8*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	26 (18 — 43) *85 (60 — 140)*
S11	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91 — 150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*

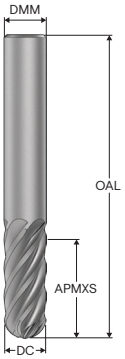
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

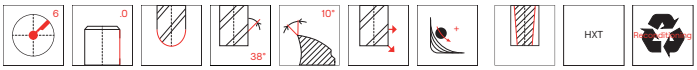
JS730

Înaltă performanţă – Titan – Cap sferic – 6 Caneluri – Cilindrică





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Două caneluri către centru
- Reascuţire posibilă

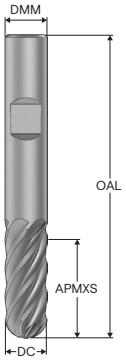
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	3,0	6	Cylindrical	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	4,0	6	Cylindrical	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	5,0	6	Cylindrical	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6,0	6	Cylindrical	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	8,0	6	Cylindrical	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	10,0	6	Cylindrical	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	12,5	6	Cylindrical	■

■ **Stoc standard.**

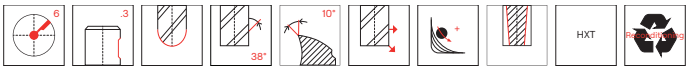
JS730

Înaltă performanţă – Titan – Cap sferic – 6 Caneluri – Weldon





D



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Două caneluri către centru
—Reascuţire posibilă

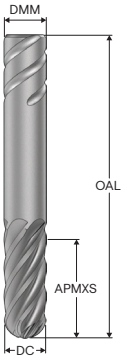
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	3,0	6	Weldon	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	4,0	6	Weldon	■
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	5,0	6	Weldon	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6,0	6	Weldon	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	8,0	6	Weldon	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	10,0	6	Weldon	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	12,5	6	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

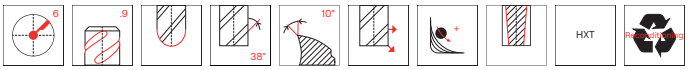
JS730

Înaltă performanţă – Titan – Cap sferic 6 Caneluri – Safelock





D



- Toleranţe:
- DMM= h5
- DC e7
- RE= ±0,02 mm
- Două caneluri către centru
- Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	3,0	6	Safe-lock	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	4,0	6	Safe-lock	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	5,0	6	Safe-lock	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6,0	6	Safe-lock	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	8,0	6	Safe-lock	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	10,0	6	Safe-lock	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	12,5	6	Safe-lock	☐

☐ Safelock disponibil. Intervalul de livrare este de 6 zile.

Parametri de așchiere – JS730 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	140 (89 — 150) *460 (300 — 490)*
M2	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (70 — 120) *360 (230 — 390)*
M3	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	85 (55 — 99) *280 (190 — 320)*
M4	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (57 — 100) *295 (190 — 320)*
M5	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (47 — 85) *245 (160 — 270)*
S1	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	43 (29 — 70) *140 (96 — 220)*
S2	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	130 (79 — 130) *425 (260 — 420)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (61 — 100) *330 (210 — 320)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	100 (62 — 100) *330 (210 — 320)*

Parametri de așchiere – JS730 Frezare laterală degroșare avansată a_e/DC=0,07

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (93 — 150) *475 (310 — 490)*
M2	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	125 (78 — 130) *410 (260 — 420)*
M3	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	90 (58 — 100) *295 (200 — 320)*
M4	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	95 (59 — 100) *310 (200 — 320)*
M5	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	80 (50 — 89) *260 (170 — 290)*
S1	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	47 (32 — 79) *155 (110 — 250)*
S2	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	38 (26 — 63) *125 (86 — 200)*
S3	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	33 (23 — 55) *110 (76 — 180)*
S11	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (94 — 150) *490 (310 — 490)*
S12	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	115 (72 — 110) *375 (240 — 360)*
S13	E	1.9 *1,9*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	120 (74 — 120) *395 (250 — 390)*

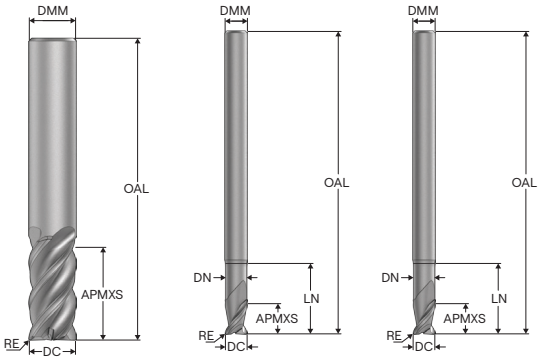
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

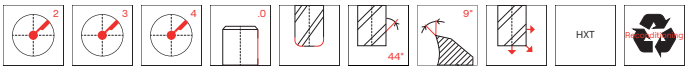
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP751

Înaltă performanţă – Titan – Pătrat – 2-4 Caneluri – Cilindrică – Rază la vârf







– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,02 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

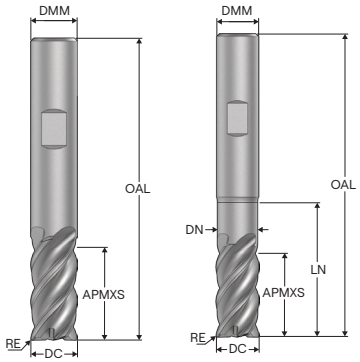
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.0Z4	HXT	10105487	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R040.0Z4	HXT	10105548	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R150.0Z4	HXT	10105549	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Cylindrical	■
JHP751120D1R040.0Z4	HXT	10105550	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Cylindrical	■
JHP751120D1R150.0Z4	HXT	10105552	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Cylindrical	■
JHP751160D1R040.0Z4	HXT	10105581	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Cylindrical	■
JHP751160D1R150.0Z4	HXT	10105582	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Cylindrical	■
JHP751200D1R080.0Z4	HXT	10105583	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Cylindrical	■
JHP751020G2R020.0Z2	HXT	10105584	2	G	2,0	3,0	3,0	38,0	6,0	1,9	0,2	2	Cylindrical	■
JHP751030G2R020.0Z2	HXT	10105585	2	E	3,0	3,0	4,5	38,0	9,0	2,8	0,2	2	Cylindrical	■
JHP751040G2R020.0Z2	HXT	10105586	2	G	4,0	6,0	6,0	50,0	9,0	3,7	0,2	2	Cylindrical	■
JHP751050G2R030.0Z2	HXT	10105587	2	G	5,0	6,0	7,5	50,0	9,0	4,6	0,3	2	Cylindrical	■
JHP751060E2R030.0Z3	HXT	10105588	2	E	6,0	6,0	9,0	57,0	19,0	5,6	0,3	3	Cylindrical	■
JHP751080E2R040.0Z4	HXT	10105589	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Cylindrical	■
JHP751100E2R040.0Z4	HXT	10105590	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Cylindrical	■
JHP751100E2R080.0Z4	HXT	10105591	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Cylindrical	■
JHP751100E2R200.0Z4	HXT	10105593	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Cylindrical	■
JHP751120E2R040.0Z4	HXT	10105594	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Cylindrical	■
JHP751120E2R080.0Z4	HXT	10105595	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Cylindrical	■
JHP751120E2R310.0Z4	HXT	10105596	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Cylindrical	■
JHP751140E2R080.0Z4	HXT	10105597	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Cylindrical	■
JHP751160E2R040.0Z4	HXT	10105598	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Cylindrical	■
JHP751160E2R080.0Z4	HXT	10105599	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Cylindrical	■
JHP751160E2R200.0Z4	HXT	10105600	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Cylindrical	■
JHP751200E2R080.0Z4	HXT	10105601	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Cylindrical	■

■ **Stoc standard.**

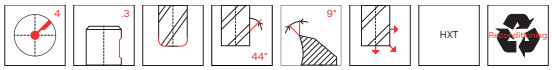
JHP751

Înaltă performanţă – Titan – Pătrat – 2-4 Caneluri – Weldon – Rază la vârf





D E



—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.3Z4	HXT	10105739	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Weldon	■
JHP751100D1R040.3Z4	HXT	10105740	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Weldon	■
JHP751100D1R150.3Z4	HXT	10105742	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Weldon	■
JHP751120D1R040.3Z4	HXT	10105743	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Weldon	■
JHP751120D1R150.3Z4	HXT	10105744	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Weldon	■
JHP751160D1R040.3Z4	HXT	10105745	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Weldon	■
JHP751160D1R150.3Z4	HXT	10105746	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Weldon	■
JHP751200D1R080.3Z4	HXT	10105747	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Weldon	■
JHP751080E2R040.3Z4	HXT	10105748	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Weldon	■
JHP751100E2R040.3Z4	HXT	10105749	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Weldon	■
JHP751100E2R080.3Z4	HXT	10105750	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Weldon	■
JHP751100E2R200.3Z4	HXT	10105751	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Weldon	■
JHP751120E2R040.3Z4	HXT	10105752	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Weldon	■
JHP751120E2R080.3Z4	HXT	10105753	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Weldon	■
JHP751120E2R310.3Z4	HXT	10105754	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Weldon	■
JHP751140E2R080.3Z4	HXT	10105755	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Weldon	■
JHP751160E2R040.3Z4	HXT	10105756	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Weldon	■
JHP751160E2R080.3Z4	HXT	10105757	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Weldon	■
JHP751160E2R200.3Z4	HXT	10105758	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Weldon	■
JHP751200E2R080.3Z4	HXT	10105759	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – JHP751 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	48 (33 — 64) *155 (110 — 200)*
S2	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	39 (26 — 51) *130 (86 — 160)*
S3	E/M/A	0.0400 *0,0400*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	33 (26 — 50) *110 (86 — 160)*
S11	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	145 (130 — 180) *475 (430 — 590)*
S12	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	110 (95 — 140) *360 (320 — 450)*
S13	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	90 (76 — 110) *295 (250 — 360)*

Parametri de așchiere – JHP751 Frezare de canal

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66 — 120)*
S2	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	24 (17 — 32) *80 (56 — 100)*
S3	E/M/A	0.34 *0,34*	0.0046 *0,00018*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.034 *0,0013*	0.040 *0,0016*	20 (15 — 29) *65 (50 — 95)*
S11	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	90 (78 — 110) *295 (260 — 360)*
S12	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (60 — 89) *230 (200 — 290)*
S13	E/M/A	0.70 *0,70*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	55 (48 — 71) *180 (160 — 230)*

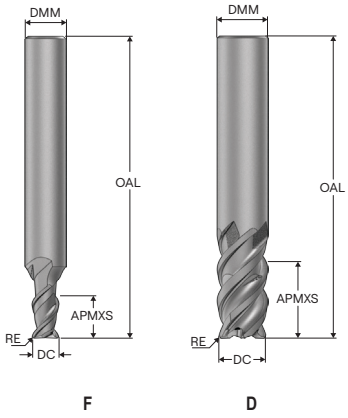
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

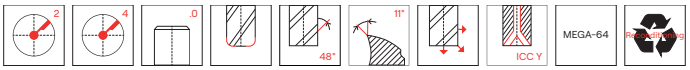
JHP760

Înaltă performanţă – ISO-M – Pătrat – 2-4 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



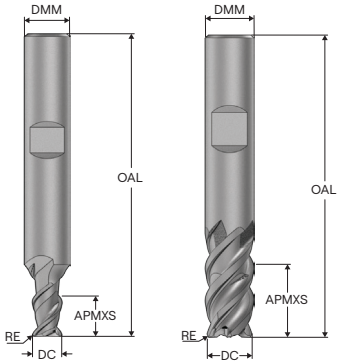
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Cylindrical	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Cylindrical	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Cylindrical	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Cylindrical	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Cylindrical	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Cylindrical	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Cylindrical	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Cylindrical	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Cylindrical	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Cylindrical	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Cylindrical	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Cylindrical	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Cylindrical	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Cylindrical	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	Cylindrical	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Cylindrical	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Cylindrical	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	Cylindrical	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	Cylindrical	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	Cylindrical	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	Cylindrical	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	Cylindrical	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	Cylindrical	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	Cylindrical	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	Cylindrical	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	Cylindrical	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	Cylindrical	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	Cylindrical	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	Cylindrical	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	Cylindrical	■

■ **Stoc standard.**

JHP760

Înaltă performanţă – ISO-M – Pătrat – 2-4 Caneluri – Weldon – Rază la vârf





F D

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,03 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

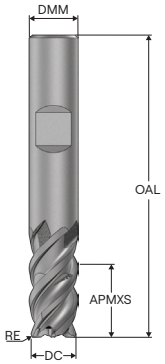
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Weldon	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Weldon	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Weldon	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Weldon	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Weldon	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Weldon	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Weldon	■
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Weldon	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Weldon	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Weldon	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Weldon	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Weldon	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Weldon	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Weldon	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	Weldon	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	Weldon	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	Weldon	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	Weldon	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	Weldon	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Weldon	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

JHP760

Înaltă performanţă – ISO-M – Pătrat – 2-4 Caneluri – Weldon – Rază la vârf





D

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,03 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	Weldon	□
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	Weldon	□
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	Weldon	□
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	Weldon	□
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	Weldon	□
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	Weldon	□
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	Weldon	□
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	Weldon	□
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	Weldon	□
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	Weldon	□
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – JHP760 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z									v_c
				4	5	6	8	10	12	16	20	25	
M1	E	0.300 *0,300*	1.5 *1,5*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (97 — 130) *395 (320 — 420)*
M2	E	0.300 *0,300*	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	100 (81 — 110) *330 (270 — 360)*
M3	E	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (58 — 91) *245 (200 — 290)*
M4	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	60 (45 — 70) *195 (150 — 220)*
M5	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	48 (37 — 59) *155 (130 — 190)*

Parametri de așchiere – JHP760 Frezare de canal

SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92 — 130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (74 — 100) *295 (250 — 320)*
M3	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	70 (54 — 85) *230 (180 — 270)*
M4	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	50 (40 — 63) *165 (140 — 200)*
M5	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	43 (34 — 53) *140 (120 — 170)*

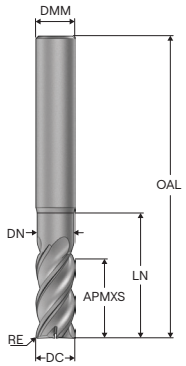
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Cilindrică – Rază la vârf





E

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



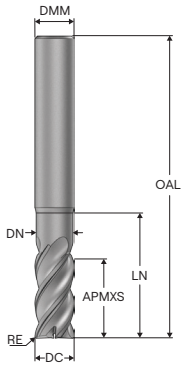
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Cylindrical	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Cylindrical	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Cylindrical	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Cylindrical	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Cylindrical	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Cylindrical	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Cylindrical	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Cylindrical	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Cylindrical	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Cylindrical	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Cylindrical	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Cylindrical	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Cylindrical	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Cylindrical	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■

■ **Stoc standard.**
Observaţie: dacă raza la vârf este >15% din DC → a_p=–30%, f_z= -20%

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Cilindrică – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

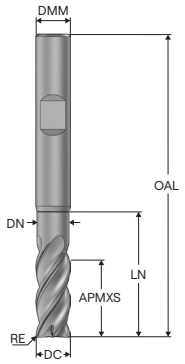
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Cylindrical	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Cylindrical	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Cylindrical	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Cylindrical	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Cylindrical	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Cylindrical	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Cylindrical	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Cylindrical	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Cylindrical	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Cylindrical	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Cylindrical	■

■ **Stoc standard.**
Observaţie: dacă raza la vârf este >15% din DC → a_p= -30%, f_z= -20%

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Weldon – Rază la vârf





E

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



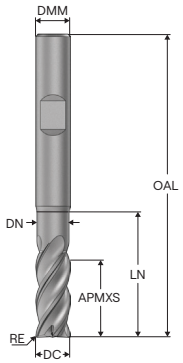
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Weldon	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Weldon	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Weldon	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Weldon	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Weldon	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Weldon	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Weldon	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Weldon	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Weldon	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Weldon	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Weldon	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Weldon	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Weldon	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Weldon	□

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.
Observaţie: dacă raza la vârf este >15% din DC → a_p=–30%, f_z=–20%
ICC = Canal de agent de răcire complet

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Weldon – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

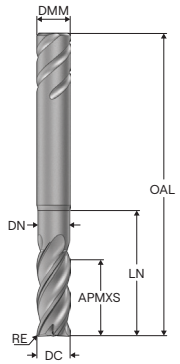
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Weldon	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Weldon	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Weldon	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Weldon	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Weldon	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Weldon	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Weldon	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Weldon	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Weldon	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Weldon	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Weldon	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.
Observaţie: dacă raza la vârf este >15% din DC → a_p=-30%, f_z=-20%
ICC = Canal de agent de răcire complet

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Safelock – Rază la vârf





E

—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă



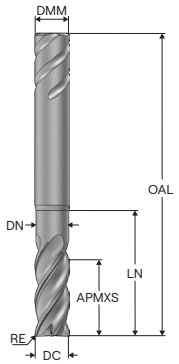
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	Safe-lock	□
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	Safe-lock	□
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	Safe-lock	□
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	Safe-lock	□
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	Safe-lock	□
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	Safe-lock	□
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	Safe-lock	□
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	Safe-lock	□
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	Safe-lock	□
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	Safe-lock	□
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	Safe-lock	□
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	Safe-lock	□
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	Safe-lock	□
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	Safe-lock	□
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	Safe-lock	□
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	Safe-lock	□
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	Safe-lock	□
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	Safe-lock	□
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	Safe-lock	□
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	Safe-lock	□
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	Safe-lock	□
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.
Observaţie: dacă raza la vârf este >15% din DC → a_p=–30%, f_z=–20%

JHP770

Înaltă performanţă – Titan – Pătrat – 4-5 Caneluri – Safelock – Rază la vârf





E



—Toleranţe:
—DMM= h5
—DC e7
—RE= ±0,02 mm
—Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.9Z5A-SIRA	02927949	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	5	Safe-lock	□
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	Safe-lock	□
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	Safe-lock	□
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	Safe-lock	□
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	Safe-lock	□
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	Safe-lock	□
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	Safe-lock	□
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	Safe-lock	□
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	Safe-lock	□
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	Safe-lock	□

□ Safelock disponibil. Intervalul de livrare este de 6 zile.
Observaţie: dacă raza la vârf este >15% din DC → a_p=-30%, f_z=-20%

Parametri de așchiere – JHP770 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S11	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
S12	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	90 (80 — 100) *295 (270 — 320)*
S13	E	0.400 *0,400*	1.8 *1,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (64 — 81) *245 (210 — 260)*

Parametri de așchiere – JHP770 Canelare

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94 — 120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (72 — 92) *260 (240 — 300)*
S13	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*

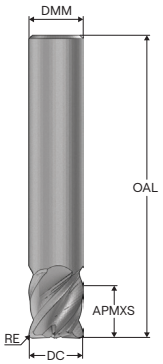
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP780

Înaltă performanţă – Superaliaj – Pătrat – 4-Caneluri – Cilindrică – Rază la vârf





D



- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă

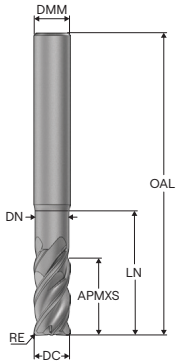
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Cylindrical	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Cylindrical	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Cylindrical	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Cylindrical	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	Cylindrical	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	Cylindrical	■

■ **Stoc standard.**

JHP780

Înaltă performanţă – Superaliaj – Pătrat – 4-Caneluri – Cilindrică – Rază la vârf





E



- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă

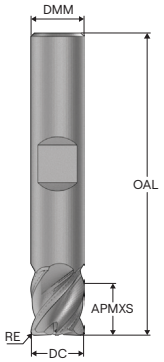
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Cylindrical	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Cylindrical	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Cylindrical	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Cylindrical	■

■ **Stoc standard.**

JHP780

Înaltă performanţă – Superaliaj – Pătrat – 4-Caneluri – Weldon – Rază la vârf





D



- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă

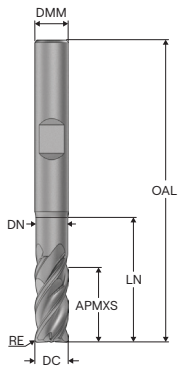
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Weldon	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Weldon	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Weldon	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Weldon	■

■ **Stoc standard.**

JHP780

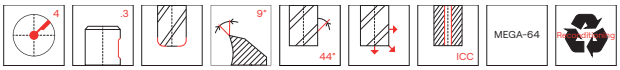
Înaltă performanţă – Superaliaj – Pătrat – 4-Caneluri – Weldon – Rază la vârf





E

—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP780060E2R030.3Z4-M64	02760878	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Weldon	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Weldon	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Weldon	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Weldon	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Weldon	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	Weldon	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – JHP780 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S1	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	50 (45 — 59) *165 (150 — 190)*
S2	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	42 (36 — 47) *140 (120 — 150)*
S3	E	0.300 *0,300*	0.80 *0,80*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	28 (23 — 33) *90 (76 — 100)*

Parametri de așchiere – JHP780 Frezare de canal

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130 — 160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	35 (30 — 40) *115 (99 — 130)*
S3	E	0.60 *0,60*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	26 (21 — 30) *85 (69 — 98)*

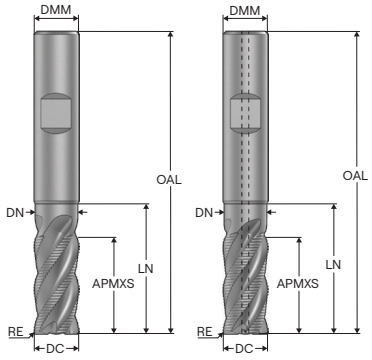
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP794

Înaltă performanţă – ISO-M – Pătrat – 4 Caneluri – Weldon – Rază la vârf





—Toleranţe:
—DMM= h6
—DC= h12
—RE= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø8



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm			
JHP794060E2R020.3Z4	TAN	10072338	2	E	■	–	6,0	6,0	13,0	57,0	18,5	2,0	0,2	4	Weldon	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	■	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	■	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	■	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	Weldon	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	Weldon	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	■	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	■	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	Weldon	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	■	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	Weldon	■

■ Stoc standard.

Parametri de așchiere – JHP794 Frezare laterală

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.3 *1,3*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 120) *295 (210 — 390)*
M2	E	1.3 *1,3*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M3	E	1.3 *1,3*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	60 (40 — 78) *195 (140 — 250)*
M4	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	45 (31 — 60) *150 (110 — 190)*
M5	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	38 (26 — 50) *125 (86 — 160)*

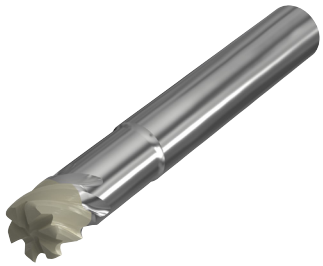
Parametri de așchiere – JHP794 Frezare de canal

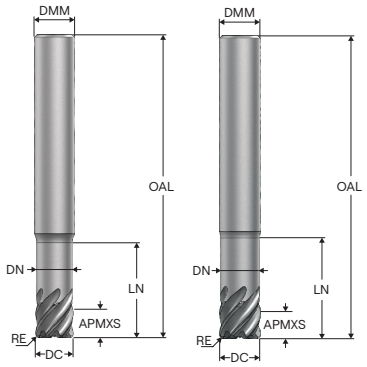
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	60 (40 — 79) *195 (140 — 250)*
M3	E	0.60 *0,60*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	47 (32 — 62) *155 (110 — 200)*
M4	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	36 (24 — 47) *120 (79 — 150)*
M5	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	30 (20 — 39) *100 (66 — 120)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

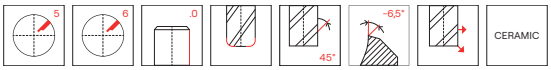
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JCG790
Înaltă performanţă – Pătrat – Superaliaj – 5-6 Caneluri – Cilindrică – Rază la vârf





G E



—Toleranţe:
—DMM= h5
—DC -0,02/-0,1 mm
—RE= ±0,05 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	15,0	5,7	0,5	5	Cylindrical	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	20,0	7,6	0,5	5	Cylindrical	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	23,5	9,0	1,0	6	Cylindrical	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	25,0	9,5	1,0	6	Cylindrical	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	28,5	10,9	1,5	6	Cylindrical	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	30,0	11,4	1,5	6	Cylindrical	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	40,0	15,2	2,0	6	Cylindrical	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	50,0	19,0	3,0	6	Cylindrical	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	50,0	23,8	4,0	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JCG790 Degroșare prin frezare laterală

SMG		a_e/DC	APMXS	f_z							v_c
				6	8	10	12	16	20	25	
S1	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Parametri de așchiere – JCG790 Frezare de canal

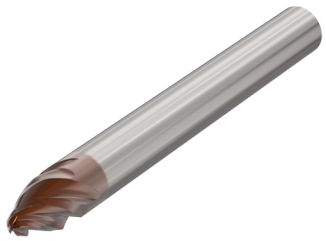
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

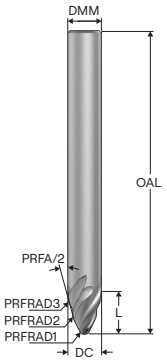
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH724

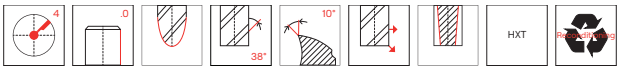
Viteză mare – ISO– M și ISO– S – Formă conică – 4 Caneluri – Cilindrică





T

—Toleranţe:
—DMM=h5
—PRFRAD1= ±0.03 mm
—Toleranţă formare PRFRAD2= 0.02 mm
—Reascuţire posibilă dacă PRFRAD este ≥ 1,5



Reper Nr.	Calitate	Număr reper	Indice lun-gime	Profilul sculei	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm	mm					
	HXT	10106106	2	T	10,0	10,0	12,3	12,3	89,0	2,0	30,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106107	2	T	10,0	10,0	12,5	12,5	89,0	2,0	50,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106108	2	T	10,0	10,0	10,7	10,7	89,0	3,0	100,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106109	2	T	10,0	10,0	10,8	10,8	89,0	3,0	250,0	5,0	20,0	4	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH724 Finisare frezare prin copiere

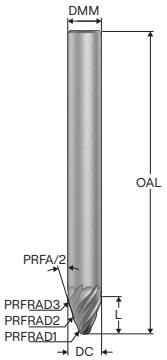
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH726

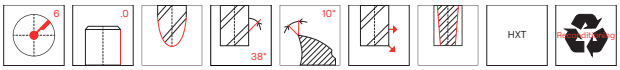
Viteză mare – ISO– M și ISO– S – Formă conică – 6 Caneluri – Cilindrică





T

—Toleranţe:
—DMM=h5
—PRFRAD1= ±0.03 mm
—Toleranţă formare PRFRAD2= 0.02 mm
—Reascuţire posibilă dacă PRFRAD este ≥ 1,5



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm	mm				
JH726100T2R2R030.0Z6	HXT	10106110	2	T	10,0	10,0	10,8	10,8	89,0	2,0	30,0	5,0	20,0	6	Cylindrical	■
JH726100T2R2R050.0Z6	HXT	10106111	2	T	10,0	10,0	10,7	10,7	89,0	2,0	50,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R100.0Z6	HXT	10106112	2	T	10,0	10,0	12,3	12,3	89,0	3,0	100,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R250.0Z6	HXT	10106113	2	T	10,0	10,0	12,5	12,5	89,0	3,0	250,0	5,0	20,0	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH726 Finisare frezare prin copiere

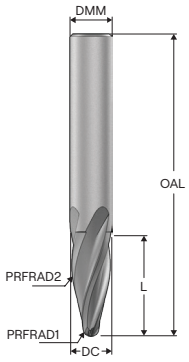
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

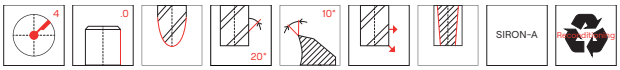
JH734

Viteză mare – ISO– M și ISO– S – Formă de picătură – 4 Caneluri – Cilindrică





X



—Toleranţe:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	18,39	62,0	1,0	95,0	4	Cylindrical	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	22,05	68,0	1,0	90,0	4	Cylindrical	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	4	Cylindrical	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	4	Cylindrical	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH734 Finisare frezare prin copiere

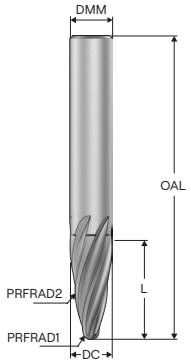
SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P8	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH736

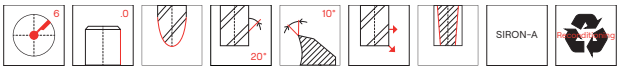
Viteză mare – ISO– M și ISO– S – Formă de picătură – 6 Caneluri – Cilindrică





X

—Toleranţe:
—DMM= h5
—PRFRAD1= ±0.03mm
—Toleranţă formare PRFRAD2= 0.02mm
—Reascuţire posibilă



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	6	Cylindrical	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	6	Cylindrical	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH736 Finisare frezare prin copiere

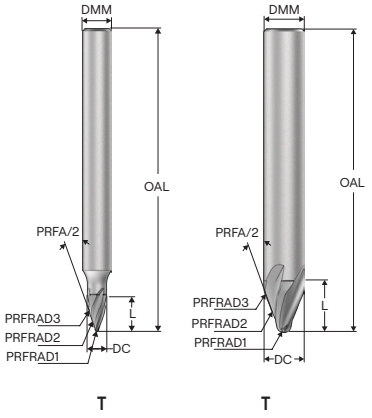
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

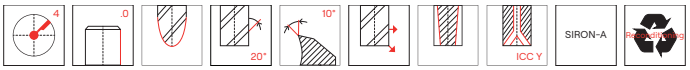
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH744

Viteză mare – ISO– M și ISO– S – Formă conică – 4 Caneluri – Cilindrică







—Toleranţe:
—DMM= h5
—PRFRAD1= ±0.03mm
—Toleranţă formare PRFRAD2= 0.02mm
—Reascuţire posibilă dacă PRFRAD1 este ≥ 1,5

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm	mm				
	SIRA	10044920	1	T	–	10,0	10,0	5,4	1,62	72,0	1,5	250,0	2,0	65,0	4	Cylindrical	■
	SIRA	10044921	1	T	–	12,0	12,0	10,5	5,33	89,0	3,0	250,0	6,0	32,5	4	Cylindrical	■
	SIRA	10044922	1	T	–	16,0	16,0	14,6	8,95	108,0	4,0	500,0	8,0	27,5	4	Cylindrical	■
	SIRA	10044923	2	T	–	4,0	6,0	7,6	4,7	62,0	0,5	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044924	2	T	–	6,0	6,0	9,6	6,71	62,0	1,0	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044925	2	T	–	8,0	8,0	10,7	7,42	68,0	1,5	250,0	4,0	20,0	4	Cylindrical	■
	SIRA	10044926	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	4	Cylindrical	■
	SIRA	10044927	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	4	Cylindrical	■
	SIRA	10044928	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	4	Cylindrical	■
	SIRA	10044929	2	T	–	16,0	16,0	31,3	28,27	108,0	2,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044930	2	T	–	16,0	16,0	24,1	21,02	108,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044931	4	T	■	16,0	16,0	24,1	21,02	150,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■

Parametri de așchiere – JH744 Finisare frezare prin copiere

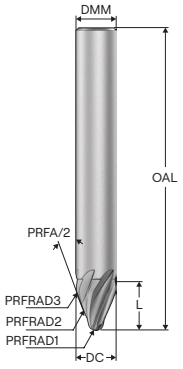
SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P8	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH746

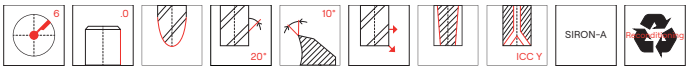
Viteză mare – ISO– M și ISO– S – Formă conică – 6 Caneluri – Cilindrică





T

—Toleranţe:
—DMM= h5
—PRFRAD1= ±0.03mm
—Toleranţă formare PRFRAD2= 0.02mm
—Reascuţire posibilă



Reper Nr.	Calitate	Număr reper	Indice lun-gime	Profilul sculei	CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm	mm					
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	6	6	Cylindrical	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	6	6	Cylindrical	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■
	SIRA	10044961	4	T	■	16,0	16,0	17,6	12,94	150,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH746 Finisare frezare prin copiere

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JH746 Degroșare pentru frezare prin copiere

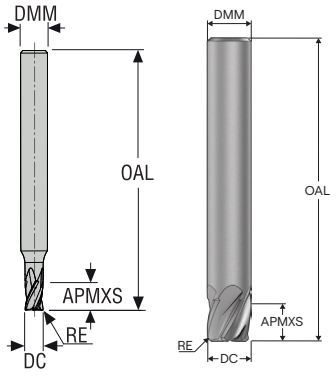
SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

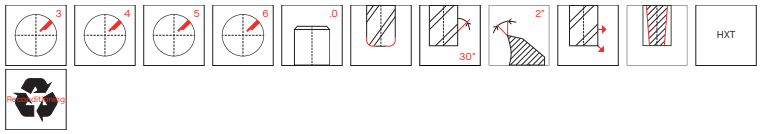
JH770

Viteză mare – CoCr / titan – Pătrat – 3-4-5-6 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	Cylindrical	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	Cylindrical	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	Cylindrical	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	Cylindrical	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	Cylindrical	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	Cylindrical	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH770 Degroșare prin frezare laterală PCEDC 3 și 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				3	4	6	8	
S2	E	0.750 *0,750*	0.12 *0,12*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	50 (42 — 62) *165 (140 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	65 (53 — 91) *215 (180 — 290)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	50 (41 — 70) *165 (140 — 220)*

Parametri de așchiere – JH770 Degroșare prin frezare laterală PCEDC 6

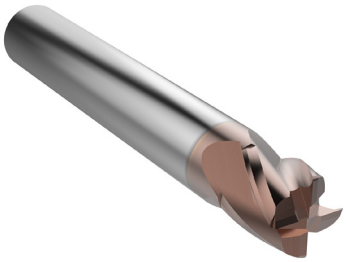
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42 — 71) *165 (140 — 230)*

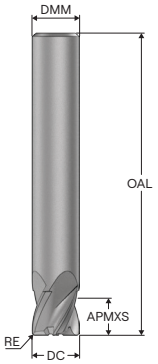
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH740

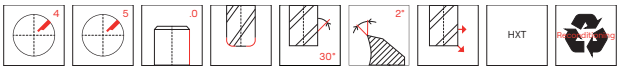
Viteză mare – CoCr / titan – Freză de finisare a părţii inferioare – 4-5 Caneluri – Cilindrică – Rază la vârf





D

—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	Cylindrical	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	Cylindrical	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	Cylindrical	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	Cylindrical	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	Cylindrical	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH740 Finisarea feţei PCEDC 4

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*
S11	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	65 (52 — 77) *215 (180 — 250)*
S12	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*

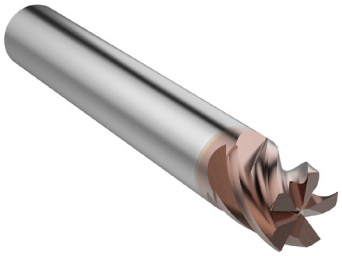
Parametri de așchiere – JH740 Finisarea feţei PCEDC 5

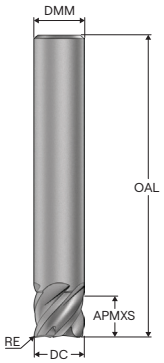
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51 — 75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH710

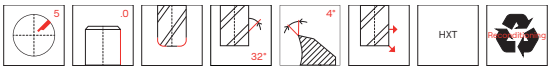
Viteză mare – CoCr / titan – Pătrat – 5 Caneluri – Cilindrică – Rază la vârf





D

- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	Cylindrical	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	Cylindrical	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	Cylindrical	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	Cylindrical	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	Cylindrical	■

■ **Stoc standard.**

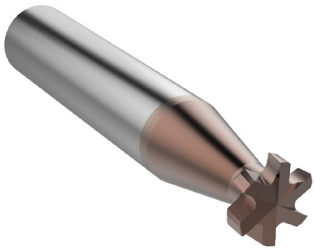
Parametri de așchiere – JH710 Finisare prin frezare laterală

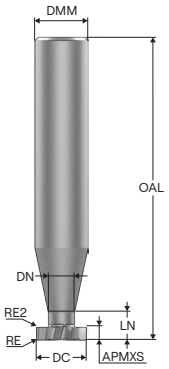
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S11	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.00800 *0,00800*	0.65 *0,65*	0.032 *0,0013*	0.040 *0,0016*	105 (92 — 120) *345 (310 — 390)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH790

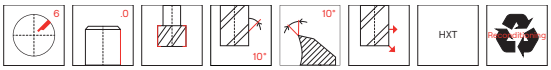
Viteză mare – CoCr / titan – Sculă aşchietoare în T – 6 Caneluri – Cilindrică





G

—Toleranţe:
—DMM=h5
—DC= ±0,02 mm
—RE= ±0,02 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm				
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■

■ **Stoc standard.**

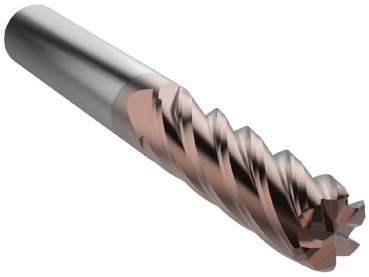
Parametri de așchiere – JH790 (T) Degroșare prin frezare laterală

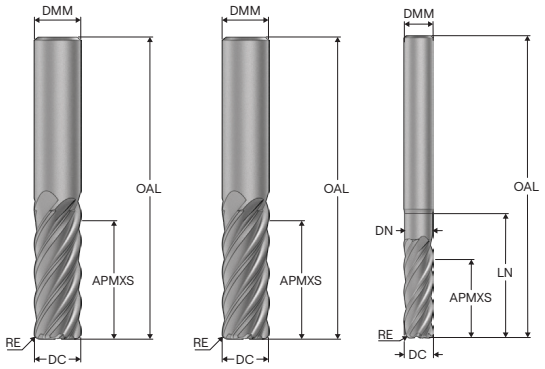
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110 — 160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66 — 100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

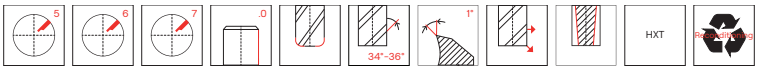
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH730

Viteză mare – CoCr / titan – Pătrat – 5-6-7 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JH730060E2R050.0Z5-HXT	10217826	2	E	6,0	6,0	19,0	65,0	25,0	5,7	0,5	5	Cylindrical	■
JH730060E2R100.0Z5-HXT	10217827	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,0	5	Cylindrical	■
JH730060E2R150.0Z5-HXT	10217828	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,5	5	Cylindrical	■
JH730075F2R050.0Z6-HXT	10217829	2	F	7,5	8,0	24,0	63,0	–	–	0,5	6	Cylindrical	■
JH730075F2R100.0Z6-HXT	10217830	2	F	7,5	8,0	24,0	63,0	–	–	1,0	6	Cylindrical	■
JH730075F2R150.0Z6-HXT	10217831	2	F	7,5	8,0	24,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	63,0	–	–	0,5	6	Cylindrical	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	63,0	–	–	1,0	6	Cylindrical	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	63,0	–	–	2,0	6	Cylindrical	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	72,0	–	–	1,0	7	Cylindrical	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	72,0	–	–	2,5	7	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH730 Finisare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	7.5	8	10	
S2	E	0,065 *0.065*	1,3 *1.3*	0,015 *0.00060*	0,019 *0.00075*	0,020 *0.00080*	0,025 *0.0010*	80 (63 — 94) *260 (210 — 300)*
S11	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	135 (110 — 160) *445 (370 — 520)*
S12	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	105 (84 — 120) *345 (280 — 390)*

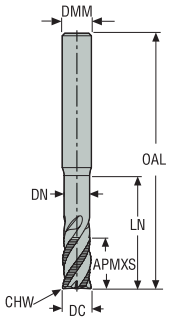
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHP994

Înaltă performanţă – CoCr / titan – Pătrat – 4 Caneluri – Cilindrică – Șanfren





E

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,1 mm
—CHW=0/-0,1 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JHP994060E3C.0Z4-HXT	03127382	3	E	■	6,0	6,0	14,0	63,0	24,0	5,6	0,2	4	Cylindrical	■
JHP994080E3C.0Z4-HXT	03127383	3	E	■	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	Cylindrical	■
JHP994100E3C.0Z4-HXT	03127384	3	E	■	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JHP994 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z			v_c
				6	8	10	
S2	E	0.0480 *0,0480*	2.0 *2,0*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	55 (40 — 69) *180 (140 — 220)*
S11	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (39 — 77) *165 (130 — 250)*
S12	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	40 (30 — 59) *130 (99 — 190)*

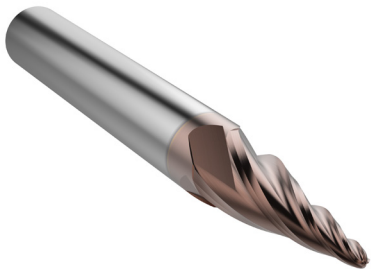
Parametri de așchiere – JHP994 Frezare de canal

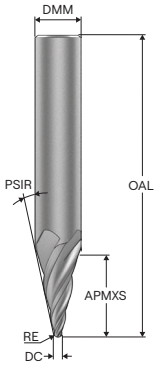
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79 — 130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83 — 150)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH780

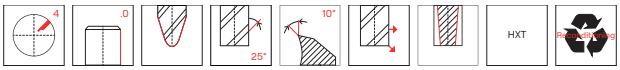
Viteză mare – CoCr / titan – Cap sferic conic – 4 Caneluri – Cilindrică





N

—Toleranţe:
—DMM=h5
—DC= ±0,04 mm
—RE= ±0,01 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	RE	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm				
JH780018N2R100.0Z4-HXT	03127386	2	N	8,0	1,827	8,0	23,5	63,0	1,0	5,1838	4	Cylindrical	■
JH780028N2R150.0Z4-HXT	03127387	2	N	8,0	2,803	8,0	23,5	63,0	1,5	3,8915	4	Cylindrical	■
JH780038N2R200.0Z4-HXT	03127388	2	N	8,0	3,823	8,0	23,5	63,0	2,0	2,5972	4	Cylindrical	■
JH780049N2R250.0Z4-HXT	03127389	2	N	8,0	4,888	8,0	23,5	63,0	2,5	1,3003	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH780 Frezare laterală

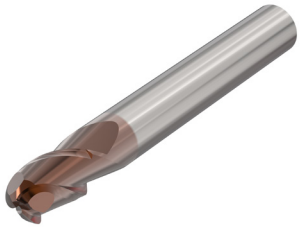
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76 — 110) *310 (250 — 360)*

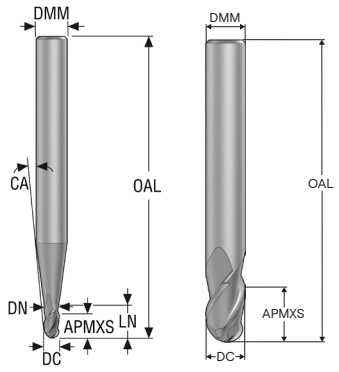
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHB720

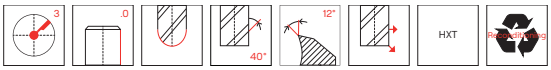
Viteză mare – Titan – Cap sferic – 3 Caneluri – Cilindrică





G D

– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	1,0	7,0	3	Cylindrical	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	1,5	5,0	3	Cylindrical	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	1,75	3,5	3	Cylindrical	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	2,0	3,0	3	Cylindrical	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	3,0	–	3	Cylindrical	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	3	Cylindrical	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	3	Cylindrical	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	3	Cylindrical	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	3	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JHB720 Frezare laterală

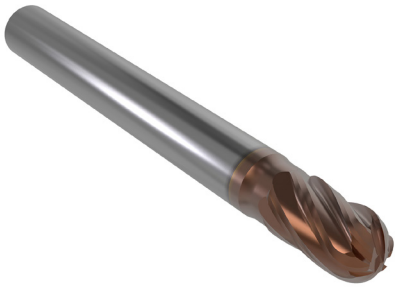
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62 — 110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	70 (51 — 90) *230 (170 — 290)*
M3	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	65 (46 — 84) *215 (160 — 270)*
M4	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	50 (35 — 65) *165 (120 — 210)*
M5	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	42 (29 — 54) *140 (96 — 170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	500 (400 — 600) *1650 (1400 — 1900)*
N3	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	335 (270 — 400) *1100 (890 — 1300)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96 — 180)*
S2	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79 — 150)*
S3	E	0.100 *0,100*	1.2 *1,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69 — 120)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.0085 *0,00034*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*

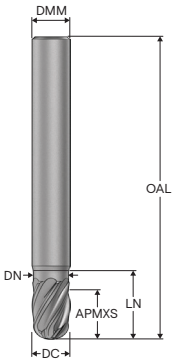
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH721

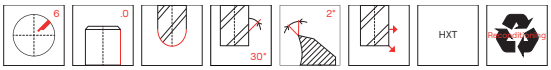
Viteză mare – CoCr / titan – Cap sferic – 6 Caneluri – Cilindrică





E

– Toleranţe:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	2,987	6	Cylindrical	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	3,98375	6	Cylindrical	■

■ **Stoc standard.**

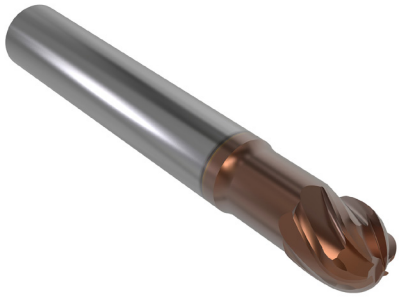
Parametri de așchiere – JH721 Finisare frezare prin copiere

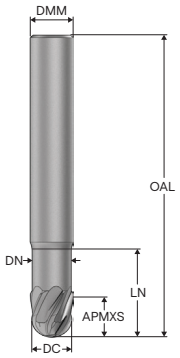
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110 — 140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460 — 750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (110 — 180) *520 (370 — 590)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH722

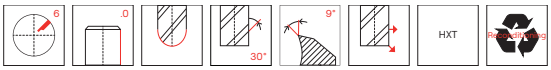
Viteză mare – CoCr / titan – Cap sferic – 6 Caneluri – Cilindrică





E

- Toleranţe:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	4,98375	6	Cylindrical	■

■ **Stoc standard.**

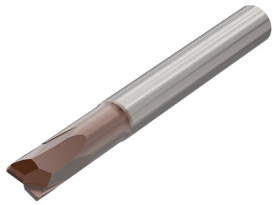
Parametri de așchiere – JH722 Finisare frezare prin copiere

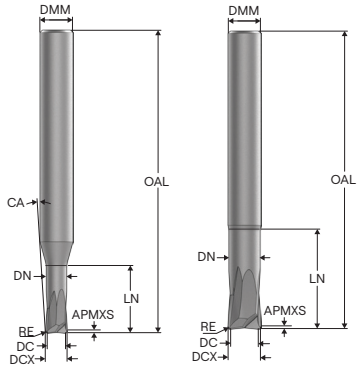
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110 — 150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630 — 750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150 — 180) *520 (500 — 590)*

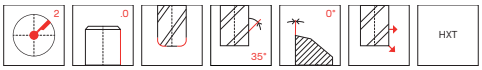
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

SHF712

Avans mare – ISO– S – 2 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC G- Formă = 0/-0,01 mm
—DC E- Formă = 0,005/-0,015 mm
—RE = ±0,005 mm

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm	mm					
SHF712040G2R050.0Z2	HXT	10106493	2	G	4,0	3,0	6,0	0,5	55,0	12,0	3,8	0,5	3,9	1,5	2	Cylindrical	■
SHF712060E2R050.0Z2	HXT	10106494	2	E	6,0	5,0	6,0	0,5	55,0	18,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G3R050.0Z2	HXT	10106495	3	G	3,0	2,0	6,0	0,5	55,0	12,0	2,85	0,5	5,65	1,5	2	Cylindrical	■
SHF712040G3R050.0Z2	HXT	10106496	3	G	4,0	3,0	6,0	0,5	55,0	16,0	3,8	0,5	3,07	1,5	2	Cylindrical	■
SHF712060E3R050.0Z2	HXT	10106497	3	E	6,0	5,0	6,0	0,5	55,0	25,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G4R050.0Z2	HXT	10106498	4	G	3,0	2,0	6,0	0,5	55,0	16,0	2,85	0,5	4,47	1,5	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – SHF712 Frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3	4	6	
S2	E	0,30 *0.30*	0,050 *0.050*	0,055 *0.0022*	0,075 *0.0030*	0,11 *0.0044*	65 (51 — 76) *215 (170 — 240)*
S12	E	0,30 *0.30*	0,050 *0.050*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	170 (150 — 190) *560 (500 — 620)*

Parametri de așchiere – SHF712 Frezare de canal

SMG		a_p/DCX	f_z			v_c
			3	4	6	
S2	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	50 (41 — 60) *165 (140 — 190)*
S12	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	145 (130 — 160) *475 (430 — 520)*

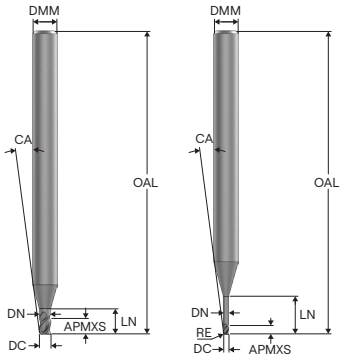
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

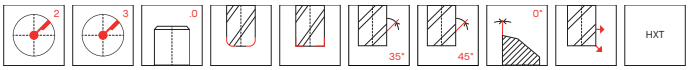
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

SME714/716

Miniatură – ISO– S – Pătrat – 2-3 Caneluri – Cilindrică – Rază la vârf sau ascuţit







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC = 0/-0,01 mm
—RE = ±0,005 mm

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
SME714020G1S.0Z3	HXT	10107349	1	G	2,0	4,0	2,0	50,0	4,0	1,9	–	6,86	3	Cylindrical	■
SME716020G1S.0Z3	HXT	10107360	1	G	2,0	6,0	2,0	50,0	4,0	1,9	–	9,42	3	Cylindrical	■
SME714020G3R010.0Z3	HXT	10107350	3	G	2,0	4,0	2,5	50,0	8,0	1,9	0,1	4,68	3	Cylindrical	■
SME716020G3R010.0Z3	HXT	10107361	3	G	2,0	6,0	2,5	50,0	8,0	1,9	0,1	7,14	3	Cylindrical	■
SME716010G4R010.0Z3	HXT	10107362	4	G	1,0	6,0	1,2	50,0	6,0	0,95	0,1	9,03	3	Cylindrical	■
SME716015G4R010.0Z3	HXT	10107363	4	G	1,5	6,0	1,8	50,0	10,0	1,4	0,1	6,79	3	Cylindrical	■
SME714010G4R010.0Z3	HXT	10107351	4	G	2,0	4,0	1,2	50,0	6,0	0,95	0,1	7,13	3	Cylindrical	■
SME714015G4R010.0Z3	HXT	10107352	4	G	2,0	4,0	1,8	50,0	10,0	1,4	0,1	4,72	3	Cylindrical	■
SME714020G4R010.0Z3	HXT	10107353	4	G	2,0	4,0	2,5	50,0	12,0	1,9	0,1	3,53	3	Cylindrical	■
SME716020G4R010.0Z3	HXT	10107364	4	G	2,0	6,0	2,5	50,0	12,0	1,9	0,1	5,72	3	Cylindrical	■
SME714015G5R010.0Z3	HXT	10107354	5	G	1,5	4,0	1,8	50,0	12,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G5R010.0Z3	HXT	10107365	5	G	1,5	6,0	1,8	50,0	12,0	1,4	0,1	6,15	3	Cylindrical	■
SME714020G5R010.0Z3	HXT	10107355	5	G	2,0	4,0	2,5	50,0	16,0	1,9	0,1	2,83	3	Cylindrical	■
SME716020G5R010.0Z3	HXT	10107366	5	G	2,0	6,0	2,5	50,0	16,0	1,9	0,1	4,77	3	Cylindrical	■
SME714005G6R005.0Z2	HXT	10107356	6	G	0,5	4,0	0,6	50,0	5,0	0,45	0,05	8,31	2	Cylindrical	■
SME716005G6R005.0Z2	HXT	10107367	6	G	0,5	6,0	0,6	50,0	5,0	0,45	0,05	9,93	2	Cylindrical	■
SME714010G6R010.0Z3	HXT	10107357	6	G	1,0	4,0	1,2	50,0	12,0	0,95	0,1	4,77	3	Cylindrical	■
SME716010G6R010.0Z3	HXT	10107368	6	G	1,0	6,0	1,6	50,0	12,0	0,95	0,1	6,56	3	Cylindrical	■
SME714015G6R010.0Z3	HXT	10107358	6	G	1,5	4,0	1,8	50,0	16,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G6R010.0Z3	HXT	10107369	6	G	1,5	6,0	1,8	50,0	16,0	1,4	0,1	5,16	3	Cylindrical	■
SME714010G7R010.0Z3	HXT	10107359	7	G	1,0	4,0	1,2	50,0	16,0	0,95	0,1	3,9	3	Cylindrical	■
SME716010G7R010.0Z3	HXT	10107370	7	G	1,0	6,0	1,2	50,0	16,0	0,95	0,1	5,55	3	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – SME714 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Parametri de așchiere – SME714 Frezare de canal

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – SME716 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Parametri de așchiere – SME716 Frezare de canal

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

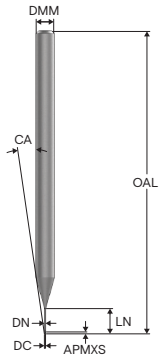
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

SMB713/714/716

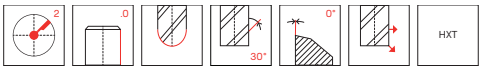
Miniatură – ISO– S – Cap sferic – 2 Caneluri – Cilindrică





G

—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC = 0/-0,01 mm
—RE = ±0,005 mm



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
SMB714020G2B.0Z2	HXT	10109582	2	G	2,0	4,0	2,0	50,0	6,0	1,9	1,0	6,13	2	Cylindrical	■
SMB716020G2B.0Z2	HXT	10109596	2	G	2,0	6,0	2,0	50,0	6,0	1,9	1,0	8,72	2	Cylindrical	■
SMB714030G2B.0Z2	HXT	10109583	2	G	3,0	4,0	3,0	50,0	9,0	2,85	1,5	2,85	2	Cylindrical	■
SMB716030G2B.0Z2	HXT	10109597	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,22	2	Cylindrical	■
SMB714030G3B.0Z2	HXT	10109584	3	G	3,0	4,0	3,0	50,0	12,0	2,85	1,5	2,2	2	Cylindrical	■
SMB716030G3B.0Z2	HXT	10109598	3	G	3,0	6,0	3,0	50,0	12,0	2,85	1,5	5,11	2	Cylindrical	■
SMB714015G4B.0Z2	HXT	10109585	4	G	1,5	4,0	1,5	50,0	9,0	1,4	0,75	5,29	2	Cylindrical	■
SMB716015G4B.0Z2	HXT	10109599	4	G	1,5	6,0	1,5	50,0	9,0	1,4	0,75	7,44	2	Cylindrical	■
SMB714020G4B.0Z2	HXT	10109586	4	G	2,0	4,0	2,0	50,0	10,0	1,9	1,0	4,3	2	Cylindrical	■
SMB716020G4B.0Z2	HXT	10109600	4	G	2,0	6,0	2,0	50,0	10,0	1,9	1,0	6,69	2	Cylindrical	■
SMB714005G5B.0Z2	HXT	10109587	5	G	0,5	4,0	0,5	50,0	4,0	0,45	0,25	9,23	2	Cylindrical	■
SMB716005G5B.0Z2	HXT	10109601	5	G	0,5	6,0	0,5	50,0	4,0	0,45	0,25	10,73	2	Cylindrical	■
SMB714010G5B.0Z2	HXT	10109588	5	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB716010G5B.0Z2	HXT	10109602	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,37	2	Cylindrical	■
SMB714015G5B.0Z2	HXT	10109589	5	G	1,5	4,0	1,5	50,0	12,0	1,4	0,75	4,41	2	Cylindrical	■
SMB716015G5B.0Z2	HXT	10109603	5	G	1,5	6,0	1,5	50,0	12,0	1,4	0,75	6,35	2	Cylindrical	■
SMB714020G5B.0Z2	HXT	10109590	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	2,96	2	Cylindrical	■
SMB716020G5B.0Z2	HXT	10109604	5	G	2,0	6,0	2,0	50,0	16,0	1,9	1,0	4,96	2	Cylindrical	■
SMB713003G6B.0Z2	HXT	10109581	6	G	0,3	3,0	0,3	50,0	4,0	0,28	0,15	8,24	2	Cylindrical	■
SMB714005G6B.0Z2	HXT	10109591	6	G	0,5	4,0	0,5	50,0	6,0	0,45	0,25	7,8	2	Cylindrical	■
SMB716005G6B.0Z2	HXT	10109605	6	G	0,5	6,0	0,5	50,0	6,0	0,45	0,25	9,46	2	Cylindrical	■
SMB714010G6B.0Z2	HXT	10109592	6	G	1,0	4,0	1,0	50,0	12,0	0,95	0,5	4,97	2	Cylindrical	■
SMB716010G6B.0Z2	HXT	10109606	6	G	1,0	6,0	1,0	50,0	12,0	0,95	0,5	6,69	2	Cylindrical	■
SMB714015G6B.0Z2	HXT	10109593	6	G	1,5	4,0	1,5	50,0	16,0	1,4	0,75	3,49	2	Cylindrical	■
SMB716015G6B.0Z2	HXT	10109607	6	G	1,5	6,0	1,5	55,0	16,0	1,4	0,75	5,31	2	Cylindrical	■
SMB714005G7B.0Z2	HXT	10109594	7	G	0,5	4,0	0,5	50,0	9,0	0,45	0,25	6,33	2	Cylindrical	■
SMB716005G7B.0Z2	HXT	10109608	7	G	0,5	6,0	0,5	50,0	9,0	0,45	0,25	8,03	2	Cylindrical	■
SMB714010G7B.0Z2	HXT	10109595	7	G	1,0	4,0	1,0	50,0	16,0	0,95	0,5	3,98	2	Cylindrical	■
SMB716010G7B.0Z2	HXT	10109609	7	G	1,0	6,0	1,0	55,0	16,0	0,95	0,5	5,64	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – SMB713 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z	v_c
				0.3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*

Parametri de așchiere – SMB714 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Parametri de așchiere – SMB716 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



NEFEROASE

Seco oferă o gamă completă de freze cilindro-frontale din carbură solidă de înaltă performanţă pentru frezare cilindro-frontală freze cu cap rotund și freze cilindro-frontale de finisare pentru productivitate ridicată pentru materiale neferoase.

- JS412 și JS413 pentru tip cu colţ ascuţit.
- JS452, JS453, S4521, S4531, S4651, JHP490, HP4931, S4931, JH40, JH421, JM403, JM404, JM406, JH410 și JH440 pentru tip rază.
- S4321, JSB512, JH450, JH460, SMB413, SMB414, SMB416, JM413 și JM416 pentru tipul cu cap rotund.

Alegerea uneltei - Neferoase

						
Nume		JS412	JS413	S4521	S4531	S4651
Pag.		443	446	449	454	463
Familia		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Tipul frezei						
Coada	Cilindrică	■	■	■	■	■
	Weldon	■	■	□	□	□
	Safelock					
Numărul de dinţi		2	3	2	3	5
CSP						■
	Metric	2-20	2-20	2-20	2-20	6-20
	Inch					
Lungimi disponibile		2	2,3	2,3	2,3	2,4
Operaţiune						
						
						
SMG						
N1		●	●	●	●	●
N2		●	●	●	●	
N3			●	●	●	
N11						●
TS1		●	●	●	●	
TP1		●	●	●	●	

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Neferoase

							
Nume		HP4931	S4931	JH40	JH421	JH410	JH440
Pag.		466	470	474	477	481	483
Familia		HPM	Solid²	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon						
	Safelock						
Numărul de dinţi		3	3	2	2-3	1	2
CSP		■	■		■		
	Metric			2-20	2-25	2-17	6-8
	Inch	1/4-1/2	1/4-1/2				
Lungimi disponibile		2,3,4	3,4,5	1,2	2,3	2,3	2
Operaţiune							
							
							
SMG							
N1		●	●	●	●	●	●
N2		●	●				●
N3		●	●				●
N11				●	●	●	●
TS1				●	●	●	●
TP1					●		●

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Neferoase

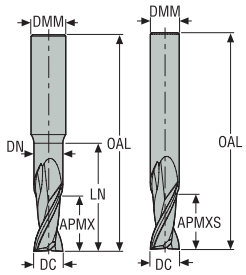
							
Nume		S4321	JH450	JH460	SMB413/414/416	JM403/404/406	JM413/416
Pag.		485	488	490	496	494	496
Familia		SOLID²	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon	□					
	Safelock						
Numărul de dinţi		2	2	2	2	1	2
CSP							
	Metric	2-20	2-20	3-12	1-3	0,5-2	0,5-2
	Inch						
Lungimi disponibile		2	2,3	2	2,3,5	1,2,5	2,3,5
Operaţiune							
							
							
SMG							
N1		●	●	●	●	●	●
N2		●	●		●	●	●
N3		●	●		●	●	●
N11			●	●			●
TS1		●	●	●	●		●
TP1		●	●	●	●		●

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

JS412

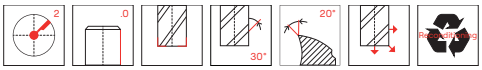
Uz general – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Ascuţit





G D

—Toleranţe:
—DMM= h5
—DC= e8
—Reascuţire posibilă dacă DC este ≥ Ø6



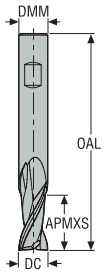
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm			
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	7,0	1,9	2	Cylindrical	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	10,0	2,8	2	Cylindrical	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2	Cylindrical	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	17,0	4,7	2	Cylindrical	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	Cylindrical	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	Cylindrical	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	Cylindrical	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	Cylindrical	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	Cylindrical	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	Cylindrical	■

■ **Stoc standard.**

JS412

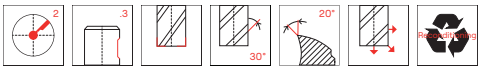
Uz general – Aluminiu – Pătrat – 2 Caneluri – Weldon – Ascuţit





D

- Toleranţe:
- DMM= h5
- DC= e8
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	Weldon	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	Weldon	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	Weldon	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	Weldon	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	Weldon	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	Weldon	■

■ **Stoc standard.**

Parametri de așchiere – JS412 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (470 — 700) *1925 (1600 — 2200)*
N2	E/M/A	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	475 (360 — 590) *1550 (1200 — 1900)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	500 (380 — 630) *1650 (1300 — 2000)*

Parametri de așchiere – JS412 Frezare de canal

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	420 (320 — 520) *1375 (1100 — 1700)*

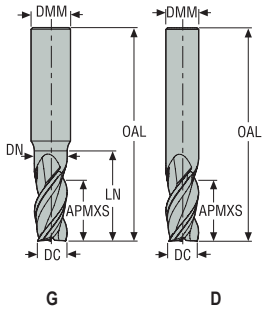
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

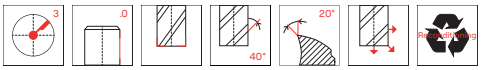
JS413

Uz general – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Ascuţit





– Toleranţe:
– DMM= h5
– DC= e8
– Reascuţire posibilă dacă DC este ≥ Ø6



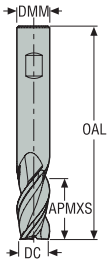
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm			
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	7,0	1,9	3	Cylindrical	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	10,0	2,8	3	Cylindrical	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	14,0	3,8	3	Cylindrical	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	17,0	4,7	3	Cylindrical	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	Cylindrical	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	Cylindrical	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	Cylindrical	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	Cylindrical	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	Cylindrical	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	Cylindrical	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	Cylindrical	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	Cylindrical	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	Cylindrical	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	Cylindrical	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	Cylindrical	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	Cylindrical	■

■ **Stoc standard.**

JS413

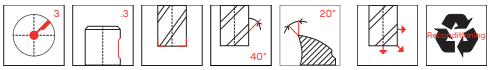
Uz general – Aluminiu – Pătrat – 3 Caneluri – Weldon – Ascuţit





D

—Toleranţe:
—DMM= h5
—DC= e8
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	Weldon	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	Weldon	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	Weldon	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	Weldon	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	Weldon	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	Weldon	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	Weldon	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	Weldon	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	Weldon	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	Weldon	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	Weldon	■
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	Weldon	■

. □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JS413 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	470 (360 — 580) *1550 (1200 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	315 (240 — 390) *1025 (790 — 1200)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	610 (500 — 730) *2000 (1700 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	330 (250 — 410) *1075 (830 — 1300)*

Parametri de aşchiere – JS413 Frezare de canal

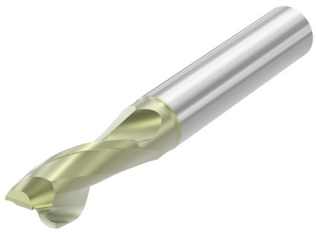
SMG		a_p/DC	f_z									v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	270 (210 — 330) *890 (690 — 1000)*

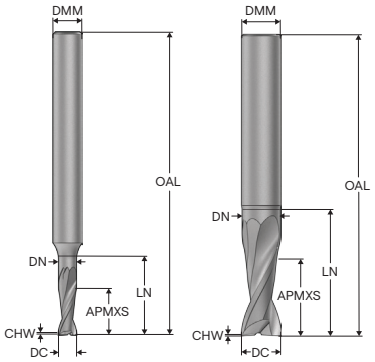
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

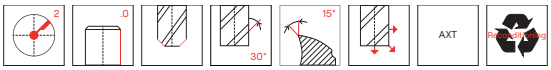
S4521

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Şanfren





- Toleranţe:
- DMM=h5
- DC= e7
- CHW= +0,04 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

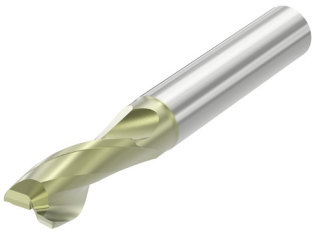


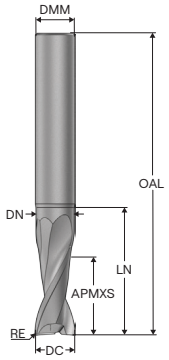
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-020G2C.0Z2	AXT	10228022	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	2	Cylindrical	■
S4521-030G2C.0Z2	AXT	10228023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	2	Cylindrical	■
S4521-040G2C.0Z2	AXT	10228024	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	2	Cylindrical	■
S4521-050G2C.0Z2	AXT	10228025	2	G	5,0	6,0	10,0	57,0	17,0	4,75	0,1	2	Cylindrical	■
S4521-060E2C.0Z2	AXT	10228026	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Cylindrical	■
S4521-080E2C.0Z2	AXT	10228029	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Cylindrical	■
S4521-100E2C.0Z2	AXT	10228033	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Cylindrical	■
S4521-120E2C.0Z2	AXT	10228037	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Cylindrical	■
S4521-140E2C.0Z2	AXT	10228043	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Cylindrical	■
S4521-160E2C.0Z2	AXT	10228044	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Cylindrical	■
S4521-200E2C.0Z2	AXT	10228051	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Cylindrical	■

■ **Stoc standard.**

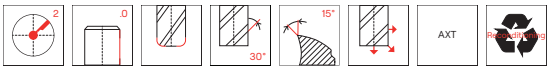
S4521

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

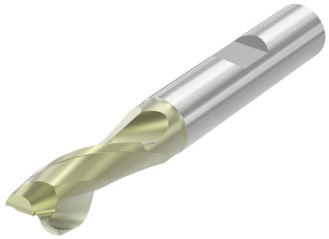


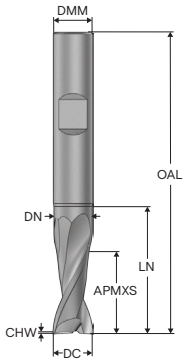
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.0Z2	AXT	10228027	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Cylindrical	■
S4521-060E2R100.0Z2	AXT	10228028	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Cylindrical	■
S4521-080E2R050.0Z2	AXT	10228030	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Cylindrical	■
S4521-080E2R100.0Z2	AXT	10228031	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Cylindrical	■
S4521-100E2R050.0Z2	AXT	10228034	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Cylindrical	■
S4521-100E2R100.0Z2	AXT	10228035	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Cylindrical	■
S4521-120E2R050.0Z2	AXT	10228038	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Cylindrical	■
S4521-120E2R100.0Z2	AXT	10228039	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Cylindrical	■
S4521-120E2R200.0Z2	AXT	10228040	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Cylindrical	■
S4521-120E2R300.0Z2	AXT	10228041	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Cylindrical	■
S4521-160E2R050.0Z2	AXT	10228045	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Cylindrical	■
S4521-160E2R100.0Z2	AXT	10228046	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Cylindrical	■
S4521-160E2R200.0Z2	AXT	10228047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Cylindrical	■
S4521-160E2R300.0Z2	AXT	10228048	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Cylindrical	■
S4521-160E2R400.0Z2	AXT	10228049	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Cylindrical	■
S4521-200E2R050.0Z2	AXT	10228052	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Cylindrical	■
S4521-200E2R100.0Z2	AXT	10228053	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Cylindrical	■
S4521-200E2R200.0Z2	AXT	10228054	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Cylindrical	■
S4521-200E2R300.0Z2	AXT	10228055	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Cylindrical	■
S4521-200E2R400.0Z2	AXT	10228056	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Cylindrical	■
S4521-080E3R020.0Z2	AXT	10228032	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Cylindrical	■
S4521-100E3R050.0Z2	AXT	10228036	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Cylindrical	■
S4521-120E3R050.0Z2	AXT	10228042	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Cylindrical	■
S4521-160E3R050.0Z2	AXT	10228050	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Cylindrical	■
S4521-200E3R050.0Z2	AXT	10228057	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Cylindrical	■

■ **Stoc standard.**

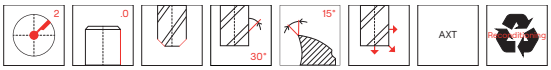
S4521

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Weldon – Şanfren





- Toleranţe:
- DMM=h5
- DC= e7
- CHW= +0,04 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

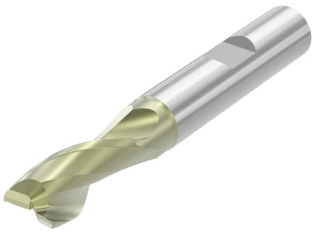


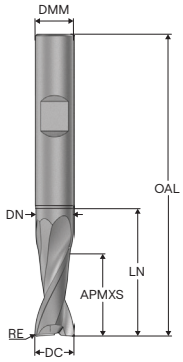
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2C.3Z2	AXT	10286908	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Weldon	□
S4521-080E2C.3Z2	AXT	10286911	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Weldon	□
S4521-100E2C.3Z2	AXT	10286915	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Weldon	□
S4521-120E2C.3Z2	AXT	10286919	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Weldon	□
S4521-140E2C.3Z2	AXT	10286925	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Weldon	□
S4521-160E2C.3Z2	AXT	10286926	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Weldon	□
S4521-200E2C.3Z2	AXT	10286933	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

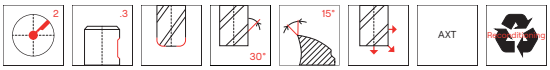
S4521

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.3Z2	AXT	10286909	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Weldon	☐
S4521-060E2R100.3Z2	AXT	10286910	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Weldon	☐
S4521-080E3R020.3Z2	AXT	10286914	2	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Weldon	☐
S4521-080E2R050.3Z2	AXT	10286912	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Weldon	☐
S4521-080E2R100.3Z2	AXT	10286913	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Weldon	☐
S4521-100E2R050.3Z2	AXT	10286916	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Weldon	☐
S4521-100E3R050.3Z2	AXT	10286918	2	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Weldon	☐
S4521-100E2R100.3Z2	AXT	10286917	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Weldon	☐
S4521-120E2R050.3Z2	AXT	10286920	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Weldon	☐
S4521-120E2R100.3Z2	AXT	10286921	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Weldon	☐
S4521-120E2R200.3Z2	AXT	10286922	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Weldon	☐
S4521-120E2R300.3Z2	AXT	10286923	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Weldon	☐
S4521-160E2R050.3Z2	AXT	10286927	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Weldon	☐
S4521-160E2R100.3Z2	AXT	10286928	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Weldon	☐
S4521-160E2R200.3Z2	AXT	10286929	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Weldon	☐
S4521-160E2R300.3Z2	AXT	10286930	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Weldon	☐
S4521-160E2R400.3Z2	AXT	10286931	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Weldon	☐
S4521-200E2R050.3Z2	AXT	10286934	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Weldon	☐
S4521-200E2R100.3Z2	AXT	10286935	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Weldon	☐
S4521-200E2R200.3Z2	AXT	10286936	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Weldon	☐
S4521-200E2R300.3Z2	AXT	10286937	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Weldon	☐
S4521-200E2R400.3Z2	AXT	10286938	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Weldon	☐
S4521-120E3R050.3Z2	AXT	10286924	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Weldon	☐
S4521-160E3R050.3Z2	AXT	10286932	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Weldon	☐
S4521-200E3R050.3Z2	AXT	10286939	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – S4521 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0,30 *0.30*	1,5 *1.5*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0,30 *0.30*	1,5 *1.5*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – S4521 Frezare de canal

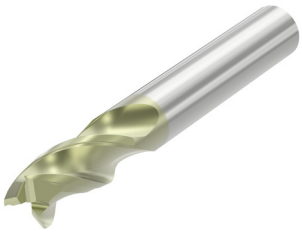
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	395 (300 — 490) *1300 (990 — 1600)*
N3	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	265 (200 — 320) *870 (660 — 1000)*
TS1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
TP1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	395 (300 — 490) *1300 (990 — 1600)*

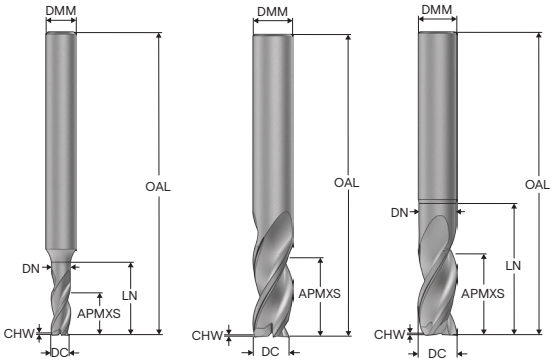
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

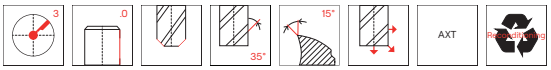
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Şanfren







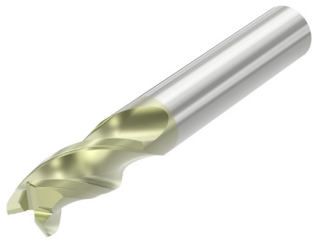
– Toleranţe:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

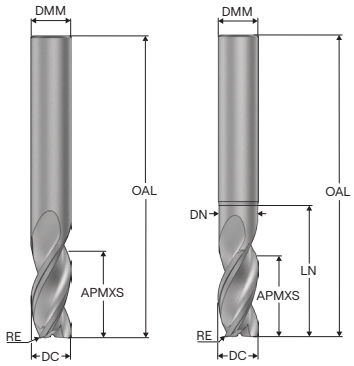
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-020G2C.0Z3	AXT	10228067	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	3	Cylindrical	■
S4531-030G2C.0Z3	AXT	10228068	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	3	Cylindrical	■
S4531-040G2C.0Z3	AXT	10228069	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	3	Cylindrical	■
S4531-050G2C.0Z3	AXT	10228070	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,1	3	Cylindrical	■
S4531-060D2C.0Z3	AXT	10228071	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Cylindrical	■
S4531-060E2C.0Z3	AXT	10228074	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Cylindrical	■
S4531-080D2C.0Z3	AXT	10228077	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080E2C.0Z3	AXT	10228080	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Cylindrical	■
S4531-100D2C.0Z3	AXT	10228083	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Cylindrical	■
S4531-100E2C.0Z3	AXT	10228087	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Cylindrical	■
S4531-120D2C.0Z3	AXT	10228091	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Cylindrical	■
S4531-120E2C.0Z3	AXT	10228096	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Cylindrical	■
S4531-140D2C.0Z3	AXT	10228102	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Cylindrical	■
S4531-160D2C.0Z3	AXT	10228103	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Cylindrical	■
S4531-200E2C.0Z3	AXT	10228114	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Cylindrical	■
S4531-030G3C.0Z3	AXT	10228058	3	G	3,0	6,0	10,0	63,0	14,0	2,85	0,1	3	Cylindrical	■
S4531-040G3C.0Z3	AXT	10228059	3	G	4,0	6,0	13,0	63,0	18,0	3,8	0,1	3	Cylindrical	■
S4531-050G3C.0Z3	AXT	10228060	3	G	5,0	6,0	16,0	63,0	20,0	4,75	0,1	3	Cylindrical	■
S4531-060D3C.0Z3	AXT	10228061	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080D3C.0Z3	AXT	10228062	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Cylindrical	■
S4531-100D3C.0Z3	AXT	10228063	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Cylindrical	■
S4531-120D3C.0Z3	AXT	10228064	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Cylindrical	■
S4531-160D3C.0Z3	AXT	10228065	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Cylindrical	■
S4531-200D3C.0Z3	AXT	10228066	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Cylindrical	■
S4531-200E3C.0Z3	AXT	10228120	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Cylindrical	■

■ **Stoc standard.**

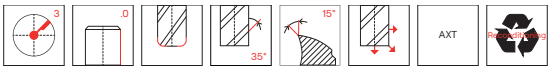
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

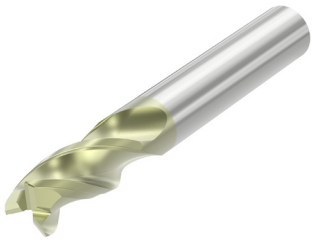


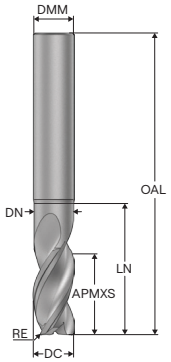
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.0Z3	AXT	10228072	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Cylindrical	■
S4531-060E2R050.0Z3	AXT	10228075	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Cylindrical	■
S4531-060D2R100.0Z3	AXT	10228073	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Cylindrical	■
S4531-060E2R100.0Z3	AXT	10228076	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Cylindrical	■
S4531-080D2R050.0Z3	AXT	10228078	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Cylindrical	■
S4531-080E2R050.0Z3	AXT	10228081	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Cylindrical	■
S4531-080D2R100.0Z3	AXT	10228079	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Cylindrical	■
S4531-080E2R100.0Z3	AXT	10228082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Cylindrical	■
S4531-100D2R050.0Z3	AXT	10228084	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Cylindrical	■
S4531-100E2R050.0Z3	AXT	10228088	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Cylindrical	■
S4531-100D2R100.0Z3	AXT	10228085	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Cylindrical	■
S4531-100E2R100.0Z3	AXT	10228089	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Cylindrical	■
S4531-100D2R200.0Z3	AXT	10228086	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Cylindrical	■
S4531-100E2R200.0Z3	AXT	10228090	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Cylindrical	■
S4531-120D2R050.0Z3	AXT	10228092	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Cylindrical	■
S4531-120E2R050.0Z3	AXT	10228097	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Cylindrical	■
S4531-120D2R100.0Z3	AXT	10228093	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Cylindrical	■
S4531-120E2R100.0Z3	AXT	10228098	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Cylindrical	■
S4531-120D2R200.0Z3	AXT	10228094	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Cylindrical	■
S4531-120E2R200.0Z3	AXT	10228099	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Cylindrical	■
S4531-120D2R300.0Z3	AXT	10228095	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Cylindrical	■
S4531-120E2R300.0Z3	AXT	10228100	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Cylindrical	■
S4531-160D2R050.0Z3	AXT	10228104	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Cylindrical	■
S4531-160E2R100.0Z3	AXT	10228105	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Cylindrical	■
S4531-160E2R200.0Z3	AXT	10228106	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Cylindrical	■
S4531-160E2R250.0Z3	AXT	10228107	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Cylindrical	■
S4531-160E2R300.0Z3	AXT	10228108	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Cylindrical	■
S4531-160E2R400.0Z3	AXT	10228109	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Cylindrical	■
S4531-200E2R050.0Z3	AXT	10228115	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Cylindrical	■
S4531-200E2R100.0Z3	AXT	10228116	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Cylindrical	■
S4531-200E2R200.0Z3	AXT	10228117	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Cylindrical	■
S4531-200E2R300.0Z3	AXT	10228118	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Cylindrical	■
S4531-200E2R400.0Z3	AXT	10228119	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Cylindrical	■

■ **Stoc standard.**

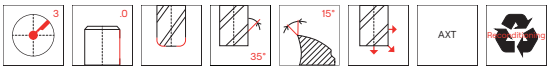
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

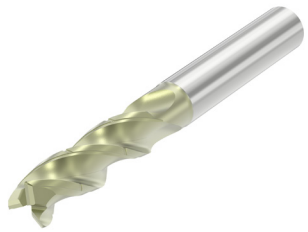


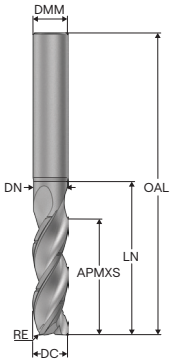
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-120E3R300.0Z3	AXT	10228101	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R100.0Z3	AXT	10228110	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3	AXT	10228111	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3	AXT	10228112	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Cylindrical	■
S4531-160E3R400.0Z3	AXT	10228113	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Cylindrical	■
S4531-200E3R050.0Z3	AXT	10228121	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3	AXT	10228122	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3	AXT	10228123	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3	AXT	10228124	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Cylindrical	■
S4531-200E3R400.0Z3	AXT	10228125	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Cylindrical	■

■ **Stoc standard.**

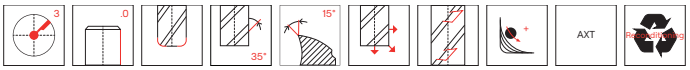
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

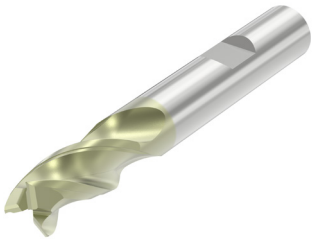


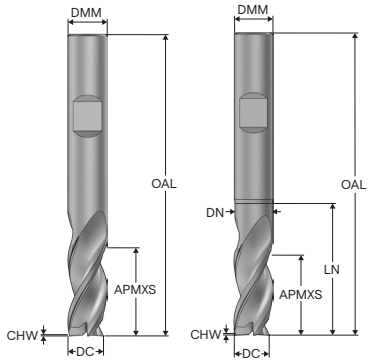
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmen-tator de aşchii	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.0Z3C	AXT	10228126	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Cylindrical	■
S4531-060E3R100.0Z3C	AXT	10228127	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Cylindrical	■
S4531-080E3R050.0Z3C	AXT	10228128	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Cylindrical	■
S4531-080E3R100.0Z3C	AXT	10228129	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Cylindrical	■
S4531-080E3R200.0Z3C	AXT	10228130	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Cylindrical	■
S4531-100E3R050.0Z3C	AXT	10228131	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Cylindrical	■
S4531-100E3R100.0Z3C	AXT	10228132	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Cylindrical	■
S4531-100E3R200.0Z3C	AXT	10228133	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Cylindrical	■
S4531-120E3R050.0Z3C	AXT	10228134	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Cylindrical	■
S4531-120E3R100.0Z3C	AXT	10228135	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Cylindrical	■
S4531-120E3R200.0Z3C	AXT	10228136	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Cylindrical	■
S4531-120E3R300.0Z3C	AXT	10228137	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R050.0Z3C	AXT	10228138	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Cylindrical	■
S4531-160E3R100.0Z3C	AXT	10228139	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3C	AXT	10228140	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3C	AXT	10228141	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Cylindrical	■
S4531-200E3R050.0Z3C	AXT	10228142	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3C	AXT	10228143	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3C	AXT	10228144	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3C	AXT	10228145	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Cylindrical	■

■ Stoc standard.

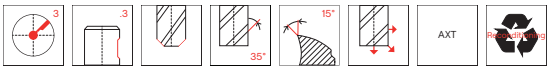
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Weldon – Şanfren





– Toleranţe:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

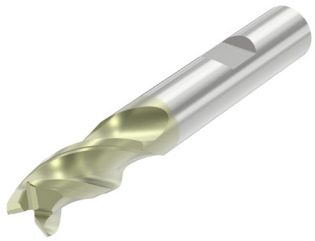


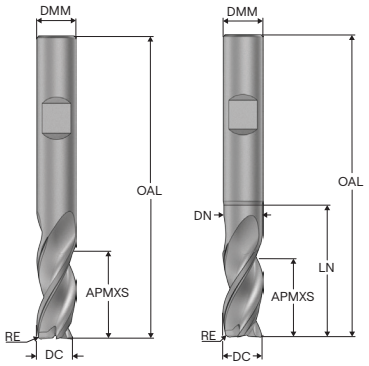
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2C.3Z3	AXT	10286946	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Weldon	☐
S4531-060E2C.3Z3	AXT	10286949	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Weldon	☐
S4531-080D2C.3Z3	AXT	10286952	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080E2C.3Z3	AXT	10286955	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Weldon	☐
S4531-100D2C.3Z3	AXT	10286958	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Weldon	☐
S4531-100E2C.3Z3	AXT	10286962	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Weldon	☐
S4531-120D2C.3Z3	AXT	10286966	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Weldon	☐
S4531-120E2C.3Z3	AXT	10286971	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Weldon	☐
S4531-140D2C.3Z3	AXT	10286977	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Weldon	☐
S4531-160D2C.3Z3	AXT	10286978	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Weldon	☐
S4531-200E2C.3Z3	AXT	10286989	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Weldon	☐
S4531-060D3C.3Z3	AXT	10286940	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080D3C.3Z3	AXT	10286941	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Weldon	☐
S4531-100D3C.3Z3	AXT	10286942	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Weldon	☐
S4531-120D3C.3Z3	AXT	10286943	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Weldon	☐
S4531-160D3C.3Z3	AXT	10286944	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Weldon	☐
S4531-200D3C.3Z3	AXT	10286945	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Weldon	☐
S4531-200E3C.3Z3	AXT	10286995	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

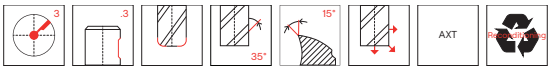
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

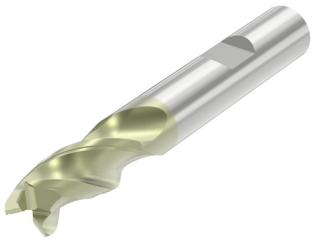


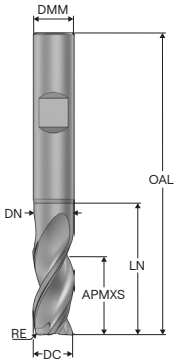
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.3Z3	AXT	10286947	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Weldon	□
S4531-060E2R050.3Z3	AXT	10286950	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Weldon	□
S4531-060D2R100.3Z3	AXT	10286948	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Weldon	□
S4531-060E2R100.3Z3	AXT	10286951	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Weldon	□
S4531-080D2R050.3Z3	AXT	10286953	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Weldon	□
S4531-080E2R050.3Z3	AXT	10286956	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	□
S4531-080D2R100.3Z3	AXT	10286954	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Weldon	□
S4531-080E2R100.3Z3	AXT	10286957	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	□
S4531-100D2R050.3Z3	AXT	10286959	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Weldon	□
S4531-100E2R050.3Z3	AXT	10286963	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Weldon	□
S4531-100D2R100.3Z3	AXT	10286960	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Weldon	□
S4531-100E2R100.3Z3	AXT	10286964	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Weldon	□
S4531-100D2R200.3Z3	AXT	10286961	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Weldon	□
S4531-100E2R200.3Z3	AXT	10286965	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Weldon	□
S4531-120D2R050.3Z3	AXT	10286967	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Weldon	□
S4531-120E2R050.3Z3	AXT	10286972	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Weldon	□
S4531-120D2R100.3Z3	AXT	10286968	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Weldon	□
S4531-120E2R100.3Z3	AXT	10286973	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Weldon	□
S4531-120D2R200.3Z3	AXT	10286969	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Weldon	□
S4531-120E2R200.3Z3	AXT	10286974	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Weldon	□
S4531-120D2R300.3Z3	AXT	10286970	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Weldon	□
S4531-120E2R300.3Z3	AXT	10286975	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Weldon	□
S4531-160D2R050.3Z3	AXT	10286979	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Weldon	□
S4531-160E2R100.3Z3	AXT	10286980	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Weldon	□
S4531-160E2R200.3Z3	AXT	10286981	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Weldon	□
S4531-160E2R250.3Z3	AXT	10286982	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Weldon	□
S4531-160E2R300.3Z3	AXT	10286983	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Weldon	□
S4531-160E2R400.3Z3	AXT	10286984	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

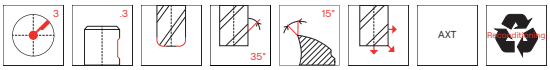
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

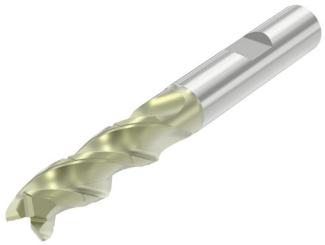


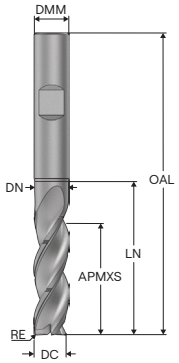
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4531-200E2R050.3Z3	AXT	10286990	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Weldon	☐
S4531-200E2R100.3Z3	AXT	10286991	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Weldon	☐
S4531-200E2R200.3Z3	AXT	10286992	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Weldon	☐
S4531-200E2R300.3Z3	AXT	10286993	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Weldon	☐
S4531-200E2R400.3Z3	AXT	10286994	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Weldon	☐
S4531-120E3R300.3Z3	AXT	10286976	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Weldon	☐
S4531-160E3R100.3Z3	AXT	10286985	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Weldon	☐
S4531-160E3R200.3Z3	AXT	10286986	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Weldon	☐
S4531-160E3R300.3Z3	AXT	10286987	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Weldon	☐
S4531-160E3R400.3Z3	AXT	10286988	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Weldon	☐
S4531-200E3R050.3Z3	AXT	10286996	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Weldon	☐
S4531-200E3R100.3Z3	AXT	10286997	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Weldon	☐
S4531-200E3R200.3Z3	AXT	10286998	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Weldon	☐
S4531-200E3R300.3Z3	AXT	10286999	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Weldon	☐
S4531-200E3R400.3Z3	AXT	10287000	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

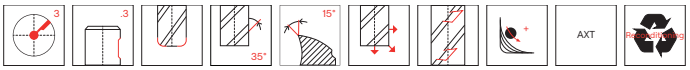
S4531

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Weldon – Rază la vârf





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.3Z3C	AXT	10287001	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Weldon	□
S4531-060E3R100.3Z3C	AXT	10287002	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Weldon	□
S4531-080E3R050.3Z3C	AXT	10287004	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Weldon	□
S4531-080E3R100.3Z3C	AXT	10287005	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Weldon	□
S4531-080E3R200.3Z3C	AXT	10287006	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Weldon	□
S4531-100E3R050.3Z3C	AXT	10287007	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Weldon	□
S4531-100E3R100.3Z3C	AXT	10287008	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Weldon	□
S4531-100E3R200.3Z3C	AXT	10287009	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Weldon	□
S4531-120E3R050.3Z3C	AXT	10287010	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Weldon	□
S4531-120E3R100.3Z3C	AXT	10287011	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Weldon	□
S4531-120E3R200.3Z3C	AXT	10287012	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Weldon	□
S4531-120E3R300.3Z3C	AXT	10287013	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Weldon	□
S4531-160E3R050.3Z3C	AXT	10287014	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Weldon	□
S4531-160E3R100.3Z3C	AXT	10287015	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Weldon	□
S4531-160E3R200.3Z3C	AXT	10287016	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Weldon	□
S4531-160E3R300.3Z3C	AXT	10287017	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Weldon	□
S4531-200E3R050.3Z3C	AXT	10287018	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Weldon	□
S4531-200E3R100.3Z3C	AXT	10287019	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Weldon	□
S4531-200E3R200.3Z3C	AXT	10287020	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Weldon	□
S4531-200E3R300.3Z3C	AXT	10287021	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – S4531 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0,30 *0.30*	1,7 *1.7*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0,30 *0.30*	1,7 *1.7*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – S4531 Frezare de canal

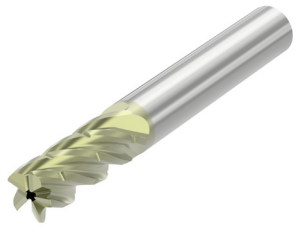
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	395 (300 — 490) *1300 (990 — 1600)*
N3	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	265 (200 — 320) *870 (660 — 1000)*
TS1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
TP1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	395 (300 — 490) *1300 (990 — 1600)*

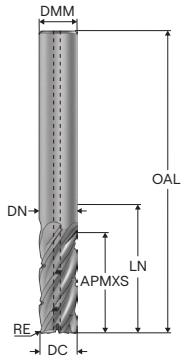
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

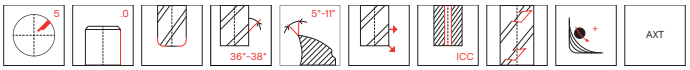
S4651

Înaltă performanţă – Aluminiu – Pătrat – 5 Caneluri – Cilindrică





—Toleranţe:
—DMM=h5
—DC= e7
—RE= ±0,02 mm

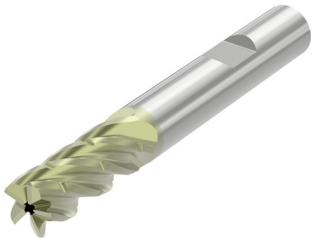


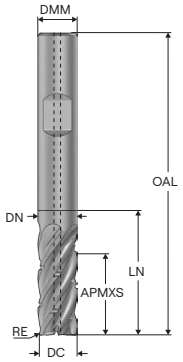
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.0Z5AC	AXT	10228163	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Cylindrical	■
S4651-060E2R100.0Z5AC	AXT	10228164	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Cylindrical	■
S4651-080E2R050.0Z5AC	AXT	10228167	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Cylindrical	■
S4651-080E2R100.0Z5AC	AXT	10228168	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Cylindrical	■
S4651-100E2R050.0Z5AC	AXT	10228171	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Cylindrical	■
S4651-100E2R100.0Z5AC	AXT	10228172	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Cylindrical	■
S4651-120E2R050.0Z5AC	AXT	10228175	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Cylindrical	■
S4651-120E2R100.0Z5AC	AXT	10228176	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Cylindrical	■
S4651-120E2R200.0Z5AC	AXT	10228177	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Cylindrical	■
S4651-120E2R300.0Z5AC	AXT	10228178	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Cylindrical	■
S4651-160E2R050.0Z5AC	AXT	10228183	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Cylindrical	■
S4651-160E2R100.0Z5AC	AXT	10228184	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Cylindrical	■
S4651-160E2R200.0Z5AC	AXT	10228185	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Cylindrical	■
S4651-160E2R300.0Z5AC	AXT	10228186	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Cylindrical	■
S4651-200E2R050.0Z5AC	AXT	10228191	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Cylindrical	■
S4651-200E2R100.0Z5AC	AXT	10228193	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Cylindrical	■
S4651-200E2R200.0Z5AC	AXT	10228194	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Cylindrical	■
S4651-200E2R300.0Z5AC	AXT	10228195	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Cylindrical	■
S4651-060E4R050.0Z5AC	AXT	10228165	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Cylindrical	■
S4651-060E4R100.0Z5AC	AXT	10228166	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Cylindrical	■
S4651-080E4R050.0Z5AC	AXT	10228169	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Cylindrical	■
S4651-080E4R100.0Z5AC	AXT	10228170	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Cylindrical	■
S4651-100E4R050.0Z5AC	AXT	10228173	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Cylindrical	■
S4651-100E4R100.0Z5AC	AXT	10228174	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Cylindrical	■
S4651-120E4R050.0Z5AC	AXT	10228179	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Cylindrical	■
S4651-120E4R100.0Z5AC	AXT	10228180	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Cylindrical	■
S4651-120E4R200.0Z5AC	AXT	10228181	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Cylindrical	■
S4651-120E4R300.0Z5AC	AXT	10228182	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Cylindrical	■
S4651-160E4R050.0Z5AC	AXT	10228187	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Cylindrical	■
S4651-160E4R100.0Z5AC	AXT	10228188	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Cylindrical	■
S4651-160E4R200.0Z5AC	AXT	10228189	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Cylindrical	■
S4651-160E4R300.0Z5AC	AXT	10228190	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,8	3,0	5	Cylindrical	■
S4651-200E4R050.0Z5AC	AXT	10228196	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Cylindrical	■
S4651-200E4R100.0Z5AC	AXT	10228197	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Cylindrical	■
S4651-200E4R200.0Z5AC	AXT	10228198	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Cylindrical	■
S4651-200E4R300.0Z5AC	AXT	10228199	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Cylindrical	■

■ **Stoc standard.**

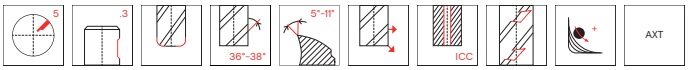
S4651

Înaltă performanţă – Aluminiu – Pătrat – 5 Caneluri – Weldon





– Toleranţe:
– DMM=h5
– DC= e7
– RE= ±0,02 mm



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.3Z5AC	AXT	10287053	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Weldon	□
S4651-060E2R100.3Z5AC	AXT	10287054	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Weldon	□
S4651-080E2R050.3Z5AC	AXT	10287057	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Weldon	□
S4651-080E2R100.3Z5AC	AXT	10287058	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Weldon	□
S4651-100E2R050.3Z5AC	AXT	10287061	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Weldon	□
S4651-100E2R100.3Z5AC	AXT	10287062	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Weldon	□
S4651-120E2R050.3Z5AC	AXT	10287065	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Weldon	□
S4651-120E2R100.3Z5AC	AXT	10287066	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Weldon	□
S4651-120E2R200.3Z5AC	AXT	10287067	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Weldon	□
S4651-120E2R300.3Z5AC	AXT	10287068	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Weldon	□
S4651-160E2R050.3Z5AC	AXT	10287073	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Weldon	□
S4651-160E2R100.3Z5AC	AXT	10287074	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Weldon	□
S4651-160E2R200.3Z5AC	AXT	10287075	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Weldon	□
S4651-160E2R300.3Z5AC	AXT	10287076	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Weldon	□
S4651-200E2R050.3Z5AC	AXT	10287081	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Weldon	□
S4651-200E2R100.3Z5AC	AXT	10287082	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Weldon	□
S4651-200E2R200.3Z5AC	AXT	10287083	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Weldon	□
S4651-200E2R300.3Z5AC	AXT	10287084	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Weldon	□
S4651-060E4R050.3Z5AC	AXT	10287055	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Weldon	□
S4651-060E4R100.3Z5AC	AXT	10287056	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Weldon	□
S4651-080E4R050.3Z5AC	AXT	10287059	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Weldon	□
S4651-080E4R100.3Z5AC	AXT	10287060	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Weldon	□
S4651-100E4R050.3Z5AC	AXT	10287063	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Weldon	□
S4651-100E4R100.3Z5AC	AXT	10287064	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Weldon	□
S4651-120E4R050.3Z5AC	AXT	10287069	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Weldon	□
S4651-120E4R100.3Z5AC	AXT	10287070	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Weldon	□
S4651-120E4R200.3Z5AC	AXT	10287071	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Weldon	□
S4651-120E4R300.3Z5AC	AXT	10287072	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Weldon	□
S4651-160E4R050.3Z5AC	AXT	10287077	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Weldon	□
S4651-160E4R100.3Z5AC	AXT	10287078	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Weldon	□
S4651-160E4R200.3Z5AC	AXT	10287079	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Weldon	□
S4651-160E4R300.3Z5AC	AXT	10287080	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	3,0	5	Weldon	□
S4651-200E4R050.3Z5AC	AXT	10287085	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Weldon	□
S4651-200E4R100.3Z5AC	AXT	10287086	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Weldon	□
S4651-200E4R200.3Z5AC	AXT	10287087	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Weldon	□
S4651-200E4R300.3Z5AC	AXT	10287088	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Weldon	□

□ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – S4651 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
N1	E	0,40 *0.40*	2,2 *2.2*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	330 (260 — 410) *1075 (860 — 1300)*
N2	E	0,40 *0.40*	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	280 (220 — 350) *920 (730 — 1100)*
N3	E	0,40 *0.40*	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	185 (150 — 230) *610 (500 — 750)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – S4651 Frezare laterală degroșare avansată a_e/DC=0,07

SMG		a_p/DC	f_z						v_c
			6	8	10	12	16	20	
N1	E	2,2 *2.2*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,24 *0.0095*	475 (370 — 600) *1550 (1300 — 1900)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	410 (320 — 520) *1350 (1100 — 1700)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	275 (210 — 350) *900 (690 — 1100)*

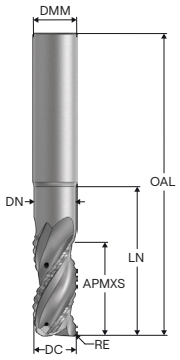
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

HP4931

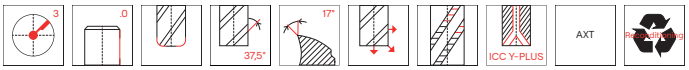
Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





E

- Toleranţe:
- DMM=h5
- DC -0,02/-0,1 mm
- RE=+/-0,05 mm
- Reascuţire posibilă



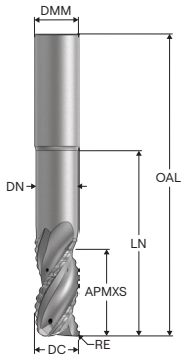
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-200E2R050.0Z3A	AXT	10318812	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	0,5	Cylindrical	■
HP4931-200E2R100.0Z3A	AXT	10318813	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	1,0	Cylindrical	■
HP4931-200E2R200.0Z3A	AXT	10318814	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	2,0	Cylindrical	■
HP4931-200E2R300.0Z3A	AXT	10318815	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	3,0	Cylindrical	■
HP4931-200E2R400.0Z3A	AXT	10318816	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	4,0	Cylindrical	■
HP4931-200E2R500.0Z3A	AXT	10318817	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	5,0	Cylindrical	□
HP4931-250E2R050.0Z3A	AXT	10318824	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	0,5	Cylindrical	■
HP4931-250E2R100.0Z3A	AXT	10318825	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	1,0	Cylindrical	■
HP4931-250E2R200.0Z3A	AXT	10318826	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	2,0	Cylindrical	■
HP4931-250E2R300.0Z3A	AXT	10318827	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	3,0	Cylindrical	■
HP4931-250E2R400.0Z3A	AXT	10318828	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	4,0	Cylindrical	■
HP4931-250E2R500.0Z3A	AXT	10318829	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	5,0	Cylindrical	□
HP4931-120E3R050.0Z3A	AXT	10318795	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	0,5	Cylindrical	■
HP4931-120E3R100.0Z3A	AXT	10318796	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	1,0	Cylindrical	■
HP4931-120E3R200.0Z3A	AXT	10318797	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	2,0	Cylindrical	■
HP4931-120E3R300.0Z3A	AXT	10318798	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	3,0	Cylindrical	■
HP4931-120E3R400.0Z3A	AXT	10318799	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	4,0	Cylindrical	□
HP4931-160E3R050.0Z3A	AXT	10318800	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	0,5	Cylindrical	■
HP4931-160E3R100.0Z3A	AXT	10318801	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	1,0	Cylindrical	■
HP4931-160E3R200.0Z3A	AXT	10318802	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	2,0	Cylindrical	■
HP4931-160E3R300.0Z3A	AXT	10318803	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	3,0	Cylindrical	■
HP4931-160E3R400.0Z3A	AXT	10318804	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	4,0	Cylindrical	■
HP4931-160E3R500.0Z3A	AXT	10318805	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	5,0	Cylindrical	□
HP4931-200E3R050.0Z3A	AXT	10318818	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	0,5	Cylindrical	■
HP4931-200E3R100.0Z3A	AXT	10318819	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	1,0	Cylindrical	■
HP4931-200E3R200.0Z3A	AXT	10318820	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	2,0	Cylindrical	■
HP4931-200E3R300.0Z3A	AXT	10318821	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	3,0	Cylindrical	■
HP4931-200E3R400.0Z3A	AXT	10318822	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	4,0	Cylindrical	■
HP4931-200E3R500.0Z3A	AXT	10318823	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	5,0	Cylindrical	□
HP4931-250E3R050.0Z3A	AXT	10318830	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	0,5	Cylindrical	■
HP4931-250E3R100.0Z3A	AXT	10318831	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	1,0	Cylindrical	■
HP4931-250E3R200.0Z3A	AXT	10318832	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	2,0	Cylindrical	■
HP4931-250E3R300.0Z3A	AXT	10318833	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	3,0	Cylindrical	■
HP4931-250E3R400.0Z3A	AXT	10318834	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	4,0	Cylindrical	■
HP4931-250E3R500.0Z3A	AXT	10318835	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	5,0	Cylindrical	□

■ **Stoc standard.**

HP4931

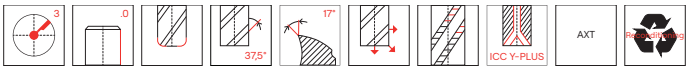
Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





E

- Toleranţe:
- DMM=h5
- DC -0,02/-0,1 mm
- RE=+/-0,05 mm
- Reascuţire posibilă



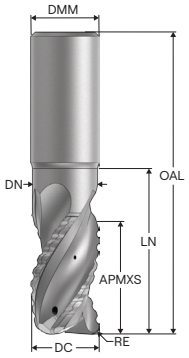
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-160E4R050.0Z3A	AXT	10318806	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	0,5	Cylindrical	■
HP4931-160E4R100.0Z3A	AXT	10318807	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	1,0	Cylindrical	■
HP4931-160E4R200.0Z3A	AXT	10318808	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	2,0	Cylindrical	■
HP4931-160E4R300.0Z3A	AXT	10318809	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	3,0	Cylindrical	■
HP4931-160E4R400.0Z3A	AXT	10318810	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	4,0	Cylindrical	■
HP4931-160E4R500.0Z3A	AXT	10318811	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	5,0	Cylindrical	□

■ **Stoc standard.**

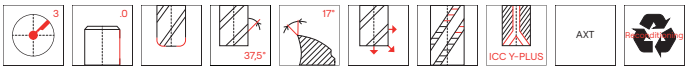
HP4931

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf – Inci





- Toleranţe:
- DMM=h5
- DC -0.001"/-0.004"
- RE=+/-0.002"
- Reascuţire posibilă



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							inci	inci	inci	inci	inci	inci	inci		
HP4931-.750E2R020.0Z3A	AXT	10318851	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.020	Cylindrical	■
HP4931-.750E2R030.0Z3A	AXT	10318852	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.030	Cylindrical	■
HP4931-.750E2R060.0Z3A	AXT	10318853	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.060	Cylindrical	■
HP4931-.750E2R090.0Z3A	AXT	10318854	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.090	Cylindrical	■
HP4931-.750E2R120.0Z3A	AXT	10318855	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.120	Cylindrical	■
HP4931-1.000E2R020.0Z3A	AXT	10318861	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.020	Cylindrical	■
HP4931-1.000E2R030.0Z3A	AXT	10318862	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.030	Cylindrical	■
HP4931-1.000E2R060.0Z3A	AXT	10318863	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.060	Cylindrical	■
HP4931-1.000E2R090.0Z3A	AXT	10318864	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.090	Cylindrical	■
HP4931-1.000E2R120.0Z3A	AXT	10318865	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.120	Cylindrical	■
HP4931-.500E3R020.0Z3A	AXT	10318836	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.020	Cylindrical	■
HP4931-.500E3R030.0Z3A	AXT	10318837	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.030	Cylindrical	■
HP4931-.500E3R060.0Z3A	AXT	10318838	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.060	Cylindrical	■
HP4931-.500E3R090.0Z3A	AXT	10318839	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.090	Cylindrical	■
HP4931-.500E3R120.0Z3A	AXT	10318840	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.120	Cylindrical	■
HP4931-.625E3R020.0Z3A	AXT	10318841	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.020	Cylindrical	■
HP4931-.625E3R030.0Z3A	AXT	10318842	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.030	Cylindrical	■
HP4931-.625E3R060.0Z3A	AXT	10318843	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.060	Cylindrical	■
HP4931-.625E3R090.0Z3A	AXT	10318844	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.090	Cylindrical	■
HP4931-.625E3R120.0Z3A	AXT	10318845	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.120	Cylindrical	■
HP4931-.750E3R020.0Z3A	AXT	10318856	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.020	Cylindrical	■
HP4931-.750E3R030.0Z3A	AXT	10318857	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.030	Cylindrical	■
HP4931-.750E3R060.0Z3A	AXT	10318858	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.060	Cylindrical	■
HP4931-.750E3R090.0Z3A	AXT	10318859	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.090	Cylindrical	■
HP4931-.750E3R120.0Z3A	AXT	10318860	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.120	Cylindrical	■
HP4931-1.000E3R020.0Z3A	AXT	10318866	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.020	Cylindrical	■
HP4931-1.000E3R030.0Z3A	AXT	10318867	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.030	Cylindrical	■
HP4931-1.000E3R060.0Z3A	AXT	10318868	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.060	Cylindrical	■
HP4931-1.000E3R090.0Z3A	AXT	10318869	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.090	Cylindrical	■
HP4931-1.000E3R120.0Z3A	AXT	10318870	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.120	Cylindrical	■
HP4931-.625E4R020.0Z3A	AXT	10318846	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.020	Cylindrical	■
HP4931-.625E4R030.0Z3A	AXT	10318847	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.030	Cylindrical	■
HP4931-.625E4R060.0Z3A	AXT	10318848	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.060	Cylindrical	■
HP4931-.625E4R090.0Z3A	AXT	10318849	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.090	Cylindrical	■
HP4931-.625E4R120.0Z3A	AXT	10318850	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.120	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – HP4931 Frezare de canal

SMG		a_p/DC	f_z				v_c
			12	16	20	25	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1500 (800 — 2400) *4925 (2700 — 7800)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	960 (520 — 1600) *3150 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1400 (750 — 2300) *4600 (2500 — 7500)*

Parametri de așchiere – HP4931 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				12	16	20	25	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1825 (980 — 3000) *6000 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1175 (630 — 1900) *3850 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1700 (910 — 2800) *5575 (3000 — 9100)*

Parametri de așchiere – HP4931 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z				v_c
				1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1850 (990 — 3000) *6075 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1200 (640 — 1900) *3925 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1725 (930 — 2800) *5650 (3100 — 9100)*

Parametri de așchiere – HP4931 Frezare de canal – Inci

SMG		a_p/DC	f_z				v_c
			1/2	5/8	3/4	1	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1525 (810 — 2500) *5000 (2700 — 8200)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	980 (530 — 1600) *3225 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1425 (760 — 2300) *4675 (2500 — 7500)*

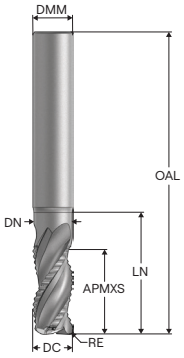
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

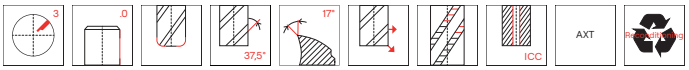
S4931

Uz general – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





– Toleranţe:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Reascuţire posibilă dacă DMM este ≥ Ø.375"

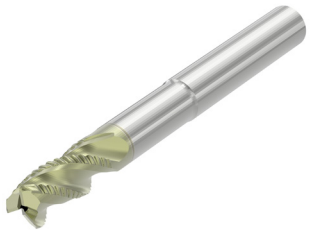


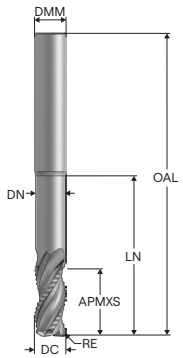
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm		
S4931-060E3R050.0Z3A	AXT	10318871	3	E	■	■	6,0	6,0	13,0	60,0	19,5	5,7	0,5	Cylindrical	■
S4931-080E3R050.0Z3A	AXT	10318873	3	E	■	■	8,0	8,0	18,0	65,0	26,0	7,6	0,5	Cylindrical	■
S4931-100E3R050.0Z3A	AXT	10318876	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	0,5	Cylindrical	■
S4931-100E3R100.0Z3A	AXT	10318879	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	1,0	Cylindrical	■
S4931-120E3R050.0Z3A	AXT	10318882	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	0,5	Cylindrical	■
S4931-120E3R100.0Z3A	AXT	10318885	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	1,0	Cylindrical	■
S4931-120E3R200.0Z3A	AXT	10318888	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	2,0	Cylindrical	■
S4931-120E3R300.0Z3A	AXT	10318891	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	3,0	Cylindrical	■
S4931-160E3R050.0Z3A	AXT	10318894	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	0,5	Cylindrical	■
S4931-160E3R100.0Z3A	AXT	10318897	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	1,0	Cylindrical	■
S4931-160E3R200.0Z3A	AXT	10318900	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	2,0	Cylindrical	■
S4931-160E3R300.0Z3A	AXT	10318903	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	3,0	Cylindrical	■
S4931-060E4R050.0Z3A	AXT	10318872	4	E	■	■	6,0	6,0	13,0	70,0	25,5	5,7	0,5	Cylindrical	■
S4931-080E4R050.0Z3A	AXT	10318874	4	E	■	■	8,0	8,0	18,0	80,0	34,0	7,6	0,5	Cylindrical	■
S4931-100E4R050.0Z3A	AXT	10318877	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	0,5	Cylindrical	■
S4931-100E4R100.0Z3A	AXT	10318880	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	1,0	Cylindrical	■
S4931-120E4R050.0Z3A	AXT	10318883	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	0,5	Cylindrical	■
S4931-120E4R100.0Z3A	AXT	10318886	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	1,0	Cylindrical	■
S4931-120E4R200.0Z3A	AXT	10318889	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	2,0	Cylindrical	■
S4931-120E4R300.0Z3A	AXT	10318892	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	3,0	Cylindrical	■
S4931-160E4R050.0Z3A	AXT	10318895	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	0,5	Cylindrical	■
S4931-160E4R100.0Z3A	AXT	10318898	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	1,0	Cylindrical	■
S4931-160E4R200.0Z3A	AXT	10318901	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	2,0	Cylindrical	■
S4931-160E4R300.0Z3A	AXT	10318904	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	3,0	Cylindrical	■
S4931-200E4R200.0Z3A	AXT	10336122	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	2,0	Cylindrical	■
S4931-200E4R300.0Z3A	AXT	10336123	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	3,0	Cylindrical	■
S4931-250E4R200.0Z3A	AXT	10336124	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	2,0	Cylindrical	■
S4931-250E4R300.0Z3A	AXT	10336125	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	3,0	Cylindrical	■

■ **Stoc standard.**

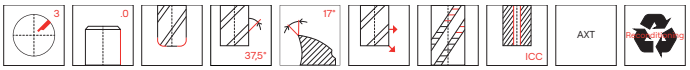
S4931

Uz general – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—DMM=-.0001"/-.0004"
—SIG= ±1°
—Reascuţire posibilă dacă DMM este ≥ Ø.375"

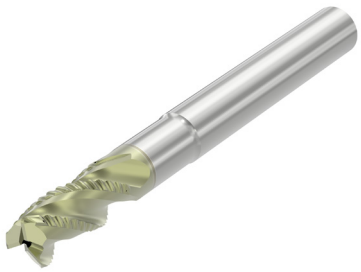


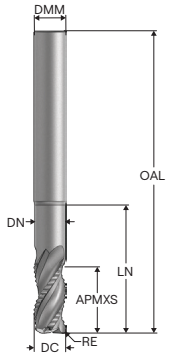
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							mm	mm	mm	mm	mm	mm	mm		
S4931-080E5R050.0Z3A	AXT	10318875	5	E	■	■	8,0	8,0	18,0	80,0	42,0	7,6	0,5	Cylindrical	■
S4931-100E5R050.0Z3A	AXT	10318878	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	0,5	Cylindrical	■
S4931-100E5R100.0Z3A	AXT	10318881	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	1,0	Cylindrical	■
S4931-120E5R050.0Z3A	AXT	10318884	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	0,5	Cylindrical	■
S4931-120E5R100.0Z3A	AXT	10318887	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	1,0	Cylindrical	■
S4931-120E5R200.0Z3A	AXT	10318890	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	2,0	Cylindrical	■
S4931-120E5R300.0Z3A	AXT	10318893	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	3,0	Cylindrical	■
S4931-160E5R050.0Z3A	AXT	10318896	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	0,5	Cylindrical	■
S4931-160E5R100.0Z3A	AXT	10318899	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	1,0	Cylindrical	■
S4931-160E5R200.0Z3A	AXT	10318902	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	2,0	Cylindrical	■
S4931-160E5R300.0Z3A	AXT	10318905	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	3,0	Cylindrical	■

■ **Stoc standard.**

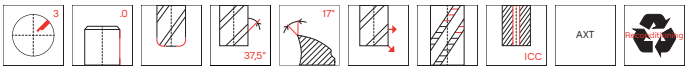
S4931

Uz general – Aluminiu – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf – Inci





– Toleranţe:
– DMM=h5
– DC -0.001"/-0.004"
– RE=+/-0.002"
– Reascuţire posibilă dacă DC este ≥ Ø.500



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Coada	Stoc standard
							inci	inci	inci	inci	inci	inci	inci		
S4931-.250E3R030.0Z3A	AXT	10318906	3	E	■	■	0.250	0.250	0.500	2.250	0.750	0.234	0.030	Cylindrical	■
S4931-.313E3R030.0Z3A	AXT	10318908	3	E	■	■	0.313	0.313	0.625	2.500	1.000	0.297	0.030	Cylindrical	■
S4931-.375E3R030.0Z3A	AXT	10318910	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.030	Cylindrical	■
S4931-.375E3R060.0Z3A	AXT	10318912	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.060	Cylindrical	■
S4931-.500E3R030.0Z3A	AXT	10318914	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.030	Cylindrical	■
S4931-.500E3R060.0Z3A	AXT	10318917	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.060	Cylindrical	■
S4931-.500E3R090.0Z3A	AXT	10318920	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.090	Cylindrical	■
S4931-.500E3R120.0Z3A	AXT	10318923	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.120	Cylindrical	■
S4931-.625E3R030.0Z3A	AXT	10318926	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.030	Cylindrical	■
S4931-.625E3R060.0Z3A	AXT	10318928	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.060	Cylindrical	■
S4931-.625E3R090.0Z3A	AXT	10318930	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.090	Cylindrical	■
S4931-.625E3R120.0Z3A	AXT	10318932	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.120	Cylindrical	■
S4931-.250E4R030.0Z3A	AXT	10318907	4	E	■	■	0.250	0.250	0.500	2.500	1.000	0.234	0.030	Cylindrical	■
S4931-.313E4R030.0Z3A	AXT	10318909	4	E	■	■	0.313	0.313	0.625	3.000	1.250	0.297	0.030	Cylindrical	■
S4931-.375E4R030.0Z3A	AXT	10318911	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.030	Cylindrical	■
S4931-.375E4R060.0Z3A	AXT	10318913	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.060	Cylindrical	■
S4931-.500E4R030.0Z3A	AXT	10318915	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.030	Cylindrical	■
S4931-.500E4R060.0Z3A	AXT	10318918	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.060	Cylindrical	■
S4931-.500E4R090.0Z3A	AXT	10318921	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.090	Cylindrical	■
S4931-.500E4R120.0Z3A	AXT	10318924	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.120	Cylindrical	■
S4931-.625E4R030.0Z3A	AXT	10318927	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.030	Cylindrical	■
S4931-.625E4R060.0Z3A	AXT	10318929	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.060	Cylindrical	■
S4931-.625E4R090.0Z3A	AXT	10318931	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.090	Cylindrical	■
S4931-.625E4R120.0Z3A	AXT	10318933	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.120	Cylindrical	■
S4931-.500E5R030.0Z3A	AXT	10318916	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.030	Cylindrical	■
S4931-.500E5R060.0Z3A	AXT	10318919	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.060	Cylindrical	■
S4931-.500E5R090.0Z3A	AXT	10318922	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.090	Cylindrical	■
S4931-.500E5R120.0Z3A	AXT	10318925	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.120	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – S4931 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	940 (360 — 1700) *3075 (1200 — 5500)*
N2	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	610 (230 — 1100) *2000 (760 — 3600)*
N3	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	940 (360 — 1700) *3075 (1200 — 5500)*

Parametri de așchiere – S4931 Frezare de canal

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*
N2	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	510 (200 — 960) *1675 (660 — 3100)*
N3	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*

Parametri de așchiere – S4931 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
N1	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*
N2	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	610 (240 — 1100) *2000 (790 — 3600)*
N3	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*

Parametri de așchiere – S4931 Frezare de canal – Inci

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
N1	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*
N2	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	520 (200 — 970) *1700 (660 — 3100)*
N3	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*

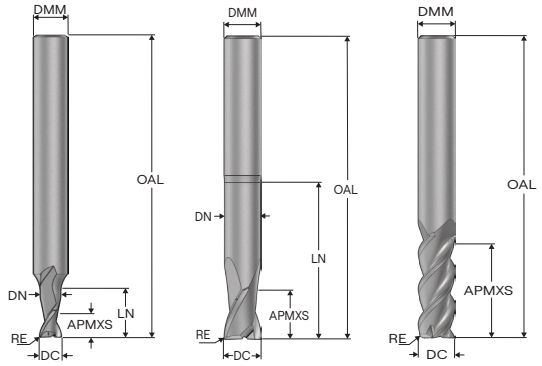
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

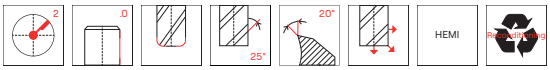
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH40

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf







– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,1 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

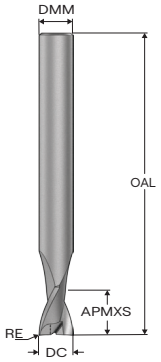
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	Cylindrical	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	Cylindrical	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	Cylindrical	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	Cylindrical	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	Cylindrical	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	Cylindrical	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	Cylindrical	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	Cylindrical	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	Cylindrical	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	Cylindrical	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	Cylindrical	■

■ **Stoc standard.**

JH40

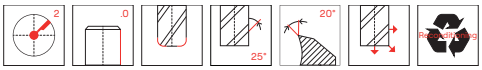
Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





P

- Toleranţe:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,1 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	0,1	2	Cylindrical	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	0,1	2	Cylindrical	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	0,1	2	Cylindrical	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	0,1	2	Cylindrical	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	0,1	2	Cylindrical	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	0,1	2	Cylindrical	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	0,1	2	Cylindrical	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	0,1	2	Cylindrical	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	0,1	2	Cylindrical	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	0,1	2	Cylindrical	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	0,1	2	Cylindrical	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	0,1	2	Cylindrical	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	0,1	2	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH40 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	425 (320 — 520) *1400 (1100 — 1700)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*

Parametri de aşchiere – JH40 Frezare de canal

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.0 *1,0*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*

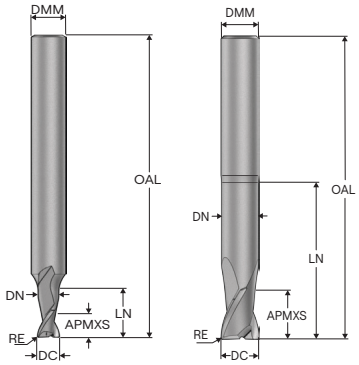
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH421

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf







– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

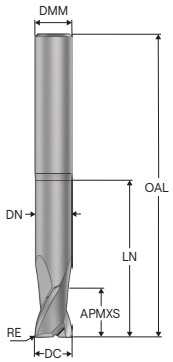
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	Cylindrical	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	Cylindrical	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	Cylindrical	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	Cylindrical	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	Cylindrical	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	Cylindrical	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	Cylindrical	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	Cylindrical	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	Cylindrical	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	Cylindrical	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	Cylindrical	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	Cylindrical	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	Cylindrical	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	Cylindrical	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	Cylindrical	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	Cylindrical	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	Cylindrical	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	Cylindrical	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	Cylindrical	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	Cylindrical	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	Cylindrical	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	Cylindrical	■

■ **Stoc standard.**
ICC = Canal de agent de răcire complet

JH421

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





E



– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Reascuţire posibilă

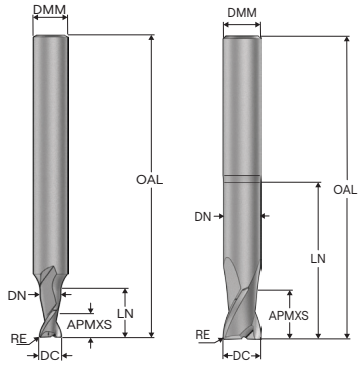
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	Cylindrical	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	Cylindrical	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	Cylindrical	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	Cylindrical	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	Cylindrical	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	Cylindrical	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	Cylindrical	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	Cylindrical	■

■ **Stoc standard.**
ICC = Canal de agent de răcire complet

JH421

Înaltă performanţă – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





- Toleranţe:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
421L080R020Z2-MEGA-T	02435068	3	E	–	8,0	8,0	6,0	75,0	40,0	7,2	0,2	2	Cylindrical	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	2	Cylindrical	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	2	Cylindrical	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	2	Cylindrical	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	2	Cylindrical	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	2	Cylindrical	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	2	Cylindrical	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	2	Cylindrical	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	2	Cylindrical	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	2	Cylindrical	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	2	Cylindrical	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	2	Cylindrical	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	2	Cylindrical	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	2	Cylindrical	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	2	Cylindrical	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	2	Cylindrical	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	2	Cylindrical	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	2	Cylindrical	■

■ **Stoc standard.**
ICC = Canal de agent de răcire complet

Parametri de aşchiere – JH421 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
N11	E/M/A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	410 (310 — 510)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*1350 (1100 — 1600)*
TS1	A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
TP1	M	0.400	1.0	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.16	0.18	0.20	0.24	410 (310 — 500)
		0,400	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*0,0070*	*0,0080*	*0,0095*	*1350 (1100 — 1600)*

Parametri de aşchiere – JH421 Frezare de canal

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
N11	E/M/A	0.50	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.10	405 (310 — 500)
		0,50	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0040*	*1325 (1100 — 1600)*
TS1	A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
TP1	M	0.50	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	405 (310 — 500)
		0,50	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1325 (1100 — 1600)*

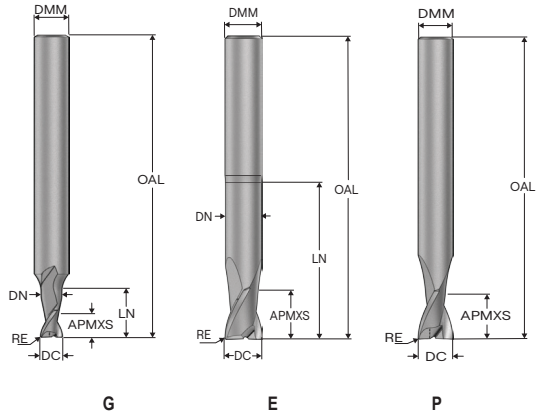
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

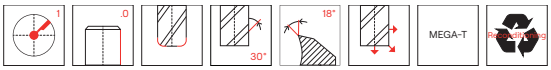
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH410

Înaltă performanţă – Aluminiu – Pătrat – 1 Canelură – Cilindrică – Rază la vârf







- Toleranţe:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm				
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	1,7	0,5	2,0	12,0	1	Cylindrical	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	2,7	0,5	2,0	7,5	1	Cylindrical	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	2,7	0,5	2,0	5,0	1	Cylindrical	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	3,6	0,5	2,0	5,5	1	Cylindrical	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	3,6	0,5	2,0	3,5	1	Cylindrical	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	4,5	0,5	2,0	2,5	1	Cylindrical	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	5,3	0,5	2,0	–	1	Cylindrical	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	5,3	0,5	2,0	–	1	Cylindrical	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	5,3	0,5	2,0	–	1	Cylindrical	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	–	0,5	3,0	–	1	Cylindrical	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	–	1,0	3,0	–	1	Cylindrical	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH410 Degroşare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*
N11	E/M/A	0.318 *0,318*	0.65 *0,65*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	495 (380 — 610) *1625 (1300 — 2000)*
TS1	A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*

Parametri de aşchiere – JH410 Frezare de canal

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	420 (320 — 520) *1375 (1100 — 1700)*
TS1	A	1.0 *1,0*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*

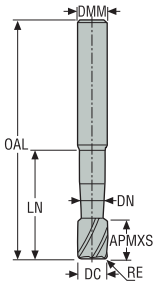
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH440

Viteză mare – Aluminiu – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





E

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,05 mm
—Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
440060-MEGA-T	00022702	2	E	6,0	6,0	8,0	60,0	30,0	5,4	1,5	2,09	2	Cylindrical	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	3,12	2	Cylindrical	■

Parametri de aşchiere – JH440 Degroşare pentru frezare prin copiere

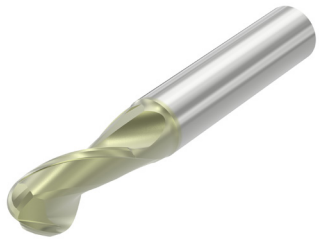
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	340 (260 — 420) *1125 (860 — 1300)*
N11	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	255 (130 — 370) *840 (430 — 1200)*
TS1	A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
TP1	A	0.300 *0,300*	0.60 *0,60*	0.060 *0,0024*	0.080 *0,0032*	510 (380 — 630) *1675 (1300 — 2000)*

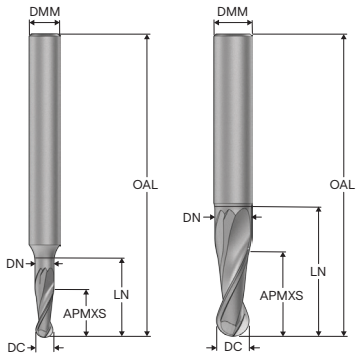
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

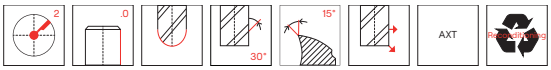
S4321

Înaltă performanţă – Aluminiu – Cap sferic – 2 Caneluri – Cilindrică





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,01 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

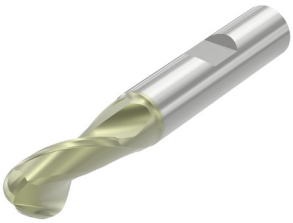


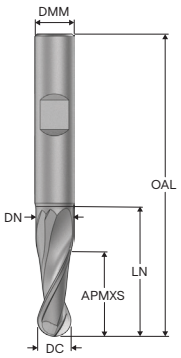
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4321-020G2B.0Z2	AXT	10228152	2	G	2,0	6,0	4,0	57,0	8,0	1,9	1,0	2	Cylindrical	■
S4321-030G2B.0Z2	AXT	10228153	2	G	3,0	6,0	6,0	57,0	10,0	2,85	1,5	2	Cylindrical	■
S4321-040G2B.0Z2	AXT	10228154	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2,0	2	Cylindrical	■
S4321-050G2B.0Z2	AXT	10228155	2	G	5,0	6,0	10,0	57,0	17,0	4,75	2,5	2	Cylindrical	■
S4321-060E2B.0Z2	AXT	10228156	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Cylindrical	■
S4321-080E2B.0Z2	AXT	10228157	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Cylindrical	■
S4321-100E2B.0Z2	AXT	10228158	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Cylindrical	■
S4321-120E2B.0Z2	AXT	10228159	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Cylindrical	■
S4321-160E2B.0Z2	AXT	10228160	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Cylindrical	■
S4321-200E2B.0Z2	AXT	10228161	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Cylindrical	■

■ **Stoc standard.**

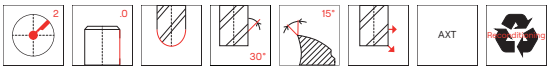
S4321

Înaltă performanţă – Aluminiu – Cap sferic – 2 Caneluri – Weldon





- Toleranţe:
- DMM=h5
- DC= e7
- RE= ±0,01 mm
- Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
S4321-060E2B.3Z2	AXT	10287043	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Weldon	☐
S4321-080E2B.3Z2	AXT	10287044	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Weldon	☐
S4321-100E2B.3Z2	AXT	10287045	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Weldon	☐
S4321-120E2B.3Z2	AXT	10287046	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Weldon	☐
S4321-160E2B.3Z2	AXT	10287047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Weldon	☐
S4321-200E2B.3Z2	AXT	10287048	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Weldon	☐

☐ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de așchiere – S4321 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0,30 *0.30*	1,5 *1.5*	0,020 *0.00080*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	560 (510 — 680) *1825 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	1,5 *1.5*	0,018 *0.00070*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	355 (270 — 440) *1175 (890 — 1400)*
N3	E/M/A	0,30 *0.30*	1,5 *1.5*	0,018 *0.00070*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	235 (180 — 290) *770 (600 — 950)*
TS1	A/D	0,30 *0.30*	1,5 *1.5*	0,022 *0.00085*	0,034 *0.0013*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,19 *0.0075*	670 (560 — 770) *2200 (1900 — 2500)*
TP1	A/D	0,30 *0.30*	1,5 *1.5*	0,0036 *0.00014*	0,0050 *0.00020*	0,0070 *0.00028*	0,0090 *0.00036*	0,010 *0.00040*	0,014 *0.00055*	0,018 *0.00070*	0,020 *0.00080*	0,028 *0.0011*	0,036 *0.0014*	460 (350 — 570) *1500 (1200 — 1800)*

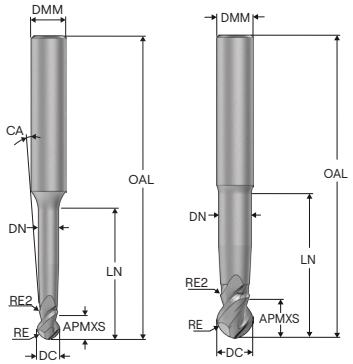
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH450

Viteză mare – Aluminiu – Cap sferic – 2 Caneluri – Cilindrică







– Toleranţe:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,02 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm					
450020-MEGA-T	00022977	2	G	2,0	3,0	1,75	40,0	10,0	1,8	1,0	1,0	3,0	2,24	2	Cylindrical	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	1,5	2,0	–	2,497	2	Cylindrical	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	2,0	3,0	5,053	2	Cylindrical	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,5	2,0	2,0	3,576	2	Cylindrical	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	3,0	2,0	–	2,465	2	Cylindrical	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	4,0	2,0	–	2,491	2	Cylindrical	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	5,0	3,0	–	3,086	2	Cylindrical	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	6,0	3,0	–	2,735	2	Cylindrical	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	8,0	4,0	–	3,45	2	Cylindrical	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	10,0	4,0	–	5,321	2	Cylindrical	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	5,0	3,0	1,5	3,16	2	Cylindrical	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	6,0	3,0	–	2,79	2	Cylindrical	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	8,0	4,0	–	3,51	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH450 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	470 (410 — 680) *1550 (1400 — 2200)*
N3	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	315 (280 — 450) *1025 (920 — 1400)*
N11	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (420 — 680) *1550 (1400 — 2200)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	700 (630 — 860) *2300 (2100 — 2800)*
TP1	M	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (410 — 680) *1550 (1400 — 2200)*

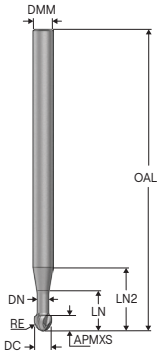
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

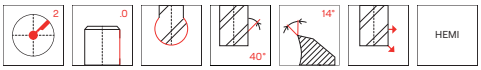
JH460

Viteză mare – Aluminiu – Cap sferic – 2 Caneluri – Cilindrică





E



– Toleranţe:
– DMM=h5
– DC=-0,02/-0,06 mm
– RE= ±0.02 mm
– SA=250°

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	1,5	1,5	2	Cylindrical	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	2,0	2,0	2	Cylindrical	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	2,5	2,5	2	Cylindrical	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	3,0	3,0	2	Cylindrical	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	4,0	4,0	2	Cylindrical	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	5,0	5,0	2	Cylindrical	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	6,0	6,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH460 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
S11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	120 (110 — 130) *395 (370 — 420)*
S12	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	90 (82 — 100) *295 (270 — 320)*
S13	E/M/A	0.300 *0,300*	0.20 *0,20*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	75 (65 — 81) *245 (220 — 260)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.13 *0,0050*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	620 (520 — 720) *2025 (1800 — 2300)*
TP1	M	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	405 (360 — 450) *1325 (1200 — 1400)*

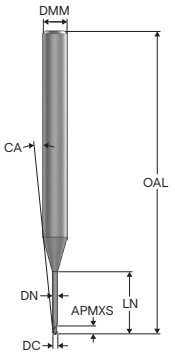
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

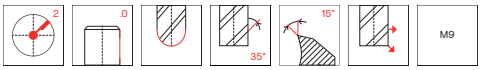
SMB413/414/416

Miniatură – Aluminiu – Cap sferic – 2 Caneluri – Cilindrică





G



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC = 0/-0,01 mm
—RE = ±0,005 mm

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
SMB414020G4B.0Z2	M9	10109139	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,75	2	Cylindrical	■
SMB414030G4B.0Z2	M9	10109140	4	G	3,0	4,0	3,0	50,0	16,0	2,85	1,5	1,68	2	Cylindrical	■
SMB413025G5B.0Z2	M9	10109136	5	G	2,5	3,0	2,5	50,0	20,0	2,4	1,25	0,71	2	Cylindrical	■
SMB414025G5B.0Z2	M9	10109141	5	G	2,5	4,0	2,5	50,0	20,0	2,4	1,25	1,94	2	Cylindrical	■
SMB416025G5B.0Z2	M9	10109145	5	G	2,5	6,0	1,0	55,0	20,0	0,95	1,25	3,87	2	Cylindrical	■
SMB414010G6B.0Z2	M9	10109142	6	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB413015G6B.0Z2	M9	10109137	6	G	1,5	3,0	1,5	50,0	20,0	1,4	0,75	1,9	2	Cylindrical	■
SMB414015G6B.0Z2	–	10109388	6	G	1,5	4,0	2,5	55,0	20,0	2,4	0,75	2,92	2	Cylindrical	■
SMB414015G6B.0Z2	M9	10109143	6	G	1,5	4,0	1,5	55,0	20,0	1,4	0,75	2,92	2	Cylindrical	■
SMB416015G6B.0Z2	M9	10109146	6	G	1,5	6,0	1,5	55,0	20,0	1,4	0,75	4,56	2	Cylindrical	■
SMB413010G7B.0Z2	M9	10109138	7	G	1,0	3,0	1,0	50,0	18,0	0,95	0,5	2,63	2	Cylindrical	■
SMB414010G7B.0Z2	M9	10109144	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■
SMB416010G7B.0Z2	M9	10109147	7	G	1,0	6,0	1,0	55,0	18,0	0,95	0,5	5,23	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – SMB413 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

Parametri de așchiere – SMB414 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				1	1.5	2	2.5	3	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*

Parametri de așchiere – SMB416 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

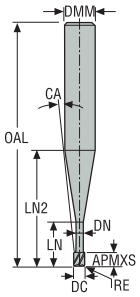
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JM403/JM404/JM406

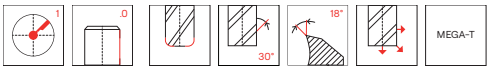
Miniatură – Aluminiu – Pătrat – 1 Canelură – Cilindrică – Rază la vârf





G

—Toleranţe:
—Bătaie radială=<0,005 mm
—DMM= h5
—DC= < Ø0,6= -0,005/-0,013 mm
—DC= ≥ Ø0,6= -0,005/-0,015 mm
—RE= ±0,01 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	0,45	0,05	11,0	1	Cylindrical	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	0,75	0,05	9,0	1	Cylindrical	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	0,95	0,1	7,5	1	Cylindrical	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	1,4	0,1	9,5	1	Cylindrical	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	1,9	0,1	6,0	1	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JM403/JM404/406 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	0.8	1	1.5	2	
N1	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	365 (310 — 420) *1200 (1100 — 1300)*
N2	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	235 (200 — 270) *770 (660 — 880)*
N3	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	155 (140 — 180) *510 (460 — 590)*

Parametri de așchiere – JM403/JM404/406 Frezare de canal

SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890 — 1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560 — 750)*
N3	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	135 (120 — 150) *445 (400 — 490)*

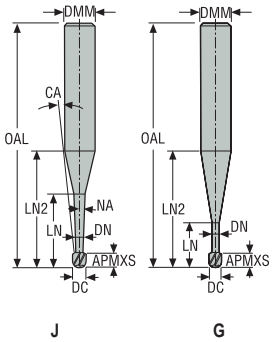
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

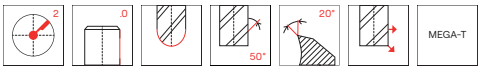
JM413/JM416

Miniatură – Aluminiu – Cap sferic – 2 Canelură – Cilindrică





—Toleranţe:
—Bătaie radială=<0,005 mm
—DMM=h5
—DC= < Ø 0,6= -0,005/-0,013 mm
—DC= ≥ Ø 0,6= -0,005/-0,015 mm
—RE= ±0,005 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	0,45	0,25	11,5	0,9	2	Cylindrical	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	0,45	0,25	10,0	–	2	Cylindrical	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	0,75	0,4	8,0	–	2	Cylindrical	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	0,95	0,5	7,0	–	2	Cylindrical	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	1,4	0,75	8,5	–	2	Cylindrical	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	1,9	1,0	7,0	–	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JM413/416 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				0,5	0.8	1	1.5	2	
N1	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
N2	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	245 (240 — 320) *800 (790 — 1000)*
N3	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	165 (160 — 210) *540 (530 — 680)*
N11	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	320 (300 — 430) *1050 (990 — 1400)*
TS1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
TP1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



MATERIALE DURE

Seco oferă o gamă completă de freze cilindro-frontale din carbură solidă de înaltă performanţă pentru frezare cilindro-frontală, freze cu cap rotund și freze cilindro-frontale de finisare pentru productivitate ridicată pentru oţel călit.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 și JME144 pentru tip rază.
- JH112, JH150, JH160 și JMB112 pentru tip cu cap rotund.

Alegerea uneltei - Materiale dure

							
Nume		JHP170	JHF181	JH120	JH130	JH930	JH142
Pag.		501	504	507	509	226, 511	303, 514
Familia		HPM	HFM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon	■					
Numărul de dinţi		3-4	3-4-5	4	5-6, 8	5-6, 8	2-4-5-6
CSP			■				
	Metric	2-20	1-10	2-16	6-20	6-20	2-12
	Inch						
Lungimi disponibile		2	1,2,3,4	2	2	2	2,3,6
Operaţiune							
							
							
SMG							
H3		•	•	•	•	•	•
H5		•	•	•	•	•	•
H7		•	•	•	•	•	•
H8		•	•	•	•	•	•
H11		•	•	•	•	•	
H12		•	•	•	•	•	
H21		•	•	•	•	•	•
H31		•	•	•	•	•	•

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
• Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Materiale dure

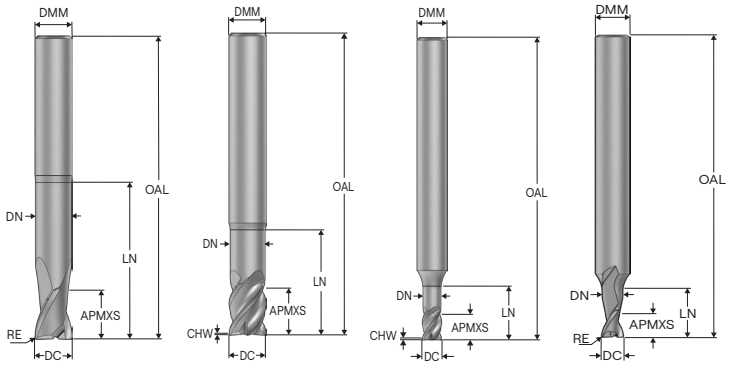
							
Nume		JH112	JH150	JH160	JME142	JME144	JMB112
Pag.		313, 517	520	522	524	529	531
Familia		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon						
Numărul de dinţi		2	4	4	2	4	2
CSP							
	Metric	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Inch						
Lungimi disponibile		1,2,3,4,5,6	2	2	1,2,3,4,5,6	2,3,4	1,2,3,4,5,6
Operaţiune							
							
							
SMG							
H3		•	•	•	•	•	•
H5		•	•	•	•	•	•
H7		•	•	•	•	•	•
H8		•	•	•	•	•	•
H11			•	•	•	•	•
H12			•	•	•	•	•
H21		•	•	•	•	•	•
H31		•	•	•	•	•	•

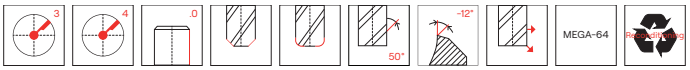
■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
• Opţiune preferată ○ Opţiune alternativă

JHP170

Înaltă performanţă – Oţel călit – Pătrat – 3-4 Caneluri – Cilindrică – Raza la colţ sau șanfrenul







—Toleranţe:
—DMM= h5
—DC= -0,02/-0,04 mm
—CHW= Ø2- Ø4=+0,05 mm
—CHW= Ø5-Ø16=+0,1 mm
—RE= ±0,05 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

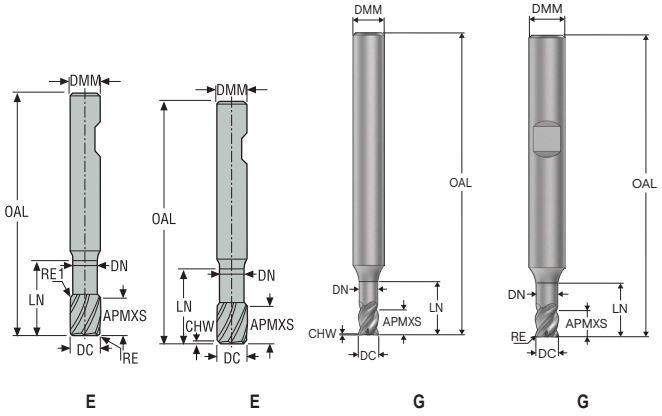
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm				
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	Cylindrical	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	Cylindrical	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	Cylindrical	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Cylindrical	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	Cylindrical	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	Cylindrical	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Cylindrical	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	Cylindrical	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	Cylindrical	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Cylindrical	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	Cylindrical	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	Cylindrical	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Cylindrical	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Cylindrical	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Cylindrical	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Cylindrical	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Cylindrical	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Cylindrical	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Cylindrical	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Cylindrical	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Cylindrical	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Cylindrical	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Cylindrical	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Cylindrical	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Cylindrical	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Cylindrical	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Cylindrical	■

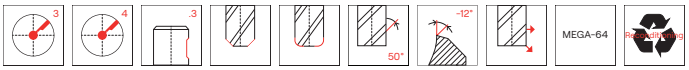
■ **Stoc standard.**

JHP170

Înaltă performanţă – Oţel călit – Pătrat – 3-4 Caneluri – Weldon – Raza la colţ sau șanfrenul







- Toleranţe:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2-Ø4=+0,05 mm
- CHW= Ø5-Ø16= +0,1 mm
- RE= ±0,05 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm	mm				
170020-MEGA-64	02452924	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	Weldon	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	Weldon	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	Weldon	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Weldon	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	Weldon	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	Weldon	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Weldon	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	Weldon	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	Weldon	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Weldon	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	Weldon	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	Weldon	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Weldon	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Weldon	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Weldon	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Weldon	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Weldon	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Weldon	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Weldon	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Weldon	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Weldon	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Weldon	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Weldon	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Weldon	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Weldon	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Weldon	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Weldon	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	Weldon	■

■ **Stoc standard.** □ Weldon disponibil. Intervalul de livrare este de 3 zile.

Parametri de aşchiere – JHP170 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
H3	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H5	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*
H7	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H8	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H11	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (71 — 86) *260 (240 — 280)*
H12	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	75 (69 — 83) *245 (230 — 270)*
H21	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H31	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*

Parametri de aşchiere – JHP170 Frezare de canal

SMG		a_p/DC	f_z									v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*
H7	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H8	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H11	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	65 (58 — 70) *215 (200 — 220)*
H12	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	60 (53 — 64) *195 (180 — 200)*
H21	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H31	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*

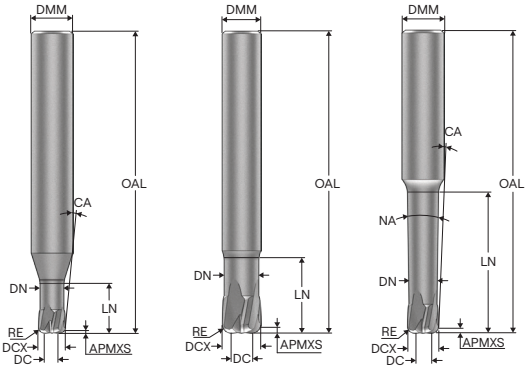
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

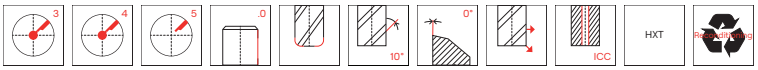
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JHF181

Avans mare – Oţel călit – Pătrat – 3-5 Caneluri – Cilindrică – Rază la vârf







– Toleranţe:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,01 mm
– Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm	mm					
JHF181020G1R050.0Z4-HXT	03067297	1	G	–	2,0	1,0	6,0	0,5	50,0	4,0	1,8	0,5	10,0	–	4	Cylindrical	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	0,75	7,5	–	4	Cylindrical	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	1,0	5,0	–	4	Cylindrical	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	5	Cylindrical	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	5	Cylindrical	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	3,0	–	–	4	Cylindrical	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	0,5	7,5	–	4	Cylindrical	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	0,75	5,0	–	4	Cylindrical	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	1,0	3,0	–	4	Cylindrical	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,5	6,8	0,9	4	Cylindrical	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,75	4,4	0,9	4	Cylindrical	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	1,0	2,6	0,9	4	Cylindrical	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	1,5	1,9	0,9	4	Cylindrical	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	2,0	1,5	0,9	4	Cylindrical	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	2,0	1,2	0,9	4	Cylindrical	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,5	5,6	0,9	3	Cylindrical	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,75	3,4	0,9	3	Cylindrical	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	1,0	2,0	0,9	3	Cylindrical	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	1,5	1,4	0,9	3	Cylindrical	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	2,0	1,1	0,9	3	Cylindrical	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	2,0	0,9	0,9	3	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JHF181 Degroşare prin frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z								v_c
				2	3	4	6	8	10	12	16	
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	305 (290 — 320) *1000 (960 — 1000)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	290 (270 — 300) *950 (890 — 980)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	270 (260 — 290) *890 (860 — 950)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	280 (270 — 290) *920 (890 — 950)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 240) *690 (630 — 780)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	185 (160 — 200) *610 (530 — 650)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	155 (140 — 170) *510 (460 — 550)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	150 (130 — 160) *490 (430 — 520)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	150 (120 — 170) *490 (400 — 550)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	220 (180 — 260) *720 (600 — 850)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	190 (160 — 220) *620 (530 — 720)*
S1	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	60 (40 — 79) *195 (140 — 250)*
S2	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	48 (33 — 64) *155 (110 — 200)*
S3	E	0.18 *0,18*	0.014 *0,014*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	42 (28 — 55) *140 (92 — 180)*
S11	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	200 (180 — 220) *660 (600 — 720)*
S12	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	155 (140 — 170) *510 (460 — 550)*
S13	E	0.18 *0,18*	0.034 *0,034*	0.032 *0,0013*	0.046 *0,0018*	0.065 *0,0026*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.24 *0,0095*	125 (110 — 130) *410 (370 — 420)*
H3	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H5	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H7	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H8	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H11	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 230) *690 (630 — 750)*
H12	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	190 (180 — 210) *620 (600 — 680)*
H21	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H31	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	125 (120 — 130) *410 (400 — 420)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JHF181 Frezare de canal

SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	255 (240 — 270) *840 (790 — 880)*
P8	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	240 (230 — 250) *790 (760 — 820)*
P11	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	250 (240 — 260) *820 (790 — 850)*
K1	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 210) *610 (560 — 680)*
K2	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	130 (110 — 150) *425 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	48 (33 — 64) *155 (110 — 200)*
S2	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	39 (26 — 51) *130 (86 — 160)*
S3	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	33 (23 — 44) *110 (76 — 140)*
S11	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	170 (150 — 190) *560 (500 — 620)*
S12	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	130 (120 — 140) *425 (400 — 450)*
S13	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	100 (89 — 110) *330 (300 — 360)*
H3	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H5	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H7	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H8	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H11	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 200) *610 (560 — 650)*
H12	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	170 (160 — 180) *560 (530 — 590)*
H21	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H31	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	110 (98 — 120) *360 (330 — 390)*

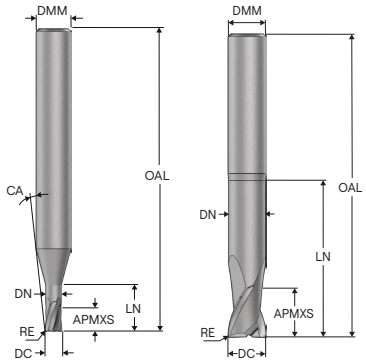
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

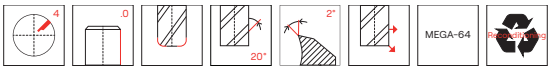
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH120

Viteză mare – Oţel călit – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—DMM=h5
—DC=-0,02/-0,03 mm
—RE= ±0,01 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
120020-MEGA-64	00019437	2	G	2,0	6,0	2,5	50,0	5,0	1,9	0,2	10,5	4	Cylindrical	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	Cylindrical	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	Cylindrical	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	Cylindrical	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	Cylindrical	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	Cylindrical	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	Cylindrical	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	Cylindrical	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	Cylindrical	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	Cylindrical	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH120 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H7	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	275 (230 — 320) *900 (760 — 1000)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	250 (210 — 290) *820 (690 — 950)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	135 (120 — 150) *445 (400 — 490)*

Parametri de așchiere – JH120 Frezare de canal

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H5	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	120 (98 — 140) *395 (330 — 450)*
H7	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H8	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H11	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	145 (120 — 170) *475 (400 — 550)*
H21	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H31	M	0.18 *0,18*	0.0055 *0,00022*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (70 — 92) *260 (230 — 300)*

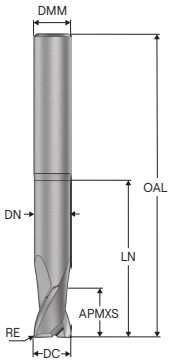
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH130

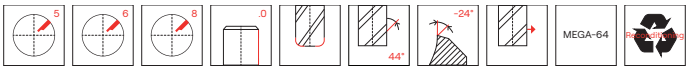
Viteză mare – Oţel călit – Pătrat – 5-8 Caneluri – Cilindrică – Rază la vârf





E

- Toleranţe:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
130060-MEGA-64	00019504	2	E	6,0	6,0	6,0	55,0	12,0	5,6	0,2	5	Cylindrical	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	Cylindrical	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	Cylindrical	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	Cylindrical	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	Cylindrical	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH130 Finisare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

Parametri de așchiere – JH130 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

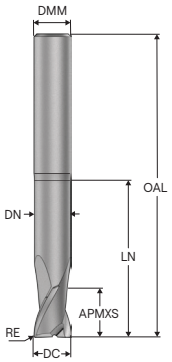
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH930

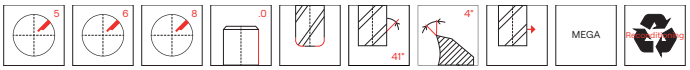
Viteză mare – Universale – Pătrat – 5-8 Caneluri – Cilindrică – Rază la vârf





E

- Toleranţe:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Reascuţire posibilă



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH930 Frezare laterală

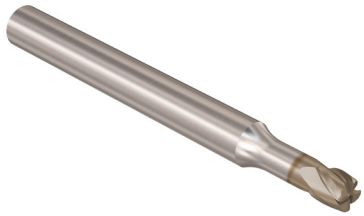
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

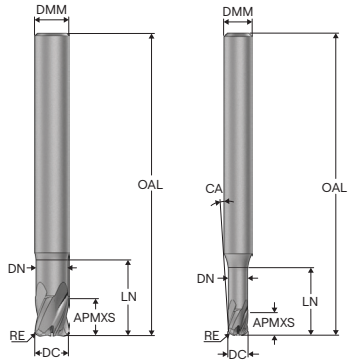
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH142

Viteză mare – Precizie ridicată – Toric – Oţel călit – 2-6 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

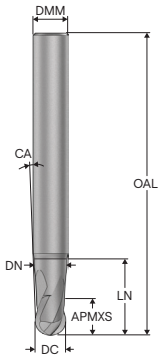
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	Cylindrical	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	Cylindrical	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	Cylindrical	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	Cylindrical	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	Cylindrical	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	Cylindrical	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	Cylindrical	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	Cylindrical	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	Cylindrical	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	Cylindrical	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	Cylindrical	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	Cylindrical	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	Cylindrical	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	Cylindrical	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	Cylindrical	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	Cylindrical	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	Cylindrical	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	Cylindrical	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	Cylindrical	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	Cylindrical	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	Cylindrical	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	Cylindrical	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	Cylindrical	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	Cylindrical	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	Cylindrical	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	Cylindrical	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	Cylindrical	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	Cylindrical	■

■ **Stoc standard.**

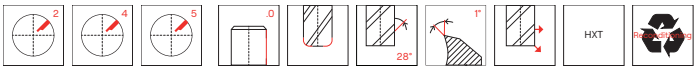
JH142

Viteză mare – Precizie ridicată – Toric – Oţel călit – 2-5 Caneluri – Cilindrică – Rază la vârf





J



- Toleranţe:
- Bătaie radială= <0,005 mm
- DMM= h5
- DC 0-0,01 mm
- RE= ±0,005 mm
- Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	2	Cylindrical	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	4	Cylindrical	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	2	Cylindrical	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	4	Cylindrical	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	2	Cylindrical	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	4	Cylindrical	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	2	Cylindrical	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	4	Cylindrical	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	2	Cylindrical	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	4	Cylindrical	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	2	Cylindrical	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	4	Cylindrical	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	2	Cylindrical	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	4	Cylindrical	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	4	Cylindrical	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	5	Cylindrical	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	4	Cylindrical	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	5	Cylindrical	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	0,9	5	Cylindrical	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	0,9	5	Cylindrical	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	0,9	5	Cylindrical	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	0,9	5	Cylindrical	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	0,9	5	Cylindrical	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	0,9	5	Cylindrical	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	0,9	5	Cylindrical	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	0,9	5	Cylindrical	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	0,9	5	Cylindrical	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	0,9	4	Cylindrical	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	0,9	4	Cylindrical	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	0,9	4	Cylindrical	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	0,9	4	Cylindrical	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	0,9	4	Cylindrical	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	0,9	4	Cylindrical	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	0,9	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH142 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

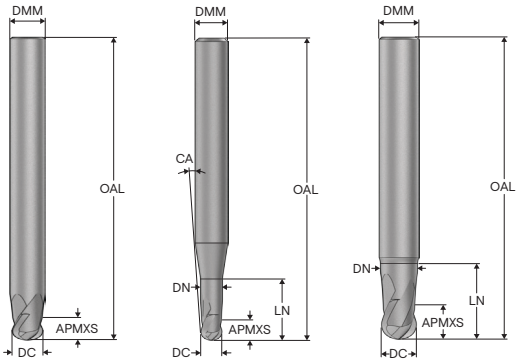
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

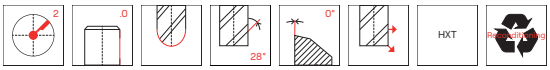
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH112

Viteză mare – Precizie ridicată – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

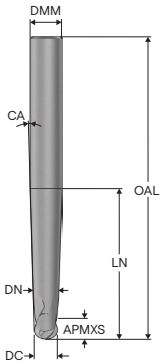
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Stoc standard.**

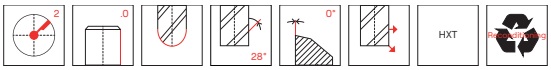
JH112

Viteză mare – Precizie ridicată – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică





J



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC 0-0,01 mm
—RE= ±0,005 mm
—Reascuţire posibilă dacă DC este ≥ Ø6

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JH112 Finisare frezare prin copiere

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – JH112 Degroşare pentru frezare prin copiere

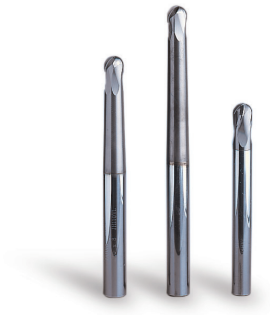
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

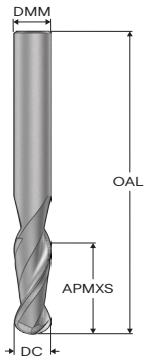
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

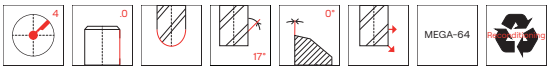
JH150

Viteză mare – Oţel călit – Cap sferic – 4 Caneluri – Cilindrică





D



—Toleranţe:
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,01 mm
—Reascuţire posibilă

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH150 Degroşare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

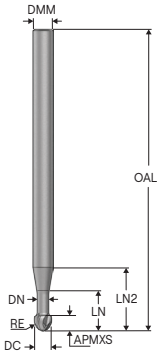
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JH160

Viteză mare – Oţel călit – Cap sferic – 4 Caneluri – Cilindrică





E

—Toleranţe:
—DMM= h5
—DC= 0,02/-0,06 mm
—SA=250°



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de aşchiere – JH160 Finisare frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

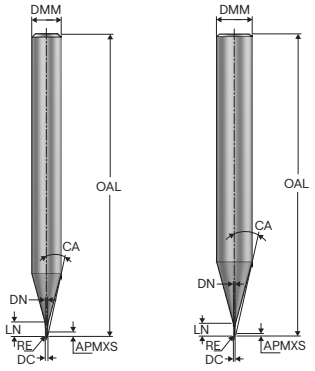
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

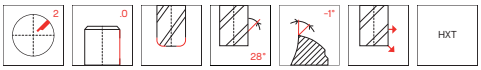
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JME142

Miniatură – Oţel călit – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC= < Ø0,6= 0/-0,008 mm
—DC= ≥ Ø0,6= 0/-0,01 mm
—RE = ±0,005 mm

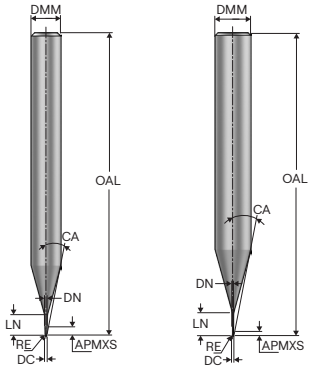
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	15,12	–	-1,0	2	Cylindrical	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	14,77	–	-1,0	2	Cylindrical	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	14,39	–	-1,0	2	Cylindrical	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	14,01	–	-1,0	2	Cylindrical	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	13,67	–	-1,0	2	Cylindrical	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	13,98	–	-1,0	2	Cylindrical	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	13,49	–	-1,0	2	Cylindrical	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	13,02	–	-1,0	2	Cylindrical	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	12,3	–	-1,0	2	Cylindrical	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	14,23	0,9	-1,0	2	Cylindrical	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	13,67	0,9	-1,0	2	Cylindrical	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	13,1	0,9	-1,0	2	Cylindrical	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	12,54	0,9	-1,0	2	Cylindrical	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	12,61	0,9	-1,0	2	Cylindrical	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	13,5	–	-1,0	2	Cylindrical	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	13,55	–	-1,0	2	Cylindrical	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	11,76	0,9	-1,0	2	Cylindrical	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	11,83	0,9	-1,0	2	Cylindrical	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	9,48	–	-1,0	2	Cylindrical	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	9,51	–	-1,0	2	Cylindrical	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	10,92	0,9	-1,0	2	Cylindrical	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	10,98	0,9	-1,0	2	Cylindrical	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	11,1	0,9	-1,0	2	Cylindrical	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	9,15	–	-1,0	2	Cylindrical	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	9,17	–	-1,0	2	Cylindrical	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	9,22	–	-1,0	2	Cylindrical	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	8,29	–	-1,0	2	Cylindrical	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	8,31	–	-1,0	2	Cylindrical	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	8,36	–	-1,0	2	Cylindrical	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	7,97	–	-1,0	2	Cylindrical	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	7,99	–	-1,0	2	Cylindrical	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	8,04	–	-1,0	2	Cylindrical	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	7,6	–	-1,0	2	Cylindrical	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	9,7	–	-1,0	2	Cylindrical	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	9,76	–	-1,0	2	Cylindrical	■

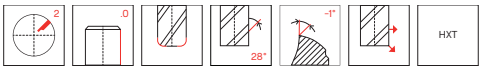
■ **Stoc standard.**

JME142

Miniatură – Oţel călit – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC= < Ø0,6= 0/-0,008 mm
—DC= ≥ Ø0,6= 0/-0,01 mm
—RE = ±0,005 mm

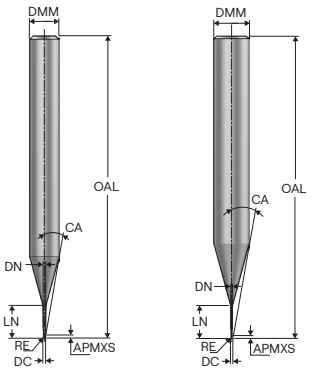
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	8,52	–	-1,0	2	Cylindrical	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	8,55	–	-1,0	2	Cylindrical	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	8,6	–	-1,0	2	Cylindrical	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	8,66	–	-1,0	2	Cylindrical	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	5,81	–	-1,0	2	Cylindrical	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	11,24	0,9	-1,0	2	Cylindrical	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	11,29	0,9	-1,0	2	Cylindrical	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	11,55	–	-1,0	2	Cylindrical	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	11,59	–	-1,0	2	Cylindrical	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	10,58	0,9	-1,0	2	Cylindrical	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	10,63	0,9	-1,0	2	Cylindrical	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	8,46	–	-1,0	2	Cylindrical	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	8,48	–	-1,0	2	Cylindrical	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	9,36	0,9	-1,0	2	Cylindrical	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	9,89	–	-1,0	2	Cylindrical	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	8,84	–	-1,0	2	Cylindrical	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	8,86	–	-1,0	2	Cylindrical	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	8,91	–	-1,0	2	Cylindrical	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	7,05	–	-1,0	2	Cylindrical	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	7,06	–	-1,0	2	Cylindrical	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	7,1	–	-1,0	2	Cylindrical	■

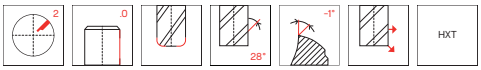
■ **Stoc standard.**

JME142

Miniatură – Oţel călit – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC= < Ø0,6= 0/-0,008 mm
—DC= ≥ Ø0,6= 0/-0,01 mm
—RE = ±0,005 mm

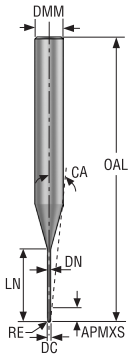
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	5,9	–	-1,0	2	Cylindrical	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	5,92	–	-1,0	2	Cylindrical	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	5,95	–	-1,0	2	Cylindrical	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	4,15	–	-1,0	2	Cylindrical	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	9,76	0,9	-1,0	2	Cylindrical	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	10,42	–	-1,0	2	Cylindrical	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	10,45	–	-1,0	2	Cylindrical	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	8,79	0,9	-1,0	2	Cylindrical	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	8,49	–	-1,0	2	Cylindrical	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	7,48	–	-1,0	2	Cylindrical	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	7,52	–	-1,0	2	Cylindrical	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	6,62	–	-1,0	2	Cylindrical	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	6,65	–	-1,0	2	Cylindrical	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	5,55	–	-1,0	2	Cylindrical	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	5,58	–	-1,0	2	Cylindrical	■

■ **Stoc standard.**

JME142

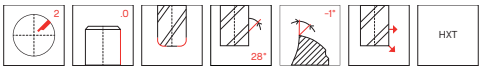
Miniatură – Oţel călit – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





G

—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC= < Ø0,6= 0/-0,008 mm
—DC= ≥ Ø0,6= 0/-0,01 mm
—RE = ±0,005 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	4,19	-1,0	2	Cylindrical	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	4,21	-1,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JME142 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1,5	1,8	2	2,5	3	
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H5	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H8	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (170 — 240) *670 (560 — 780)*
H12	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (110 — 140) *395 (370 — 450)*

Parametri de așchiere – JME142 Frezare de canal

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H5	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H7	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H8	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H11	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (98 — 140) *395 (330 — 450)*
H31	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	90 (73 — 100) *295 (240 — 320)*

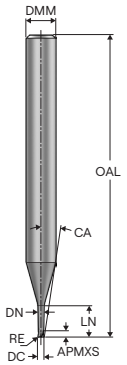
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JME144

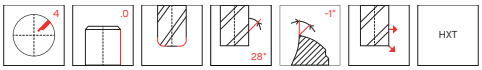
Miniatură – Oţel călit – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





J

—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM=h5
—DC = 0-0,01 mm
—RE= ±0,005 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JME144010J2R005Z4.0-HXT	03205214	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,05	9,08	0,9	-1,0	4	Cylindrical	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	9,13	0,9	-1,0	4	Cylindrical	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	9,22	0,9	-1,0	4	Cylindrical	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	7,52	0,9	-1,0	4	Cylindrical	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	7,56	0,9	-1,0	4	Cylindrical	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	7,63	0,9	-1,0	4	Cylindrical	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	5,97	0,9	-1,0	4	Cylindrical	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	6,0	0,9	-1,0	4	Cylindrical	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	6,12	0,9	-1,0	4	Cylindrical	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	2,66	0,9	-1,0	4	Cylindrical	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	2,69	0,9	-1,0	4	Cylindrical	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	8,3	0,9	-1,0	4	Cylindrical	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	4,29	0,9	-1,0	4	Cylindrical	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	4,31	0,9	-1,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JME144 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				1.0	1.2	1.5	2.0	3	
H3	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	210 (180 — 240) *690 (600 — 780)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	125 (110 — 140) *410 (370 — 450)*

Parametri de așchiere – JME144 Frezare de canal

SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H7	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H8	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H11	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H31	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	90 (73 — 100) *295 (240 — 320)*

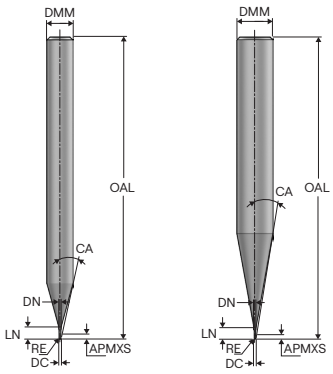
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

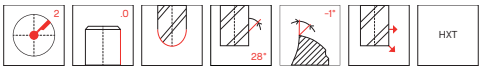
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JMB112

Miniatură – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC <Ø0,6= 0/-0,008 mm
—DC ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

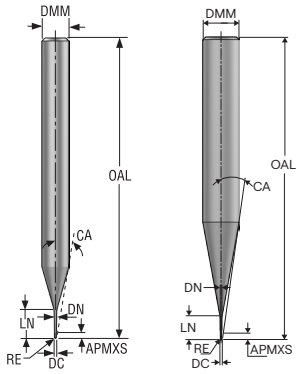
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	15,11	–	-1,0	2	Cylindrical	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	14,77	–	-1,0	2	Cylindrical	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	14,32	–	-1,0	2	Cylindrical	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	13,97	–	-1,0	2	Cylindrical	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	13,64	–	-1,0	2	Cylindrical	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	13,96	–	-1,0	2	Cylindrical	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	13,49	–	-1,0	2	Cylindrical	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	13,02	–	-1,0	2	Cylindrical	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	12,2	–	-1,0	2	Cylindrical	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	14,33	0,9	-1,0	2	Cylindrical	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	13,85	0,9	-1,0	2	Cylindrical	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	13,3	0,9	-1,0	2	Cylindrical	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	12,85	0,9	-1,0	2	Cylindrical	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	9,91	–	-1,0	2	Cylindrical	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	12,09	0,9	-1,0	2	Cylindrical	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	9,62	–	-1,0	2	Cylindrical	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	11,34	0,9	-1,0	2	Cylindrical	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	9,33	–	-1,0	2	Cylindrical	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	9,49	0,9	-1,0	2	Cylindrical	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	8,49	–	-1,0	2	Cylindrical	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	8,83	0,9	-1,0	2	Cylindrical	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	8,21	–	-1,0	2	Cylindrical	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	8,1	0,9	-1,0	2	Cylindrical	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,14	–	-1,0	2	Cylindrical	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	6,6	0,9	-1,0	2	Cylindrical	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,1	–	-1,0	2	Cylindrical	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	3,04	0,9	-1,0	2	Cylindrical	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,35	–	-1,0	2	Cylindrical	■

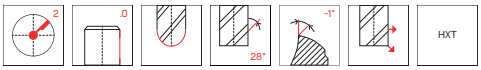
■ **Stoc standard.**

JMB112

Miniatură – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică







—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC <Ø0,6= 0/-0,008 mm
—DC ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

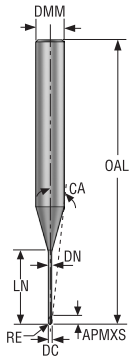
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm						
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	11,49	0,9	-1,0	2	Cylindrical	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	8,81	–	-1,0	2	Cylindrical	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	10,83	0,9	-1,0	2	Cylindrical	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	8,56	–	-1,0	2	Cylindrical	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	9,67	0,9	-1,0	2	Cylindrical	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	10,1	–	-1,0	2	Cylindrical	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	8,6	0,9	-1,0	2	Cylindrical	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	–	-1,0	2	Cylindrical	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,65	0,9	-1,0	2	Cylindrical	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	8,42	–	-1,0	2	Cylindrical	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	6,4	0,9	-1,0	2	Cylindrical	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	7,31	–	-1,0	2	Cylindrical	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,61	0,9	-1,0	2	Cylindrical	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	6,19	–	-1,0	2	Cylindrical	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	1,91	0,9	-1,0	2	Cylindrical	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	4,41	–	-1,0	2	Cylindrical	■

■ **Stoc standard.**

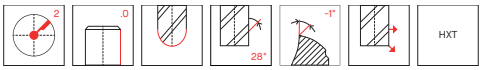
JMB112

Miniatură – Oţel călit – Cap sferic – 2 Caneluri – Cilindrică





G



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC <Ø0,6= 0/-0,008 mm
—DC ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm					
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,86	-1,0	2	Cylindrical	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,65	-1,0	2	Cylindrical	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	-1,0	2	Cylindrical	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	5,7	-1,0	2	Cylindrical	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	4,68	-1,0	2	Cylindrical	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	2,51	-1,0	2	Cylindrical	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	-1,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JMB112 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H5	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (200 — 240) *720 (660 — 780)*
H7	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H8	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H11	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 310) *920 (830 — 1000)*
H12	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	255 (230 — 280) *840 (760 — 910)*
H21	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H31	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.036 *0,0014*	0.042 *0,0017*	0.044 *0,0017*	165 (150 — 180) *540 (500 — 590)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



PLASTIC ȘI CFRP

Seco prezintă o gamă completă de freze cilindro-frontale din carbură solidă pentru prelucrarea sticlei și plasticului ranforsat cu fibră de carbon. Cuprinde freze cilindro-frontale din carbură solidă și diamant policristalin acoperite cu diamant și neacoperite, cu diverse
geometrii, precum și freze cu muchii brazate cu diamant policristalin. Această familie de produse oferă scule optimizate pentru condiţii de aşchiere dificile și pentru prelucrarea materialelor dificile.

- JC860, JC870, JC871, JC899, JPD890, J93F și J28 pentru tip cu colţ ascuţit.
- JC845, JC880, JC885 și JC898 pentru tip rază.
- D8961, JC875, JC876, JC877 și JPD880 cu tip șanfren 45°.
- JC850 și JPD850 pentru tip cu cap rotund.

Alegerea uneltei - Plastic și CFRP

							
Nume		D8961	JC845	JC850	JC860	JC870	JC871
Pag.		539	542	544	546	548	554
Familia		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Tipul frezei							
Coada	Cilindrică	■	■	■	■	■	■
	Weldon						
Numărul de dinţi		6	3	4	5,6,8,9		
CSP							
	Metric		6-8	3-12	6-12	3-12	3-12
	Inch					1/4 -1/2	1/4 -1/2
Lungimi disponibile		2,3	2	2	2	2	2
Operaţiune							
							
							
SMG							
TS1							
TS2		●	●	●	●	●	●
TS3		●	●	●	●	●	●
TP1							
TP2		●	●	●	●	●	●
TP3		●	●	●	●	●	●
Fagure*					●	●	●

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Plastic și CFRP

								
Nume		JC875	JC876	JC877	JC880	JC885	JC898	JC899
Pag.		560	564	568	572	574	576	578
Familia		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Tipul frezei								
Coada	Cilindrică	■	■	■	■	■	■	■
	Weldon							
Numărul de dinţi		5,6,10	6,8,10,12,14	6,8,10,12,14	4	4	4	4
CSP							■	
	Metric	3-10	3-12	3-12	4-20	4-10	8-15	8,5-14,8
	Inch	1/4 -1/2	1/4-1/2	1/4-1/2				
Lungimi disponibile		2	2	2	2	2	2	2
Operaţiune								
								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Fagure*								

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Plastic și CFRP

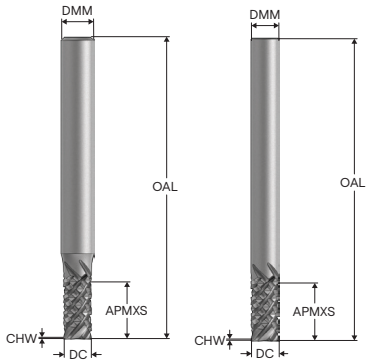
						
Nume		JPD850	JPD880	JPD890	J93F	J28
Pag.		581	583	585	587	589
Familia		PCD	PCD	PCD	VHM	VHM
Tipul frezei						
Coada	Cilindrică	■	■	■	■	■
	Weldon					
Numărul de dinţi		2	2	2	2	1
CSP		■	■	■		
	Metric	4-10	6-16	6-12	1,5-20	3-12
	Inch					
Lungimi disponibile		2	2,3	2,3	1,2,3,4	2
Operaţiune						
						
						
SMG						
TS1					•	•
TS2		•	•	•		
TS3		•	•	•		
TP1					•	
TP2		•	•	•		
TP3		•	•	•		
Fagure*						

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
• Opţiune preferată ○ Opţiune alternativă

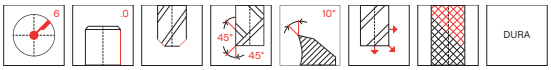
D8961

Compozit – Router – 6 Caneluri – Cilindrică – Șanfren





—Toleranțe:
—DMM= h5
—DC= -0/-0,05 mm



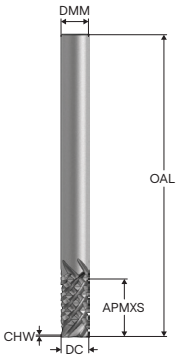
Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	Coada	Stoc standard
					mm	mm	mm	mm	mm		
D8961-050F2C.0Z6	DURA	10318178	2	F	5,0	6,0	10,0	65,0	0,152	Cylindrical	■
D8961-060D2C.0Z6	DURA	10318180	2	D	6,0	6,0	12,0	65,0	0,152	Cylindrical	■
D8961-080D2C.0Z6	DURA	10318182	2	D	8,0	8,0	16,0	70,0	0,203	Cylindrical	■
D8961-100D2C.0Z6	DURA	10318184	2	D	10,0	10,0	20,0	75,0	0,203	Cylindrical	■
D8961-120D2C.0Z6	DURA	10318186	2	D	12,0	12,0	24,0	76,0	0,254	Cylindrical	■
D8961-140D2C.0Z6	DURA	10318188	2	D	14,0	14,0	28,0	82,0	0,254	Cylindrical	■
D8961-160D2C.0Z6	DURA	10318190	2	D	16,0	16,0	32,0	94,0	0,254	Cylindrical	■
D8961-050F3C.0Z6	DURA	10318179	3	F	5,0	6,0	15,0	70,0	0,152	Cylindrical	■
D8961-060D3C.0Z6	DURA	10318181	3	D	6,0	6,0	18,0	70,0	0,152	Cylindrical	■
D8961-080D3C.0Z6	DURA	10318183	3	D	8,0	8,0	24,0	75,0	0,203	Cylindrical	■
D8961-100D3C.0Z6	DURA	10318185	3	D	10,0	10,0	30,0	90,0	0,203	Cylindrical	■
D8961-120D3C.0Z6	DURA	10318187	3	D	12,0	12,0	36,0	90,0	0,254	Cylindrical	■
D8961-140D3C.0Z6	DURA	10318189	3	D	14,0	14,0	42,0	96,0	0,254	Cylindrical	■
D8961-160D3C.0Z6	DURA	10318191	3	D	16,0	16,0	48,0	110,0	0,254	Cylindrical	■

■ **Stoc standard.**

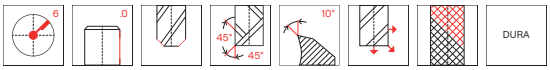
D8961

Compozit – Router – 6 Caneluri – Cilindrică – Șanfren – Inci





—Toleranţe:
—DMM=-.0001"/-.0004"
—DC=0/ -0.002"



Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CHW	Coada	Stoc standard
					inci	inci	inci	inci	inci		
D8961-.250D2C.0Z6	DURA	10318192	2	D	0.250	0.250	0.500	2.500	0.006	Cylindrical	■
D8961-.313D2C.0Z6	DURA	10318194	2	D	0.313	0.313	0.625	2.500	0.008	Cylindrical	■
D8961-.375D2C.0Z6	DURA	10318196	2	D	0.375	0.375	0.750	2.500	0.008	Cylindrical	■
D8961-.500D2C.0Z6	DURA	10318198	2	D	0.500	0.500	1.000	3.000	0.010	Cylindrical	■
D8961-.625D2C.0Z6	DURA	10318200	2	D	0.625	0.625	1.250	3.500	0.010	Cylindrical	■
D8961-.250D3C.0Z6	DURA	10318193	3	D	0.250	0.250	0.750	3.000	0.006	Cylindrical	■
D8961-.313D3C.0Z6	DURA	10318195	3	D	0.313	0.313	0.937	3.000	0.008	Cylindrical	■
D8961-.375D3C.0Z6	DURA	10318197	3	D	0.375	0.375	1.125	3.000	0.008	Cylindrical	■
D8961-.500D3C.0Z6	DURA	10318199	3	D	0.500	0.500	1.500	4.000	0.010	Cylindrical	■
D8961-.625D3C.0Z6	DURA	10318201	3	D	0.625	0.625	1.875	4.000	0.010	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – D8961 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				5	6	8	10	12	14	16	
TS2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Parametri de așchiere – D8961 Frezare de canal

SMG		a_p/DC	f_z							v_c
			5	6	8	10	12	14	16	
TS2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

Parametri de așchiere – D8961 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
TS2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Parametri de așchiere – D8961 Frezare de canal – Inci

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
TS2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

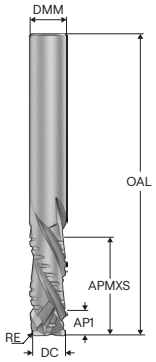
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

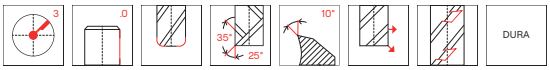
JC845

Compozit – Compresie – 3 Caneluri – Cilindrică – Rază la vârf





—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE=±0,01 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm			
JC845060D2R050.0Z3-DURA	02843006	2	D	■	6,0	6,0	18,0	4,2	65,0	0,5	3	Cylindrical	■
JC845080D2R050.0Z3-DURA	02843007	2	D	■	8,0	8,0	24,0	5,2	75,0	0,5	3	Cylindrical	■
JC845100D2R050.0Z3-DURA	02843008	2	D	■	10,0	10,0	30,0	6,3	85,0	0,5	3	Cylindrical	■
JC845120D2R050.0Z5-DURA	02843009	2	D	■	12,0	12,0	36,0	8,3	100,0	0,5	5	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC845 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	185 (130 — 240) *610 (430 — 780)*
TS3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 160) *410 (290 — 520)*
TP2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 180) *410 (290 — 590)*
TP3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	85 (62 — 110) *280 (210 — 360)*

Parametri de așchiere – JC845 Frezare de canal

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (76 — 130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (75 — 160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (54 — 96) *245 (180 — 310)*

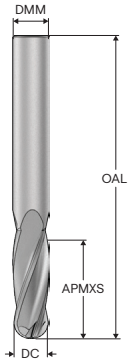
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

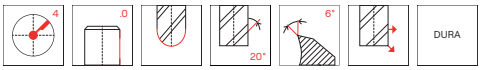
JC850

Compozit – Cap sferic – 4 Caneluri – Cilindrică





D



—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,02 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	1,5	4	Cylindrical	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	2,0	4	Cylindrical	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	3,0	4	Cylindrical	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4,0	4	Cylindrical	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC850 Frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730 — 1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	160 (110 — 210) *520 (370 — 680)*
TP2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	215 (110 — 320) *710 (370 — 1000)*
TP3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	105 (54 — 150) *345 (180 — 490)*

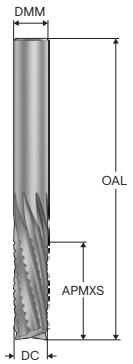
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC860

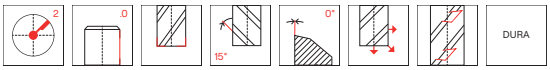
Fagure – Pătrat – 5-9 Caneluri – Cilindrică – Ascuţit





D

—Toleranţe:
—DMM=h5
—DC= -0.02-0.08 mm
—FCEDC=dinţi frontali



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm				
860060Z5.0-DURA	02720211	2	D	■	6,0	6,0	18,0	18,0	70,0	2	5	Cylindrical	■
860080Z6.0-DURA	02720212	2	D	■	8,0	8,0	24,0	24,0	80,0	2	6	Cylindrical	■
860100Z8.0-DURA	02720216	2	D	■	10,0	10,0	30,0	30,0	90,0	2	8	Cylindrical	■
860120Z9.0-DURA	02720217	2	D	■	12,0	12,0	36,0	36,0	110,0	2	9	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC860 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	235 (200 — 270) *770 (660 — 880)*
TS3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	160 (130 — 180) *520 (430 — 590)*
TP2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	165 (130 — 200) *540 (430 — 650)*
TP3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	65 (50 — 110) *215 (170 — 360)*

Parametri de așchiere – JC860 Frezare de canal

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	110 (84 — 130) *360 (280 — 420)*
TP3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	44 (34 — 78) *145 (120 — 250)*

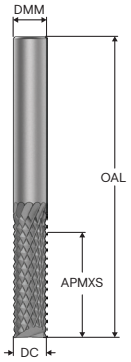
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC870

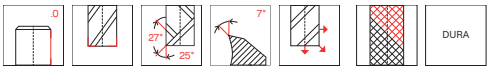
Compozit – Router – Pătrat – Cilindrică – Ascuţit





D

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,08 mm
—Router (tăiere în jos)*



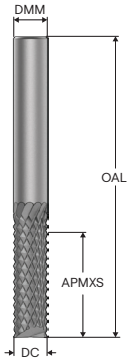
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm				
870030.0-DURA	02720219	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0-DURA	02720226	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870060.0-DURA	02720228	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0-DURA	02720229	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0-DURA	02720231	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0-DURA	02720232	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se foloseşte prinderea în vid.

JC870

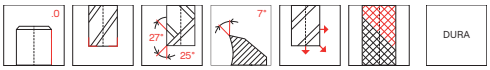
Compozit – Router – Pătrat – Cilindrică – Ascuţit – Inci





D

—Toleranţe:
—DMM= h5
—DC= -.0008/-.0030 *Inci*
—Router (tăiere în jos)*



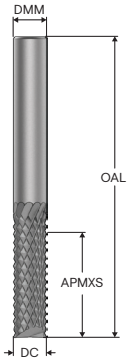
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci				
8700250.0-DURA	02720784	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700375.0-DURA	02720785	2	D	■	0.375	0.375	1.250	3.500	2	12	Cylindrical	■

■ **Stoc standard.**
*Așchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

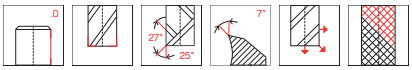
JC870

Compozit – Router – Pătrat – Cilindrică – Ascuţit





D



—Toleranţe:
—DMM=h5
—DC=-0,02/-0,08 mm
—Router (tăiere în jos)*

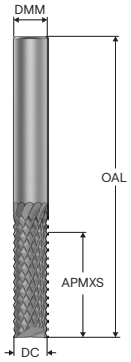
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de aşchii	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm				
870030.0	02742789	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0	02742792	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870050.0	02742793	2	D	■	5,0	5,0	15,0	15,0	50,0	2	10	Cylindrical	■
870060.0	02742794	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0	02742795	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0	02742796	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0	02742797	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

JC870

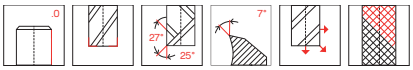
Compozit – Router – Pătrat – Cilindrică – Ascuţit – Inci





D

—Toleranţe:
—DMM= h5
—DC=- .0008 / -.0015 *inch*
—Router (tăiere în jos)*



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci				
8700250.0	02742798	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700500.0	02742800	2	D	■	0.500	0.500	1.500	4.250	2	14	Cylindrical	■

■ **Stoc standard.**
*Așchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

Parametri de așchiere – JC870 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri de așchiere – JC870 Frezare de canal

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JC870 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri de așchiere – JC870 Frezare de canal – Inci

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

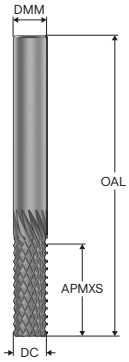
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC871

Compozit – Router – Pătrat – Cilindrică – Ascuţit





D

—Toleranţe:
—DMM= h5
—DC= -0,02/-0,08 mm
—Router (tăiere în jos)*



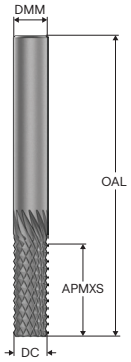
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm			
871030.0-DURA	02720249	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0-DURA	02720250	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0-DURA	02720252	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0-DURA	02720253	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0-DURA	02720254	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0-DURA	02720257	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se foloseşte prinderea în vid.

JC871

Compozit – Router – Pătrat – Cilindrică – Ascuţit – Inci





D

—Toleranţe:
—DMM= h5
—DC= -.0008 / -.0015 *inch*
—Router (tăiere în jos)*



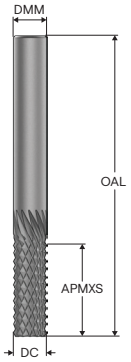
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
8710250.0-DURA	02720788	2	D	■	0.250	0.250	0.750	2.250	10	Cylindrical	■
8710375.0-DURA	02720789	2	D	■	0.375	0.375	1.250	3.500	12	Cylindrical	■
8710500.0-DURA	02720790	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

JC871

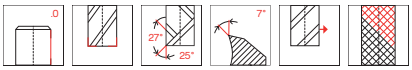
Compozit – Router – Pătrat – Cilindrică – Ascuţit





D

—Toleranţe:
—DMM= h5
—DC= -0,02/-0,08 mm
—Router (tăiere în jos)*



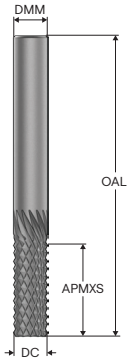
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm			
871030.0	02742801	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0	02742803	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0	02742806	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0	02742807	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0	02742808	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0	02742809	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

JC871

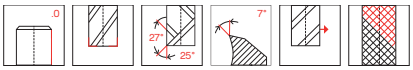
Compozit – Router – Pătrat – Cilindrică – Ascuţit – Inci





D

—Toleranţe:
—DMM=h5
—DC=-0,02/-0,08 mm
—Router (tăiere în jos)*



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci			
8710500.0	02742814	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **Stoc standard.**
*Aşchierea în jos indică geometrii ale canelurilor care sunt combinate pentru a crea mici forţe în jos care ajută la menţinerea prinderii componentei, în special când se folosește prinderea în vid.

Parametri de așchiere – JC871 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri de așchiere – JC871 Frezare de canal

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	155 (140 — 180) *510 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (84 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (79 — 130) *345 (260 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	40 (31 — 70) *130 (110 — 220)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JC871 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Parametri de așchiere – JC871 Frezare de canal – Inci

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

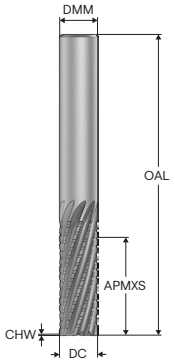
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC875

Compozit – Pătrat – 5-10 Caneluri – Cilindrică – Șanfren





D

—Toleranțe:
—DMM=h5
—DC=-0,02/-0,08 mm



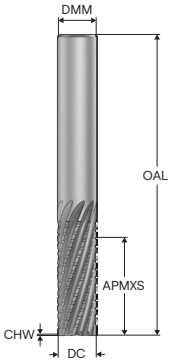
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm			
JC875030D2.0-DURA	02968155	2	D	■	3,0	3,0	9,0	50,0	0,05	5	Cylindrical	■
JC875050D2.0-DURA	02968157	2	D	■	5,0	5,0	15,0	50,0	0,05	6	Cylindrical	■
JC875060D2.0-DURA	02968158	2	D	■	6,0	6,0	18,0	65,0	0,06	6	Cylindrical	■
JC875080D2.0-DURA	02968159	2	D	■	8,0	8,0	24,0	70,0	0,08	10	Cylindrical	■
JC875100D2.0-DURA	02968160	2	D	■	10,0	10,0	30,0	80,0	0,1	10	Cylindrical	■

■ **Stoc standard.**

JC875

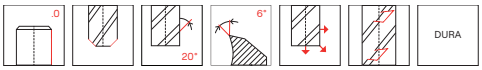
Compozit – Pătrat – 6-10 Caneluri – Cilindrică – Șanfren – Inci





D

—Toleranțe:
—DMM=h5
—DC= -.0008/-.0030 *Inci*



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	APMXS	OAL	CHW	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
JC875.250D2.0-DURA	02968162	2	D	■	0.250	0.250	0.750	3.000	0.002	6	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC875 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	5	6	8	10	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	50 (39 — 89) *165 (130 — 290)*

Parametri de așchiere – JC875 Frezare de canal

SMG		a_p/DC	f_z					v_c
			3	5	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	42 (33 — 74) *140 (110 — 240)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JC875 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	50 (39 — 89) *165 (130 — 290)*

Parametri de așchiere – JC875 Frezare de canal – Inci

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	42 (33 — 74) *140 (110 — 240)*

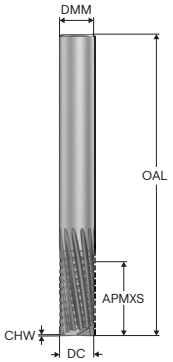
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

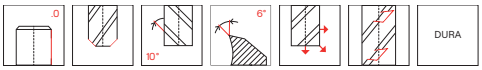
JC876

Compozit – Pătrat – 6-14 Caneluri – Cilindrică – Șanfren





D



—Toleranţe:
—DMM=h5
—DC=-0,02 -0,08 mm
—Spirală spre stânga

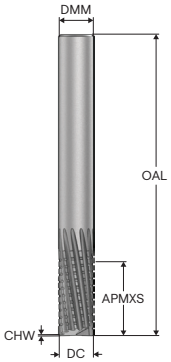
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm				
JC876030D2C.0Z6-DURA	03135004	2	D	■	3,0	3,0	7,5	7,5	50,0	0,035	2	6	Cylindrical	■
JC876040D2C.0Z6-DURA	03135005	2	D	■	4,0	4,0	10,0	10,0	54,0	0,045	2	6	Cylindrical	■
JC876060D2C.0Z8-DURA	03135006	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	8	Cylindrical	■
JC876060D2C.0Z10-DURA	03135007	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	10	Cylindrical	■
JC876080D2C.0Z10-DURA	03135009	2	D	■	8,0	8,0	20,0	20,0	70,0	0,1	2	10	Cylindrical	■
JC876100D2C.0Z12-DURA	03135011	2	D	■	10,0	10,0	25,0	25,0	82,0	0,125	2	12	Cylindrical	■
JC876120D2C.0Z14-DURA	03135012	2	D	■	12,0	12,0	30,0	30,0	95,0	0,15	2	14	Cylindrical	■

■ **Stoc standard.**

JC876

Compozit – Pătrat – 8-14 Caneluri – Cilindrică – Șanfren – Inci





D

—Toleranțe:
—DMM=h5
—DC= -.0008/-.0030 *Inci*
—Spirală spre stânga



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci				
JC876.250D2C.0Z8-DURA	03135125	2	D	■	0.250	0.250	0.625	2.500	0.003	2	8	Cylindrical	■
JC876.375D2C.0Z12-DURA	03135127	2	D	■	0.375	0.375	1.000	3.000	0.005	2	12	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC876 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	75 (44 — 100) *245 (150 — 320)*

Parametri de așchiere – JC876 Frezare de canal

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	60 (36 — 81) *195 (120 — 260)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JC876 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	75 (44 — 100) *245 (150 — 320)*

Parametri de așchiere – JC876 Frezare de canal – Inci

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	60 (36 — 81) *195 (120 — 260)*

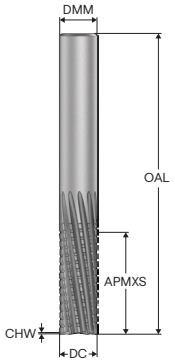
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC877

Compozit – Pătrat – 6-14 Caneluri – Cilindrică – Șanfren





D

—Toleranţe:
—DMM=h5
—DC=-0,02, -0,08 mm
—Spirală spre stânga



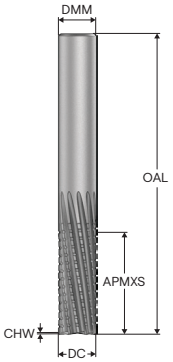
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de așchii	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm				
JC877030D2C.0Z6-DURA	03135013	2	D	■	3,0	3,0	9,0	9,0	50,0	0,035	3	6	Cylindrical	■
JC877040D2C.0Z6-DURA	03135014	2	D	■	4,0	4,0	12,0	12,0	54,0	0,045	3	6	Cylindrical	■
JC877060D2C.0Z8-DURA	03135015	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	4	8	Cylindrical	■
JC877060D2C.0Z10-DURA	03135016	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	5	10	Cylindrical	■
JC877080D2C.0Z10-DURA	03135018	2	D	■	8,0	8,0	24,0	24,0	70,0	0,1	5	10	Cylindrical	■
JC877100D2C.0Z12-DURA	03135020	2	D	■	10,0	10,0	30,0	30,0	82,0	0,125	6	12	Cylindrical	■
JC877120D2C.0Z14-DURA	03135021	2	D	■	12,0	12,0	36,0	36,0	95,0	0,15	7	14	Cylindrical	■

■ **Stoc standard.**

JC877

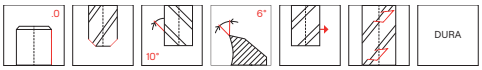
Compozit – Pătrat – 8-14 Caneluri – Cilindrică – Șanfren – Inci





D

—Toleranțe:
—DMM=h5
—DC= -.0008/-.0030 *Inci*
—Spirală spre stânga



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmenta-tor de așchii	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci				
JC877.250D2C.0Z8-DURA	03135129	2	D	■	0.250	0.250	0.750	2.500	0.003	4	8	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC877 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (40 — 91) *215 (140 — 290)*

Parametri de așchiere – JC877 Frezare de canal

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	170 (150 — 200) *115 (92 — 130)*
TP2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	115 (86 — 140) *55 (35 — 80)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – JC877 Degroșare prin frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	65 (40 — 91) *215 (140 — 290)*

Parametri de așchiere – JC877 Frezare de canal – Inci

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (80 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	55 (32 — 74) *180 (110 — 240)*

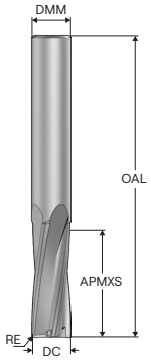
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm/dinte (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

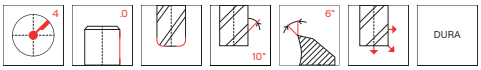
JC880

Compozit – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





D



—Toleranţe:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE=±0,01 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	Cylindrical	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	Cylindrical	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	Cylindrical	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	Cylindrical	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	Cylindrical	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	Cylindrical	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC880 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z							v_c
				4	6	8	10	12	16	20	
TS2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	130 (93 — 170) *425 (310 — 550)*
TP2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	125 (95 — 150) *410 (320 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (40 — 92) *165 (140 — 300)*

Parametri de așchiere – JC880 Frezare de canal

SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	100 (71 — 130) *330 (240 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (76 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	40 (31 — 70) *130 (110 — 220)*

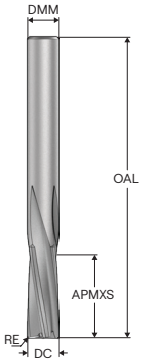
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

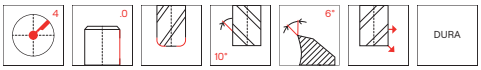
JC885

Compozit – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf





D



- Toleranţe:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm
- Spirală spre stânga

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm			
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	Cylindrical	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC885 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				4	6	8	10	
TS2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	130 (99 — 170) *425 (330 — 550)*
TP2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	125 (94 — 150) *410 (310 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (33 — 92) *165 (110 — 300)*

Parametri de așchiere – JC885 Frezare de canal

SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76 — 130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	100 (75 — 120) *330 (250 — 390)*
TP3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	40 (26 — 70) *130 (86 — 220)*

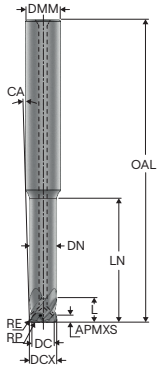
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

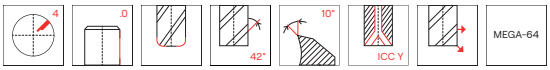
JC898

Avans mare – Materiale suprapuse – Rază la vârf – 4 Caneluri – Cilindrică – Rază la vârf





G



—Toleranţe:
—DMM=h5
—DC= e7
—RE= ±0,1 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DCX	DC	DMM	L	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm				
JC898080G3HZ4A.0-M64	03245308	3	G	■	8,0	4,0	10,0	6,0	0,43	88,0	35,0	7,6	0,5	0,87	0,22	1,5	4	Cylindrical	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	15,0	7,5	16,0	12,0	0,796	125,0	70,0	14,3	0,94	1,63	0,4	0,4	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC898 Frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z		v_c
				8	15	
S12+TS2/TP2	D	0,30 *0,30*	0,020 *0,020*	0,1 *0,0040*	0,15 *0,0060*	90 (80-120) *300 (270-400)*
TP2+TS2/TP2	D	0,30 *0,30*	0,034 *0,034*	0,12 *0,0048*	0,25 *0,0100*	120 (90-150) *400 (300-490)*

Parametri de așchiere – JC898 Frezare de canal

SMG		a_p/DCX	f_z		v_c
			8	15	
S12+TP2/TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*
N1+TP2/TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*

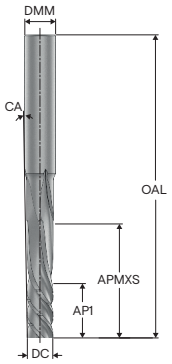
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JC899

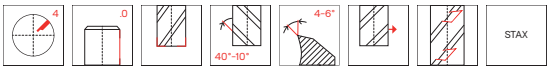
Înaltă performanţă – Materiale suprapuse – Pătrat – 4 Caneluri – Cilindrică – Ascuţit





F

– Toleranţe:
– DMM=h5
– DC= ±0,02 mm



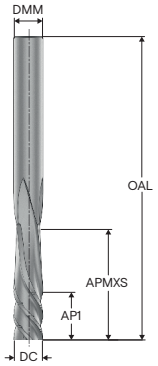
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	OAL	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm				
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	100,0	0,8	4	Cylindrical	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	150,0	0,53	4	Cylindrical	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	150,0	0,48	4	Cylindrical	■

■ **Stoc standard.**

JC899

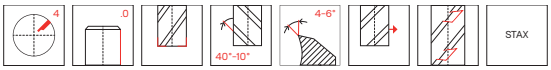
Înaltă performanţă – Materiale suprapuse – Pătrat – 4 Caneluri – Cilindrică – Ascuţit – Inci





D

—Toleranţe:
—DMM=h5
—DC= ±0,0008 *Inci*



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	fragmentator de aşchii	DC	DMM	APMXS	AP1	OAL	PCEDC	Coada	Stoc standard
					inci	inci	inci	inci	inci			
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JC899 Finisare

SMG		a_e/DC	a_p/DC	f_z		v_c
				8.5	14.8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,04 *0,0016*	0,075 *0,0030*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,06 *0,0032*	0,09 *0,0036*	60 (50 — 75) *200 (170 — 250)*

Parametri de așchiere – JC899 Finisare – Inci

SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50 — 75) *200 (170 — 250)*

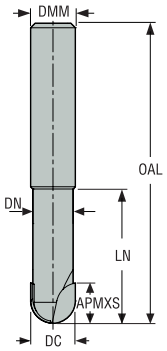
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JPD850

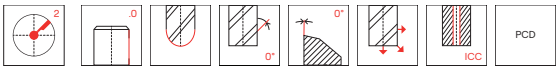
Compozit – Cap sferic – 2 Caneluri – Cilindrică





E

—Toleranţe:
—DMM=h5
—DC= h10
—CSP= 2 canale drepte



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	3,0	2	Cylindrical	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	4,0	2	Cylindrical	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	5,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JPD850 Frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	310 (270 — 460) *1025 (890 — 1500)*
TP2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	890 (750 — 1300) *2925 (2500 — 4200)*
TP3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	580 (500 — 870) *1900 (1700 — 2800)*

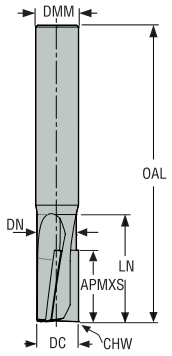
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JPD880

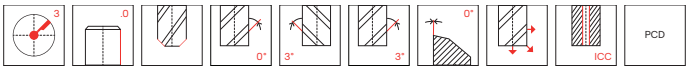
Compozit – Pătrat – 3 Caneluri – Cilindrică – Șanfren





E

—Toleranţe:
—DMM=h5
—DC=h10
—CSP=Y



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JPD880060G2C.0Z3A	02968190	2	G	■	6,0	8,0	13,0	64,0	20,0	5,3	0,1	3	Cylindrical	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	Cylindrical	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	Cylindrical	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	Cylindrical	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JPD880 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				6	8	10	12	16	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	510 (430 — 750) *1675 (1500 — 2400)*
TS3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	275 (230 — 410) *900 (760 — 1300)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	810 (680 — 940) *2650 (2300 — 3000)*
TP3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	520 (440 — 780) *1700 (1500 — 2500)*

Parametri de așchiere – JPD880 Frezare de canal

SMG		a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	620 (520 — 710) *2025 (1800 — 2300)*
TP3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	395 (340 — 590) *1300 (1200 — 1900)*

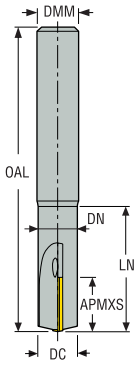
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JPD890

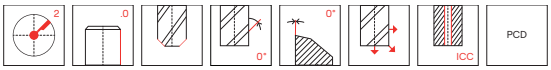
Compozit – Pătrat – 2 Caneluri – Cilindrică – Șanfren





E

—Toleranțe:
—DMM=h5
—DC=h10
—CSP=2 canale drepte



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm			
JPD890060G2S.0Z2A	02791382	2	G	■	6,0	8,0	13,0	64,0	20,0	5,4	0,1	2	Cylindrical	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	Cylindrical	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	Cylindrical	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JPD890 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	415 (360 — 620) *1350 (1200 — 2000)*
TS3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (260 — 450) *1000 (860 — 1400)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	670 (560 — 770) *2200 (1900 — 2500)*
TP3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	580 (490 — 860) *1900 (1700 — 2800)*

Parametri de așchiere – JPD890 Frezare de canal

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	600 (500 — 690) *1975 (1700 — 2200)*
TP3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	420 (360 — 630) *1375 (1200 — 2000)*

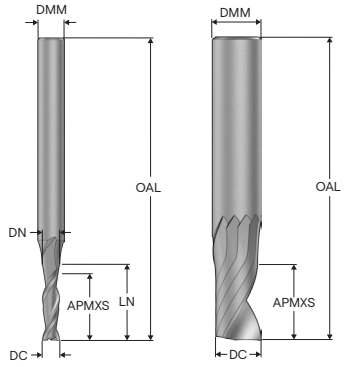
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

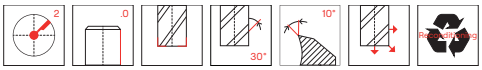
J93F

Uz general – Plastic – Pătrat – 2 Caneluri – Cilindrică – Ascuţit





—Toleranţe:
—DMM= h5
—DC= Ø1-Ø6= -0,02/-0,034 mm
—DC= Ø8-Ø20= -0,02/-0,044 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm				
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	Cylindrical	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	Cylindrical	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	Cylindrical	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	Cylindrical	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	Cylindrical	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	Cylindrical	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	Cylindrical	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	Cylindrical	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	Cylindrical	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	Cylindrical	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	Cylindrical	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	Cylindrical	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	Cylindrical	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	Cylindrical	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	Cylindrical	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	Cylindrical	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	Cylindrical	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – J93F Frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	590 (480 — 710) *1925 (1600 — 2300)*
TP1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	570 (460 — 680) *1875 (1600 — 2200)*

Parametri de așchiere – J93F Frezare de canal

SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	485 (390 — 580) *1600 (1300 — 1900)*

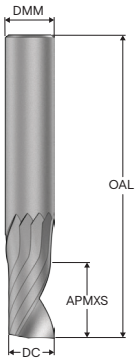
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

J28

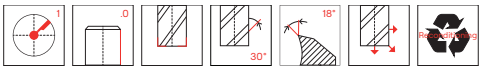
Uz general – Plastic – Pătrat – 1 Canelură – Cilindrică – Ascuţit





D

—Toleranţe:
—DMM= h5
—DC= Ø2-Ø6= -0,02/-0,034 mm
—DC= Ø8-Ø12= -0,02/-0,044 mm
—Reascuţire posibilă dacă DC este ≥ Ø6



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm			
28030	00029353	2	D	3,0	3,0	10,0	40,0	1	Cylindrical	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	1	Cylindrical	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	1	Cylindrical	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	1	Cylindrical	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	1	Cylindrical	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	1	Cylindrical	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	1	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – J28 Frezare laterală a_e/DC=0,4

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	490 (370 — 610) *1600 (1300 — 2000)*

Parametri de așchiere – J28 Frezare de canal

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	400 (310 — 490) *1300 (1100 — 1600)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



GRAFIT

Frezele cilindro-frontale Seco din carbură solidă acoperite cu diamant sunt proiectate anume pentru prelucrarea grafitului. Oferă o durata de viaţă a sculei de până la 10 ori mai mare decât frezele cu acoperiri convenţionale. Disponibile într-o varietate de geometrii și o
gamă cuprinzătoare de diametre, aceste scule dispun de cel mai bun substrat posibil, pentru a asigura aderarea perfectă a acoperirii cu diamant la o diversitate de parametri de așchiere.

- JD620, JD630, JD640 și JME642 pentru tip rază.
- JD660, SMB614, SMB616 și JMB642 pentru tip cu cap rotund.

Alegerea uneltei - Grafit

					
Nume		JD620	JD630	JD640	JD660
Pag.		594	596	598	600
Familia		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Tipul frezei					
Coada	Cilindrică	■	■	■	■
	Weldon				
Numărul de dinţi		2	3	4	2
CSP					
	Metric	3-12	3-8	6-12	3-6
	Inch				
Lungimi disponibile		2,3,4	2,3,4	2,3,4	1,2,3,4,5
Operaţiune					
					
					
SMG					
GR		●	●	●	●

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
● Opţiune preferată ○ Opţiune alternativă

Alegerea uneltei - Grafit

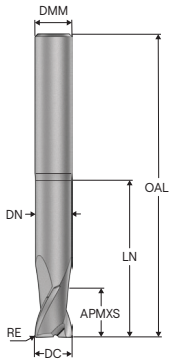
				
Nume		SMB614/616	JME642	JMB642/JMB662
Pag.		604	604	606
Familia		MINI DIAMOND	MINI DIAMOND	MINI DIAMOND
Tipul frezei				
Coada	Cilindrică	■	■	■
	Weldon			
Numărul de dinţi		2	2	2
CSP				
	Metric	0,6-3	0,2-2,0	0,2-3,0
	Inch			
Lungimi disponibile		1,3,5,6,7	1,3,5,6,7	1,3,5,6,7
Operaţiune				
				
				
SMG				
GR		•	•	•

■ Stoc standard □ Weldon disponibil, intervalul de livrare este de 3 zile.
• Opţiune preferată ○ Opţiune alternativă

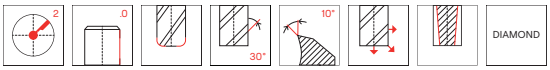
JD620

Diamond – Grafit – Pătrat – 2 Caneluri – Cilindrică – Rază la vârf





E



—Toleranţe:
—Bătaie radială= <0,01 mm
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,05 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
620V030R050-DIAMOND	00023425	2	E	3,0	3,0	5,0	60,0	30,0	2,85	0,5	2	Cylindrical	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	Cylindrical	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	Cylindrical	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	Cylindrical	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	Cylindrical	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	Cylindrical	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	Cylindrical	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	Cylindrical	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	Cylindrical	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	Cylindrical	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	Cylindrical	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	Cylindrical	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	Cylindrical	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	Cylindrical	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JD620 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
GR1	D	0.500 *0,500*	0.50 *0,50*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	690 (580 — 800) *2275 (2000 — 2600)*

Parametri de așchiere – JD620 Frezare de canal

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

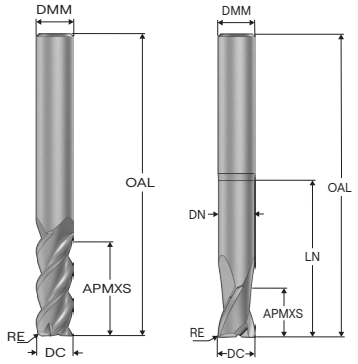
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

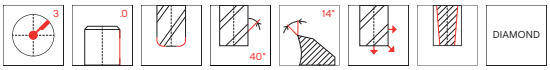
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JD630

Diamond – Grafit – Pătrat – 3 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,01 mm
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,05 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	Cylindrical	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	Cylindrical	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	Cylindrical	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	Cylindrical	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	Cylindrical	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	Cylindrical	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	Cylindrical	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	Cylindrical	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	Cylindrical	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	Cylindrical	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JD630 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	4	5	6	8	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	680 (580 — 790) *2225 (2000 — 2500)*

Parametri de așchiere – JD630 Frezare de canal

SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520 — 720) *2025 (1800 — 2300)*

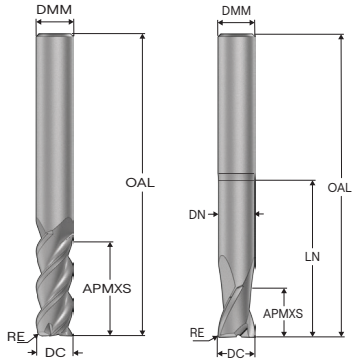
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

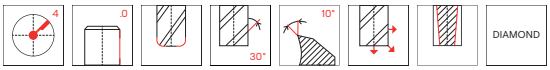
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JD640

Diamond – Grafit – Pătrat – 4 Caneluri – Cilindrică – Rază la vârf







—Toleranţe:
—Bătaie radială= <0,01 mm
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,05 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	Cylindrical	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	Cylindrical	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	Cylindrical	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	Cylindrical	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	Cylindrical	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	Cylindrical	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	Cylindrical	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JD640 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	680 (570 — 780) *2225 (1900 — 2500)*

Parametri de așchiere – JD640 Frezare de canal

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

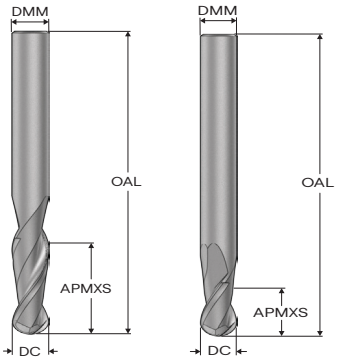
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

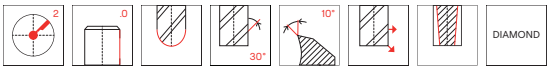
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

JD660

Diamond – Grafit – Cap sferic – 2 Caneluri – Cilindrică







—Toleranţe:
—Bătaie radială=<0,01 mm
—DMM=h5
—DC= -0,02/-0,04 mm
—RE= ±0,01 mm
—B=0,9°

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm			
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	Cylindrical	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	Cylindrical	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	Cylindrical	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	Cylindrical	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	Cylindrical	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	Cylindrical	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	Cylindrical	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	Cylindrical	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	Cylindrical	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	Cylindrical	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	Cylindrical	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JD660 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780 — 1000) *3025 (2600 — 3200)*

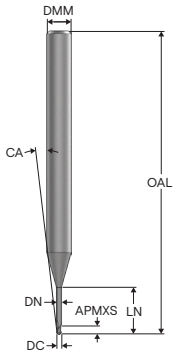
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

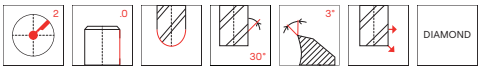
SMB614/616

Miniatură – Grafit – Cap sferic – 2 Caneluri – Cilindrică





G



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM = h5
—DC Acoperit = -0,01/-0,025 mm
—DC Acoperit = 0/-0,015 mm
—RE = ±0,01 mm

Reper Nr.	Calitate	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
					mm	mm	mm	mm	mm	mm	mm				
SMB614010G4B.0Z2	DIA	10108776	4	G	1,0	4,0	1,0	50,0	7,5	0,95	0,5	6,54	2	Cylindrical	■
SMB614020G4B.0Z2	DIA	10108777	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,74	2	Cylindrical	■
SMB614030G4B.0Z2	DIA	10108778	4	G	3,0	4,0	3,0	50,0	20,0	2,85	1,5	1,36	2	Cylindrical	■
SMB614020G5B.0Z2	DIA	10108779	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	3,13	2	Cylindrical	■
SMB614006G6B.0Z2	DIA	10108780	6	G	0,6	4,0	0,6	50,0	6,0	0,55	0,3	7,72	2	Cylindrical	■
SMB614008G6B.0Z2	DIA	10108781	6	G	0,8	4,0	0,8	50,0	10,0	0,75	0,4	5,69	2	Cylindrical	■
SMB614010G6B.0Z2	DIA	10108782	6	G	1,0	4,0	0,5	50,0	12,0	0,95	0,5	4,88	2	Cylindrical	■
SMB614020G6B.0Z2	DIA	10108783	6	G	2,0	4,0	2,0	50,0	20,0	1,9	1,0	2,46	2	Cylindrical	■
SMB614006G7B.0Z2	DIA	10108784	7	G	0,6	4,0	0,6	50,0	10,0	0,55	0,3	5,87	2	Cylindrical	■
SMB614010G7B.0Z2	DIA	10108785	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – SMB614 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.6	0.8	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,024 *0.00095*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – SMB616 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.6	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

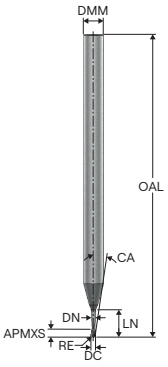
Pentru recalcularea regimurilor de frezare, a se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

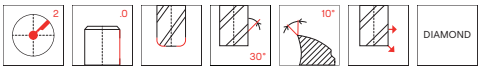
JME642

Miniatură – Grafit – Pătrat – Diamond – 2 Caneluri – DMM 4 – Cilindrică – Rază la vârf





G



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC= 0/-0,015 mm
—RE= ±0,007 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JME642002G1R002.0Z2-DIA	03215524	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,02	14,32	2	Cylindrical	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	14,1	2	Cylindrical	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	11,67	2	Cylindrical	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	10,97	2	Cylindrical	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	10,31	2	Cylindrical	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	9,31	2	Cylindrical	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	8,04	2	Cylindrical	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	7,09	2	Cylindrical	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	5,8	2	Cylindrical	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	4,11	2	Cylindrical	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	4,11	2	Cylindrical	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	9,43	2	Cylindrical	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	8,5	2	Cylindrical	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	7,02	2	Cylindrical	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	6,06	2	Cylindrical	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	5,23	2	Cylindrical	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	4,25	2	Cylindrical	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2,87	2	Cylindrical	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2,87	2	Cylindrical	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	4,86	2	Cylindrical	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	3,13	2	Cylindrical	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	1,97	2	Cylindrical	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	1,68	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JME642/JME662 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.80 *0,80*	0.024 *0,00095*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	175 (130 — 370) *570 (430 — 1200)*

Parametri de așchiere – JME642 Frezare de canal

SMG		a_p/DC	f_z										v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

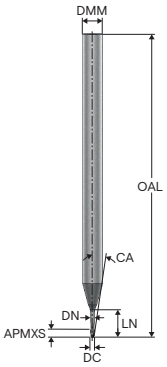
Tabel bazat pe LV3, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile. 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

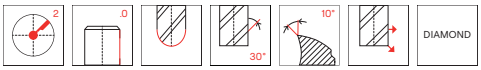
JMB642/JMB662

Miniatură – Grafit – Cap sferic – Diamond – 2 Caneluri – DMM 4-6 – Cilindrică





G



—Toleranţe:
—Bătaie radială= <0,005 mm
—DMM= h5
—DC= 0/-0,015 mm
—RE= ±0,007 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Coada	Stoc standard
				mm	mm	mm	mm	mm	mm	mm				
JMB642002G1B.0Z2-DIA	03215373	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,1	14,5	2	Cylindrical	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	14,17	2	Cylindrical	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	13,8	2	Cylindrical	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	11,19	2	Cylindrical	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	10,55	2	Cylindrical	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	9,38	2	Cylindrical	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	8,33	2	Cylindrical	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	7,38	2	Cylindrical	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	6,08	2	Cylindrical	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	4,35	2	Cylindrical	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	4,38	2	Cylindrical	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	9,6	2	Cylindrical	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	8,68	2	Cylindrical	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	7,18	2	Cylindrical	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	6,22	2	Cylindrical	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	5,4	2	Cylindrical	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	4,4	2	Cylindrical	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2,99	2	Cylindrical	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	3,0	2	Cylindrical	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	4,96	2	Cylindrical	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	3,21	2	Cylindrical	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2,03	2	Cylindrical	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	1,72	2	Cylindrical	■

■ **Stoc standard.**

Parametri de așchiere – JMB642/662 Degroșare prin frezare laterală

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Parametri de așchiere – JMB642/662 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Tabel bazat pe LV3, recalculaţi pe baza versiunii de lungime alese. A se vedea paginile 699 - 707

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă



SECO X-HEADS

Noua gamă de capete interschimbabile Seco Tools este o ofertă cuprinzătoare pentru a satisface majoritatea cerinţelor clienţilor. Utilizând geometriile noastre dovedite din carbură solidă, oferim diferite tipuri de mașini pentru majoritatea materialelor și pentru a finaliza diferite operaţiuni de prelucrare. Conexiunea este un design de cap schimbabil dovedit pentru a oferi securitate și fiabilitate ridicată a procesului. Cozile oferă multe posibilităţi pentru aplicaţii cu rază scurtă de acţiune până la aplicaţii cu rază lungă de acţiune. Gâturile drepte și conice oferă cea mai bună combinaţie de stabilitate, în funcţie de necesităţile operaţiunii dvs. De prelucrare.

- XSE550, XSE720, XSE450, XHF5831, XHF580, XHF780 XVE540 and XVE510 pentru tip rază și șanfren.
- XSB540, XSB720 și XVB510 pentru tip cu cap rotund.
- XVC506, XVC509, XS5021, XS5061 and XVC512 pentru tip conic.
- XHT740 pentru tipul butoi.

Alegerea uneltei - X-Heads

							
Nume		XSE550	XSB540	XSE720	XSB720	XSE450	XHT740
Pag.		620	637	639	645	651	655
Familia		X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS HSM/TORNADO
Tipul frezei							
Numărul de dinţi		3,4,5	4	6	6	3	4,6
CSP			■				
	Metric	10-20	10-16	10-25	10-20	10-20	10-16
	Inch	3/8-1		3/8-1	3/8-1	3/8-1	
Lungimi disponibile		1,2	1	3	3	2	2,3
Operaţiune							
							
							
							
SMG							
P1-8		●	●	○	○		○
P11-12		●	○	●	●		●
M1-3		●	●	●	●		●
M4-5		●	●	●	●		
K1-7		●	●				
S1-3		●	○	●	●		○
S11-13		●	●	●	●		●
H3 H5 H7 H8 H11 H12 H21 H31		●	○				
N1		●	●			●	
N2-3		●	●			●	
N11		●	●			●	
TS1		●	●			●	
TP1		●	●			●	
GR		○	○				

■ Stoc standard.
● Opţiune preferată, ○ Opţiune alternativă

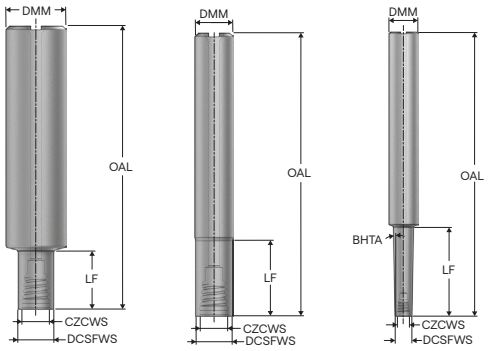
Alegerea uneltei - X-Heads

										
Nume		XHF580	XHF780	XS5021	XS5061	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Pag.		658	663	669	671	680	685	688	692	696
Familia		X-HEADS HFM	X-HEADS HFM	X-HEADS SOLID[2]	X-HEADS SOLID[2]	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Tipul frezei										
Numărul de dinţi		4	4	2	6	3,4	2	2	2	4
CSP		■				■				
	Metric	10-16	10-16	10-16	10-16	10-20	10-12	10-16	10-16	12-20
	Inch	3/8-5/8	3/8-5/8			3/8-3/4		3/8-5/8		
Lungimi disponibile		1	1	1	1	1	1	1	1	1
Operaţiune										
										
										
										
SMG										
P1-8		●	○	●	●	●	●	●	●	●
P11-12		●	○	●	●	●	●	●	●	●
M1-3		●	●	●	●	●	●	●	●	●
M4-5		●	●	●	●	●	●	●	●	●
K1-7		●		●	●	●	●	●	●	●
S1-3		○	●	○	○	○	○	○	○	○
S11-13		○	●	○	○	○	○	○	○	○
H3 H5 H7 H8 H11 H12 H21 H31		○	○	●	●	○				○
N1				○	○	●	○	○	○	●
N2-3				○	○	●	○	○	○	●
N11				○	○	●	○	○	○	●
TS1				●	●	●	●	●	●	●
TP1				●	●	●	●	●	●	●
GR				○	○	○	○	○	○	○

■ Stoc standard ☐ Weldon disponibil, intervalul de livrare este de 3 zile. ☐ Safe-Lock disponibil, intervalul de livrare este de 6 zile
● Opţiune preferată ○ Opţiune alternativă

Oţel - Metric







—Toleranţe:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					mm	mm	mm	mm			
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	Cylindrical	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	Cylindrical	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	Cylindrical	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	Cylindrical	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	Cylindrical	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	Cylindrical	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	Cylindrical	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	Cylindrical	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	Cylindrical	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	Cylindrical	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	Cylindrical	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	Cylindrical	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	Cylindrical	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	Cylindrical	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	Cylindrical	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	Cylindrical	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	Cylindrical	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	Cylindrical	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	Cylindrical	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	Cylindrical	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	Cylindrical	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	Cylindrical	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	Cylindrical	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	Cylindrical	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	Cylindrical	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	Cylindrical	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	Cylindrical	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	Cylindrical	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	Cylindrical	■

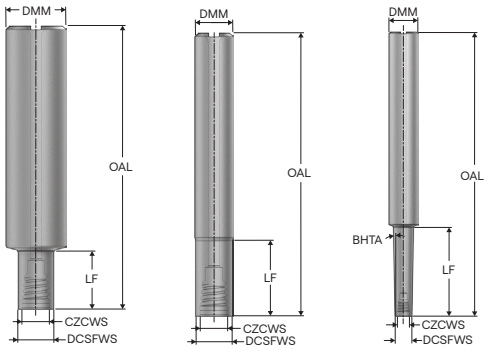
Piese de schimb, Piese incluse la livrare Accesorii

Pentru freza	Cheie fixă	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Stoc standard.**

Oţel - Inci







—Toleranţe:
—DMM= h6
—DCSFWS= ±.002 Inci
—BHTA= ±20'

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					inci	inci	inci	inci			
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	Cylindrical	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	Cylindrical	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	Cylindrical	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	Cylindrical	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	Cylindrical	■
XE10.375E2-3.00-00.0S	10334248	2	E	E10	0.362	0.375	0.799	3.000	0,0	Cylindrical	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	Cylindrical	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	Cylindrical	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	Cylindrical	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	Cylindrical	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	Cylindrical	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	Cylindrical	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	Cylindrical	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	Cylindrical	■
XE201.00J2-6.00-05.0S	10334251	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.00E2-4.50-00.0S	10218129	2	E	E25	0.961	1.000	1.500	4.500	0,0	Cylindrical	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-7.50-05.0S	10218130	2	J	E25	0.961	1.250	1.654	7.500	5,0	Cylindrical	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	Cylindrical	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	Cylindrical	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	Cylindrical	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	Cylindrical	■
XE10.625J4-5.50-05.0S	10334250	4	J	E10	0.374	0.625	1.512	5.500	5,0	Cylindrical	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	Cylindrical	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	Cylindrical	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0S	10334249	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	Cylindrical	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	Cylindrical	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	Cylindrical	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	Cylindrical	■

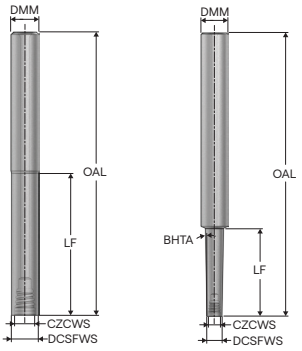
Piese de schimb, Piese incluse la livrare Accesorii

Pentru freza	Cheie fixă	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Stoc standard.**

Carbură solidă - Metric





E J



—Toleranţe:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					mm	mm	mm	mm			
XE12160J2-165-05.0E	10334240	2	J	E12	11,6	16,0	25,1	165,0	5,0	Cylindrical	■
XE16200J2-165-05.0E	10334241	2	J	E16	15,4	20,0	26,3	165,0	5,0	Cylindrical	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	Cylindrical	■
XE20250J2-150-05.0E	10334242	2	J	E20	19,2	25,0	33,1	150,0	5,0	Cylindrical	■
XE25320J2-190-05.0E	10218127	2	J	E25	24,1	32,0	45,1	190,0	5,0	Cylindrical	■
XE25320J2-215-05.0E	10218128	2	J	E25	24,1	32,0	45,1	215,0	5,0	Cylindrical	■
XE10120G3-095-00.0E	10334223	3	G	E10	9,6	12,0	30,0	95,0	0,0	Cylindrical	■
XE10160J3-140-05.0E	10334239	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160G3-107-00.0E	10334226	3	G	E12	11,6	16,0	36,0	107,0	0,0	Cylindrical	■
XE16160E3-126-00.0E	10334229	3	E	E16	15,4	16,0	48,0	126,0	0,0	Cylindrical	■
XE20320J3-175-05.0E	10334243	3	J	E20	19,2	32,0	73,2	175,0	5,0	Cylindrical	■
XE10120G4-105-00.0E	10334224	4	G	E10	9,6	12,0	40,0	105,0	0,0	Cylindrical	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	Cylindrical	■
XE12160G4-120-00.0E	10334227	4	G	E12	11,6	16,0	48,0	120,0	0,0	Cylindrical	■
XE16160E4-140-00.0E	10334230	4	E	E16	15,4	16,0	64,0	140,0	0,0	Cylindrical	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	Cylindrical	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	Cylindrical	■
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	Cylindrical	■
XE10120G5-125-00.0E	10334225	5	G	E10	9,6	12,0	50,0	125,0	0,0	Cylindrical	■
XE10160J5-120-01.0E	10334232	5	J	E10	9,6	16,0	50,0	120,0	1,0	Cylindrical	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	Cylindrical	■
XE12160G5-150-00.0E	10334228	5	G	E12	11,6	16,0	60,0	150,0	0,0	Cylindrical	■
XE16200J5-135-01.0E	10334235	5	J	E16	15,4	20,0	80,0	135,0	1,0	Cylindrical	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	Cylindrical	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	Cylindrical	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	Cylindrical	■
XE10160J8-150-01.0E	10334233	8	J	E10	9,6	16,0	80,0	150,0	1,0	Cylindrical	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	Cylindrical	■

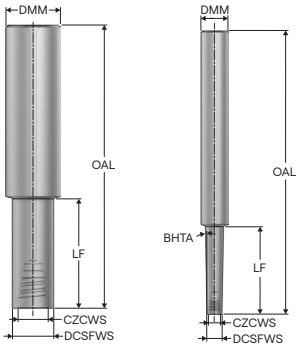
Piese de schimb, Piese incluse la livrare Accesorii

Pentru freza	Cheie fixă	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Stoc standard.**

Carbură solidă - Inci







—Toleranţe:
—DMM= h6
—DCSFWS= ±.002 Inci
—BHTA= ±20'

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					inci	inci	inci	inci			
XE12.625J2-6.50-05.0E	10334245	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.750J2-6.50-05.0E	10334246	2	J	E16	0.606	0.750	0.823	6.500	5,0	Cylindrical	■
XE201.00J2-6.00-05.0E	10334247	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-8.50-05.0E	10218131	2	J	E25	0.961	1.250	1.654	8.500	5,0	Cylindrical	■
XE10.625J4-5.50-05.0E	10334244	4	J	E10	0.360	0.625	1.512	5.500	5,0	Cylindrical	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.500G5-5.00-00.0E	10334236	5	G	E10	0.360	0.500	2.000	5.000	0,0	Cylindrical	■
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.625G5-6.00-00.0E	10334237	5	G	E12	0.480	0.625	2.400	6.000	0,0	Cylindrical	■
XE16.625E5-7.00-00.0E	10334238	5	E	E16	0.606	0.625	3.200	7.000	0,0	Cylindrical	■

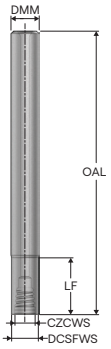
Piese de schimb, Piese incluse la livrare Accesorii

Pentru freza	Cheie fixă	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Stoc standard.**

Densimet - Metric





E



—Toleranţe:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					mm	mm	mm	mm			
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	Cylindrical	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	Cylindrical	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	Cylindrical	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	Cylindrical	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	Cylindrical	■

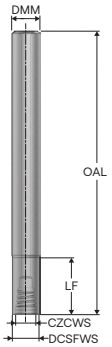
Piese de schimb, Piese incluse la livrare Accesorii

Pentru freza	Cheie fixă	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Stoc standard.**

Densimet - Inci





E



—Toleranţe:
—DMM= h6
—DCSFWS= ±.002 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Coada	Stoc standard
					inci	inci	inci	inci			
XE251.00E2-7.28-00.0DM	10218132	2	E	E25	0.961	1.000	2.559	7.283	0,0	Cylindrical	■

Piese de schimb, Piese incluse la livrare

Accesorii

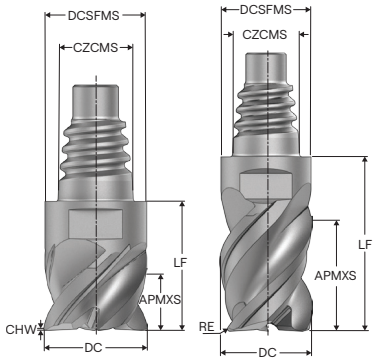
Pentru freza	Cheie fixă	Lamă interschimbabilă	Cheie dinamometrică
			
E25	XW-E25	XTWH-E25.20	XTW-E16.E25

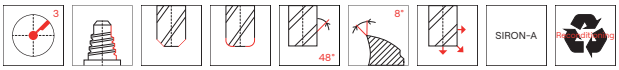
■ **Stoc standard.**

XSE550

Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Raza la colţ sau şanfrenul







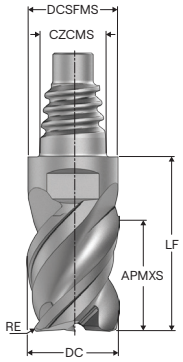
– Toleranţe:
– DC= e7
– RE= ±0,02 mm
– Reascuţire posibilă dacă DC este ≥ Ø12 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	3	8,0	■
XSE550E10100D1R100Z3	10219210	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	3	8,0	■
XSE550E10100D1R200Z3	10219211	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	3	8,0	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE550E10100D2R100Z3	10219218	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE550E10100D2R200Z3	10219219	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	3	8,0	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	3	10,0	■
XSE550E12120D1R100Z3	10219212	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	3	10,0	■
XSE550E12120D1R200Z3	10219213	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	3	10,0	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE550E12120D2R100Z3	10219220	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE550E12120D2R200Z3	10219221	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	3	10,0	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	3	12,0	■
XSE550E16160D1R100Z3	10219214	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	3	12,0	■
XSE550E16160D1R200Z3	10219215	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	3	12,0	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE550E16160D2R100Z3	10219222	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE550E16160D2R200Z3	10219223	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	3	12,0	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	–	0,5	3	16,0	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE550E20200D1R100Z3	10219216	1	D	E20	20,0	19,7	11,0	21,2	–	1,0	3	16,0	■
XSE550E20200D1R200Z3	10219217	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	3	16,0	■
XSE550E20200D2R100Z3	10219224	2	D	E20	20,0	19,7	24,0	34,3	–	1,0	3	16,0	■
XSE550E20200D2R200Z3	10219225	2	D	E20	20,0	19,7	24,0	34,3	–	2,0	3	16,0	■
XSE550E25250D1CZ3	10219207	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	3	20,0	■
XSE550E25250D1R050Z3	10219208	1	D	E25	25,0	24,2	13,75	25,5	–	0,5	3	20,0	■
XSE550E25250D1R100Z3	10219209	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	3	20,0	■

.

XSE550 – Inci
Înaltă performanţă – Universale – Pătrat – 3 Caneluri – Rază la vârf – Inci





D

—Toleranţe:
—DC= e7
—RE= ±.0008 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XSE550E10.375D1R030Z3	10138146	1	D	E10	0.375	0.364	0.206	0.484	0.030	3	8,0	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10,0	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16,0	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■

Parametri de așchiere – XSE550 – Frezare laterală PCEDC 3

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	185 (140 — 220) *610 (460 — 720)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	175 (140 — 210) *570 (460 — 680)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 190) *510 (400 — 620)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	135 (110 — 170) *445 (370 — 550)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	130 (98 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 170) *460 (370 — 550)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	130 (97 — 160) *425 (320 — 520)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 100) *310 (270 — 320)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	60 (51 — 67) *195 (170 — 210)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	90 (76 — 100) *295 (250 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (44 — 68) *180 (150 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	43 (34 — 52) *140 (120 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 43) *120 (92 — 140)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (130 — 160) *460 (430 — 520)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	180 (150 — 200) *590 (500 — 650)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	600 (560 — 780) *1975 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	390 (360 — 500) *1275 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	260 (240 — 330) *850 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*

Parametri de așchiere – XSE550 – Frezare de canal PCEDC 3

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	45 (39 — 51) *150 (130 — 160)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	540 (500 — 690) *1775 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	345 (330 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 25) *65 (50 — 82)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*

Parametri de aşchiere – XSE550 – Frezare laterală PCEDC 3 – Inci

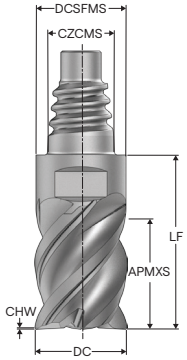
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*

Parametri de așchiere – XSE550 – Frezare de canal PCEDC 3 – Inci

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*

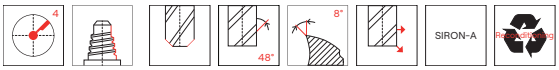
XSE550
Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Şanfren





D

—Toleranţe:
—DC= e7
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

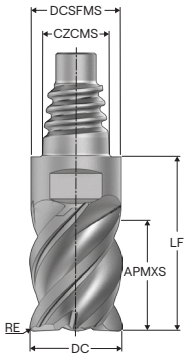


Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	CHW	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1CZ4	10219229	1	D	E10	10,0	9,7	5,5	12,3	0,125	4	8,0	■
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	4	8,0	■
XSE550E12120D1CZ4	10219230	1	D	E12	12,0	11,7	6,6	14,4	0,15	4	10,0	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	4	10,0	■
XSE550E16160D1CZ4	10219231	1	D	E16	16,0	15,5	8,8	18,6	0,2	4	12,0	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	4	12,0	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	4	16,0	■
XSE550E20200D1CZ4	10219232	1	D	E20	20,0	19,7	11,0	21,2	0,25	4	16,0	■
XSE550E25250D1CZ4	10219226	1	D	E25	25,0	24,2	13,75	25,5	0,3125	4	20,0	■

■ **Stoc standard.**

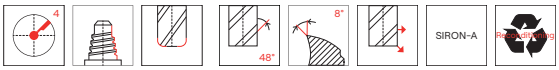
XSE550
Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Rază la vârf





D

—Toleranţe:
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

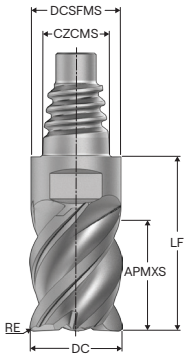


Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R100Z4	10219233	1	D	E10	10,0	9,7	5,5	12,3	1,0	4	8,0	■
XSE550E10100D1R200Z4	10219234	1	D	E10	10,0	9,7	5,5	12,3	2,0	4	8,0	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	0,5	4	8,0	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	1,0	4	8,0	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	0,5	4	8,0	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	2,0	4	8,0	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	2,5	4	8,0	■
XSE550E12120D1R100Z4	10219235	1	D	E12	12,0	11,7	6,6	14,4	1,0	4	10,0	■
XSE550E12120D1R200Z4	10219236	1	D	E12	12,0	11,7	6,6	14,4	2,0	4	10,0	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	0,5	4	10,0	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	1,0	4	10,0	■
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	0,5	4	10,0	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	2,0	4	10,0	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	3,0	4	10,0	■
XSE550E16160D1R100Z4	10219237	1	D	E16	16,0	15,5	8,8	18,6	1,0	4	12,0	■
XSE550E16160D1R200Z4	10219238	1	D	E16	16,0	15,5	8,8	18,6	2,0	4	12,0	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	0,5	4	12,0	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	1,0	4	12,0	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	0,5	4	12,0	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	2,0	4	12,0	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	3,0	4	12,0	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	1,0	4	16,0	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	1,0	4	16,0	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	2,0	4	16,0	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	3,0	4	16,0	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	4,0	4	16,0	■
XSE550E20200D1R200Z4	10219239	1	D	E20	20,0	19,7	11,0	21,2	2,0	4	16,0	■
XSE550E25250D1R100Z4	10219227	1	D	E25	25,0	24,2	13,75	25,5	1,0	4	20,0	■
XSE550E25250D1R200Z4	10219228	1	D	E25	25,0	24,2	13,75	25,5	2,0	4	20,0	■

■ **Stoc standard.**

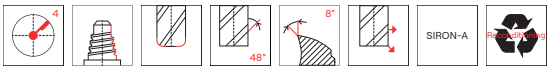
XSE550 – Inci
Înaltă performanţă – Universale – Pătrat – 4 Caneluri – Rază la vârf – Inci





D

—Toleranţe:
—DC= e7
—RE= ±.0008 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XSE550E10.375D1R030Z4	10138176	1	D	E10	0.375	0.364	0.206	0.484	0.030	4	8,0	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8,0	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10,0	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10,0	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16,0	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16,0	■

■ **Stoc standard.**

Parametri de așchiere – XSE550 – Frezare laterală PCEDC 4

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	165 (130 — 200) *540 (430 — 650)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	130 (97 — 160) *425 (320 — 520)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	125 (93 — 150) *410 (310 — 490)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	130 (98 — 160) *425 (330 — 520)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (91 — 150) *395 (300 — 490)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	85 (72 — 100) *280 (240 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	55 (46 — 68) *180 (160 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	95 (83 — 120) *310 (280 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	80 (69 — 100) *260 (230 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	47 (36 — 58) *155 (120 — 190)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 45) *120 (92 — 140)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	30 (23 — 37) *100 (76 — 120)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	130 (120 — 150) *425 (400 — 490)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (96 — 120) *360 (320 — 390)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	355 (290 — 420) *1175 (960 — 1300)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	240 (200 — 280) *790 (660 — 910)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	310 (280 — 380) *1025 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	90 (77 — 120) *295 (260 — 390)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	70 (59 — 93) *230 (200 — 300)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (47 — 74) *180 (160 — 240)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*

Parametri de așchiere – XSE550 – Frezare de canal PCEDC 4

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	75 (64 — 94) *245 (210 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	44 (38 — 55) *145 (130 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 110) *280 (250 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	70 (60 — 90) *230 (200 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	40 (30 — 50) *130 (99 — 160)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	30 (23 — 37) *100 (76 — 120)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	25 (19 — 31) *80 (63 — 100)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	320 (260 — 380) *1050 (860 — 1200)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	215 (180 — 250) *710 (600 — 820)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	280 (250 — 340) *920 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	80 (65 — 100) *260 (220 — 320)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 79) *195 (170 — 250)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	46 (39 — 61) *150 (130 — 200)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*

Parametri de așchiere – XSE550 – Frezare laterală PCEDC 4 – Inci

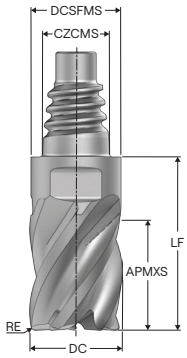
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*

Parametri de așchiere – XSE550 – Frezare de canal PCEDC 4 – Inci

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*

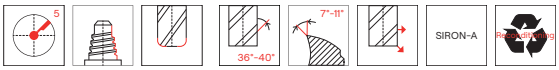
XSE550
Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Rază la vârf





D

—Toleranţe:
—DC= 0/-0,0508 mm
—RE= ±0,0254 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

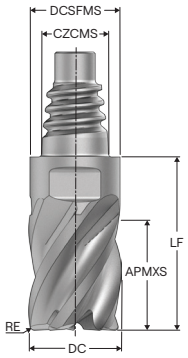


Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8,0	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8,0	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10,0	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10,0	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12,0	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12,0	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16,0	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16,0	■

■ **Stoc standard.**

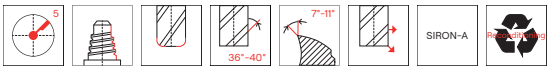
XSE550
Înaltă performanţă – Universale – Pătrat – 5 Caneluri – Rază la vârf – Inci





D

—Toleranţe:
—DC= 0/-.002 Inci
—RE= ±.001 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XSE550E10.375D2R015Z5	10138345	2	D	E10	0.375	0.364	0.450	0.720	0.015	5	8,0	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8,0	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8,0	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10,0	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10,0	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10,0	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12,0	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12,0	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12,0	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16,0	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16,0	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16,0	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20,0	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20,0	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20,0	■

■ **Stoc standard.**

Parametri de așchiere – XSE550 – Frezare laterală PCEDC 5

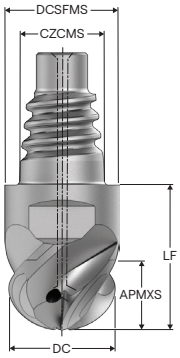
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	165 (130 — 190) *540 (430 — 620)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	160 (130 — 190) *520 (430 — 620)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 160) *460 (370 — 520)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	125 (97 — 140) *410 (320 — 450)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (97 — 130) *360 (320 — 420)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 150) *410 (370 — 490)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	110 (97 — 130) *360 (320 — 420)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	130 (120 — 150) *425 (400 — 490)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	115 (98 — 130) *375 (330 — 420)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	100 (83 — 110) *330 (280 — 360)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	95 (79 — 100) *310 (260 — 320)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	105 (89 — 130) *345 (300 — 420)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	155 (130 — 190) *510 (430 — 620)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	27 (24 — 41) *90 (79 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	26 (21 — 35) *85 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	25 (19 — 30) *80 (63 — 98)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (52 — 88) *215 (180 — 280)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	50 (40 — 68) *165 (140 — 220)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	41 (32 — 54) *135 (110 — 170)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*

Parametri de așchiere – XSE550 – Frezare laterală PCEDC 5 – Inci

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*

XSB540
Înaltă performanţă – Universale – Cap sferic – 4 Caneluri





D

- Toleranţe:
- DC= e8
- RE= ±0,02 mm
- Reascuţire posibilă dacă DC este ≥ Ø12 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
						mm	mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	■	E10	10,0	9,7	5,5	12,3	5,0	4	8,0	■
XSB540E12120D1BZ4A	10138335	1	D	■	E12	12,0	11,7	6,6	14,4	6,0	4	10,0	■
XSB540E16160D1BZ4A	10138336	1	D	■	E16	16,0	15,5	8,8	18,6	8,0	4	12,0	■

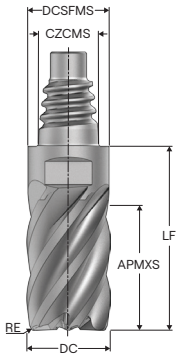
■ **Stoc standard.**

Parametri de așchiere – XSB540 Degroșare pentru frezare prin copiere

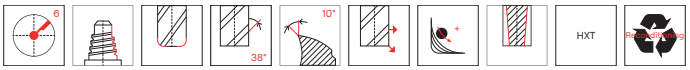
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	190 (160 — 220) *620 (530 — 720)*
P12	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M1	E/M/A	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	145 (120 — 170) *475 (400 — 550)*
M2	E/M/A	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M3	E/M/A	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	95 (75 — 110) *310 (250 — 360)*
M4	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	75 (57 — 88) *245 (190 — 280)*
M5	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	60 (48 — 74) *195 (160 — 240)*
K1	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	205 (190 — 220) *670 (630 — 720)*
K2	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	180 (160 — 190) *590 (530 — 620)*
K3	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	150 (140 — 160) *490 (460 — 520)*
K4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	170 (150 — 190) *560 (500 — 620)*
K5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	105 (90 — 110) *345 (300 — 360)*
K6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	150 (140 — 160) *490 (460 — 520)*
K7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	130 (120 — 140) *425 (400 — 450)*
N1	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	640 (540 — 740) *2100 (1800 — 2400)*
N2	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	275 (230 — 320) *900 (760 — 1000)*
N11	E/M/A	0,15 *0.15*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	430 (380 — 480) *1400 (1300 — 1500)*
S1	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (54 — 74) *215 (180 — 240)*
S2	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (59 — 75) *215 (200 — 240)*
S3	E	0,10 *0.10*	0,50 *0.50*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	32 (22 — 42) *105 (73 — 130)*
S11	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	110 (98 — 120) *360 (330 — 390)*
S12	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 96) *280 (250 — 310)*
S13	E	0,15 *0.15*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	65 (59 — 75) *215 (200 — 240)*
H5	M/A	0,030 *0.030*	0,44 *0.44*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
H8	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H21	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H31	M/A	0,030 *0.030*	0,44 *0.44*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	100 (86 — 110) *330 (290 — 360)*
TS1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
TP1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*

XSE720
Înaltă performanţă – Superaliaj – Pătrat – 6 Caneluri – Rază la vârf





D



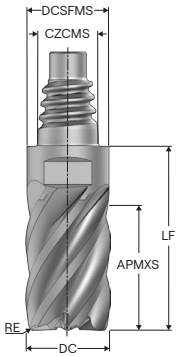
—Toleranţe:
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8,0	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8,0	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10,0	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10,0	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10,0	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10,0	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12,0	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12,0	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12,0	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12,0	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16,0	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16,0	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16,0	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16,0	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20,0	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20,0	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20,0	■

■ **Stoc standard.**

XSE720
Înaltă performanţă – Superaliaj – Pătrat – 6 Caneluri – Raza la colţ sau colţ viu – Inci





D

—Toleranţe:
—DC= e7
—RE= ±.0008 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			HXT
XSE720E10.375D3SZ6	10138204	3	D	E10	0.375	0.364	0.563	0.827	–	6	8,0	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8,0	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10,0	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10,0	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10,0	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.120	6	10,0	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12,0	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12,0	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12,0	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.120	6	12,0	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16,0	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16,0	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16,0	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.120	6	16,0	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20,0	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20,0	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20,0	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.120	6	20,0	■

■ **Stoc standard.**

Parametri de așchiere – XSE720 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	230 (180 — 280) *750 (600 — 910)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 230) *640 (500 — 750)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	170 (130 — 200) *560 (430 — 650)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	130 (100 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (120 — 190) *475 (400 — 620)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 180) *460 (370 — 590)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	130 (100 — 160) *425 (330 — 520)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	130 (110 — 170) *425 (370 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 130) *395 (330 — 420)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 88) *245 (210 — 280)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XSE720 degroşare avansată

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	245 (190 — 300) *800 (630 — 980)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	240 (190 — 290) *790 (630 — 950)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	205 (160 — 250) *670 (530 — 820)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	185 (140 — 220) *610 (460 — 720)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (130 — 200) *510 (430 — 650)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 190) *490 (400 — 620)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 180) *460 (370 — 590)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 110) *310 (270 — 360)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 92) *260 (220 — 300)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – XSE720 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

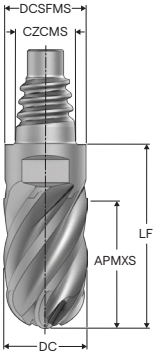
Parametri de aşchiere – XSE720 degroşare avansată – Inci

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

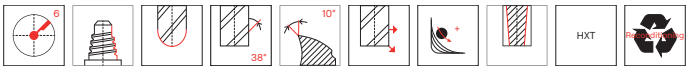
XSB720
Înaltă performanţă – Superaliaj – Cap sferic – 6 Caneluri





D

—Toleranţe:
—DC= e7
—RE= ±0,02 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

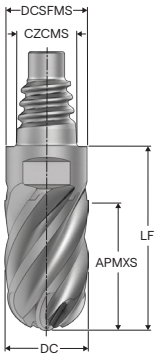


Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	5,0	6	8,0	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6,0	6	10,0	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	8,0	6	12,0	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	10,0	6	16,0	■

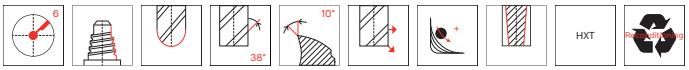
■ **Stoc standard.**

XSB720
Înaltă performanţă – Superaliaj – Cap sferic – 6 Caneluri – Inci





D



—Toleranţe:
—DC= e7
—RE= ±.0008 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	0.188	6	8,0	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	0.250	6	10,0	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	0.313	6	12,0	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	0.375	6	16,0	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	0.500	6	20,0	■

■ **Stoc standard.**

Parametri de așchiere – XSB720 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	185 (150 — 140) *610 (500 — 450)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	175 (140 — 130) *570 (460 — 420)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 110) *510 (400 — 360)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 100) *445 (370 — 320)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	130 (110 — 100) *425 (370 — 320)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (120 — 110) *475 (400 — 360)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 100) *460 (370 — 320)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	130 (99 — 98) *425 (330 — 320)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	140 (110 — 100) *460 (370 — 320)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	85 (68 — 67) *280 (230 — 210)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	140 (120 — 160) *460 (400 — 520)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	75 (65 — 89) *245 (220 — 290)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (47 — 77) *195 (160 — 250)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XSB720 Frezare laterală degroşare avansată a_e/DC=0,07

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	195 (160 — 150) *640 (530 — 490)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	190 (150 — 140) *620 (500 — 450)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	165 (130 — 120) *540 (430 — 390)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	145 (120 — 110) *475 (400 — 360)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (130 — 120) *520 (430 — 390)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	150 (120 — 110) *490 (400 — 360)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 110) *490 (400 — 360)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	95 (73 — 72) *310 (240 — 230)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	185 (160 — 200) *610 (530 — 650)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (81 — 110) *310 (270 — 360)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	80 (68 — 93) *260 (230 — 300)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	65 (49 — 81) *215 (170 — 260)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – XSB720 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XSB720 Frezare laterală degroşare avansată a_e/DC=0,07

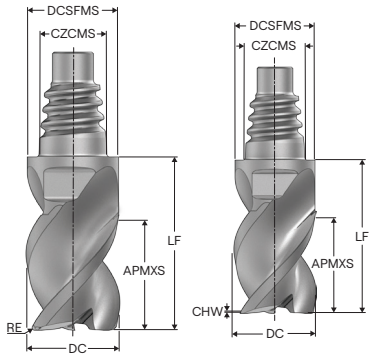
SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

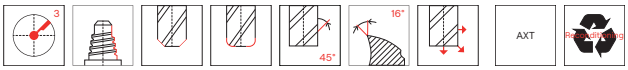
SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

XSE450

Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Raza la colţ sau şanfrenul







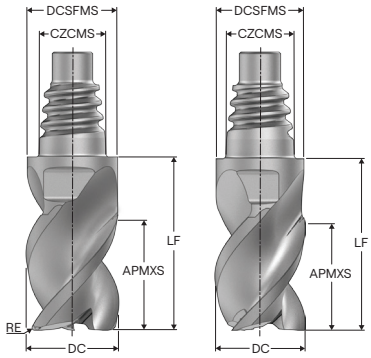
—Toleranţe:
—DC= 0/-0,0508 mm
—RE= ±0,0254 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm

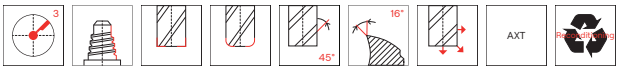
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm	mm			AXT
XSE450E10100D2CZ3	10271542	2	D	E10	10,0	9,7	12,0	18,7	0,1	–	3	8,0	■
XSE450E10100D2R100Z3	10271547	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE450E12120D2CZ3	10271543	2	D	E12	12,0	11,7	14,4	22,1	0,1	–	3	10,0	■
XSE450E12120D2R300Z3	10271551	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	3	10,0	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE450E16160D2CZ3	10271544	2	D	E16	16,0	15,5	19,2	29,2	0,1	–	3	12,0	■
XSE450E16160D2R300Z3	10271553	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	3	12,0	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE450E20200D2CZ3	10271545	2	D	E20	20,0	19,3	24,0	34,3	0,1	–	3	16,0	■
XSE450E20200D2R300Z3	10271555	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	3	16,0	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	3	16,0	■

■ **Stoc standard.**

XSE450
Înaltă performanţă – Aluminiu – Pătrat – 3 Caneluri – Rază la vârf sau ascuţit – Inci







—Toleranţe:
—DC= 0/-.002 Inci
—RE= ±.001 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			AXT
XSE450E10.375D2R010Z3	10271561	2	D	E10	0.375	0.364	0.450	0.720	0.010	3	8,0	■
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8,0	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE450E12.500D2R010Z3	10271562	2	D	E12	0.500	0.484	0.600	0.906	0.010	3	10,0	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10,0	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10,0	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12,0	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12,0	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12,0	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12,0	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16,0	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16,0	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16,0	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20,0	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20,0	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20,0	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20,0	■

■ **Stoc standard.**

Parametri de așchiere – XSE450 Frezare laterală

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	405 (340 — 450) *1325 (1200 — 1400)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	275 (230 — 330) *900 (760 — 1000)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	185 (150 — 220) *610 (500 — 720)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	245 (200 — 290) *800 (660 — 950)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	280 (170 — 390) *920 (560 — 1200)*

Parametri de așchiere – XSE450 Frezare de canal

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
N1	E/M/A	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	370 (310 — 410) *1225 (1100 — 1300)*
N2	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	255 (210 — 300) *840 (690 — 980)*
N3	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	170 (140 — 200) *560 (460 — 650)*
N11	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	225 (190 — 270) *740 (630 — 880)*
TS1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 1100)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XSE450 Frezare laterală – Inci

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

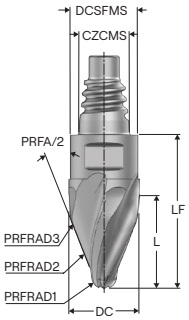
Parametri de aşchiere – XSE450 Frezare de canal – Inci

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

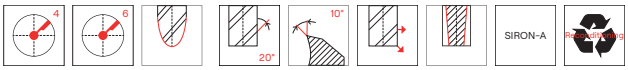
XHT740
Viteză mare – ISO– M și ISO– S – Formă conică – 4-6 Caneluri





T

—Toleranţe:
—PRFRAD1= ±0,03 mm
—Toleranţă formare PRFRAD2= 0,02 mm
—Reascuţire posibilă dacă DC este ≥Ø12 mm şi PRFRAD1 este ≥1,5 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	L	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	1,62	18,7	5,4	1,5	250,0	2,0	65,0	4	8,0	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	4	8,0	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	6	8,0	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	5,33	22,1	10,5	3,0	250,0	6,0	32,5	4	10,0	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	4	10,0	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	6	10,0	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	8,95	29,2	14,6	4,0	500,0	8,0	27,5	4	12,0	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	21,02	34,1	24,0	4,0	1000,0	5,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	6	12,0	■

■ **Stoc standard.**

Parametri de aşchiere – XHT740 – Frezare prin copiere PCEDC 4

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

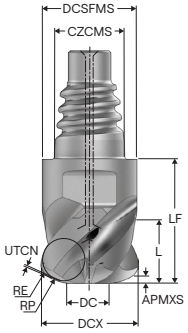
Parametri de aşchiere – XHT740 – Frezare prin copiere PCEDC 6

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

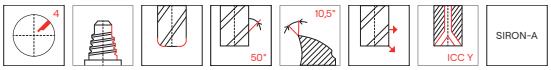
XHF580
Avans mare – Universale – 4 Caneluri – Rază la vârf





D

– Toleranţe:
– DCX= h9
– RE= ±0,03 mm



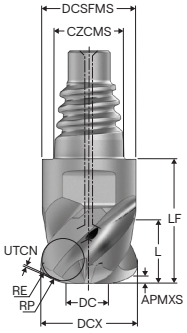
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Calitate
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	■	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8,0	■
XHF580E12120D1HZ4A	10137972	1	D	■	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10,0	■
XHF580E16160D1HZ4A	10137973	1	D	■	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12,0	■

■ **Stoc standard.**

XHF580

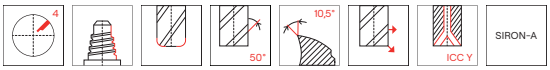
Avans mare – Universale – 3-4 Caneluri – Rază la vârf – Inci





D

—Toleranţe:
—DCX= h9
—RE= ±.0012 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Calitate
						Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XHF580E10.375D1HZ4A	10137974	1	D	■	E10	0.375	0.134	0.364	0.024	0.236	0.488	0.060	0.076	0.008	4	8,0	■
XHF580E12.500D1HZ4A	10137975	1	D	■	E12	0.500	0.197	0.484	0.033	0.315	0.571	0.060	0.086	0.014	4	10,0	■
XHF580E16.625D1HZ4A	10137976	1	D	■	E16	0.625	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12,0	■

■ **Stoc standard.**

Parametri de așchiere – XHF580 Frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (330 — 400) *1150 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	340 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	190 (180 — 230) *620 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 220) *590 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	170 (160 — 200) *560 (530 — 650)*
P11	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	145 (150 — 170) *475 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	170 (170 — 200) *560 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 99) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (330 — 400) *1125 (1100 — 1300)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	300 (280 — 340) *980 (920 — 1100)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	250 (240 — 290) *820 (790 — 950)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	240 (230 — 280) *790 (760 — 910)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	145 (140 — 160) *475 (460 — 520)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	210 (200 — 240) *690 (660 — 780)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (180 — 210) *610 (600 — 680)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	125 (120 — 150) *410 (400 — 490)*
S13	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (91 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (74 — 100) *260 (250 — 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XHF580 Frezare de canal

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	320 (300 — 360) *1050 (990 — 1100)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (250 — 300) *870 (830 — 980)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	175 (160 — 210) *570 (530 — 680)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (150 — 200) *540 (500 — 650)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P11	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (130 — 160) *425 (430 — 520)*
P12	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (75 — 94) *260 (250 — 300)*
M1	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	155 (150 — 180) *510 (500 — 590)*
M2	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	125 (120 — 150) *410 (400 — 490)*
M3	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 110) *310 (290 — 360)*
M4	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (66 — 89) *230 (220 — 290)*
M5	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	60 (55 — 74) *195 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (300 — 360) *1025 (990 — 1100)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (260 — 310) *890 (860 — 1000)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	220 (210 — 250) *720 (690 — 820)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	130 (130 — 150) *425 (430 — 490)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	190 (180 — 220) *620 (600 — 720)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (160 — 190) *540 (530 — 620)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	39 (32 — 62) *130 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (26 — 50) *100 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	27 (22 — 43) *90 (73 — 140)*
S11	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	150 (150 — 180) *490 (500 — 590)*
S12	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	115 (110 — 140) *375 (370 — 450)*
S13	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	90 (85 — 100) *295 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (67 — 91) *230 (220 — 290)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – XHF580 Frezare laterală – Inci

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

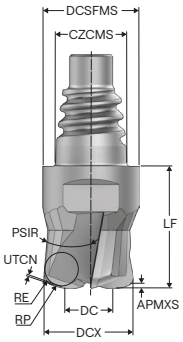
Parametri de aşchiere – XHF580 Frezare de canal – Inci

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

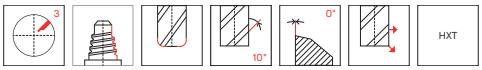
XHF780
Avans mare – ISO– M și ISO– S – 3 Caneluri – Rază la vârf





D

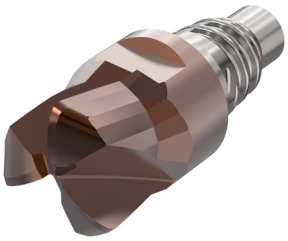
– Toleranțe:
– DCX= -0,02/-0,04 mm
– RE= ±0,05 mm

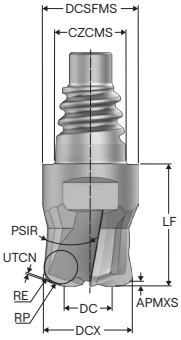


Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm	mm	mm	mm	mm			HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	5,5	12,3	0,8	1,175	0,232	3	8,0	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	6,6	14,4	1,0	1,416	0,262	3	10,0	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	8,8	18,6	1,5	1,989	0,32	3	12,0	■

■ **Stoc standard.**

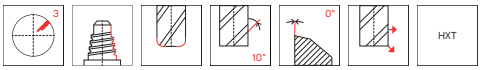
XHF780
Avans mare – ISO– M şi ISO– S – 3 Caneluri – Rază la vârf – Inci





D

—Toleranţe:
—DCX= -.0008/-0.0016 Inci
—RE= ±.002 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*			HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.206	0.484	0.028	0.043	0.009	3	8,0	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.500	0.250	0.484	0.020	0.276	0.567	0.045	0.061	0.010	3	10,0	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.343	0.732	0.061	0.080	0.012	3	12,0	■

■ **Stoc standard.**

Parametri de așchiere – XHF780 Frezare laterală

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	355 (330 — 410) *1175 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	195 (180 — 230) *640 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (170 — 220) *610 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	175 (160 — 210) *570 (530 — 680)*
P11	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 210) *590 (560 — 680)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	175 (170 — 210) *570 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 100) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	120 (120 — 150) *395 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (90 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	135 (130 — 170) *445 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (75 — 100) *260 (250 — 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de aşchiere – XHF780 Frezare de canal

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	300 (290 — 350) *980 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (250 — 300) *850 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	170 (160 — 200) *560 (530 — 650)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	160 (150 — 190) *520 (500 — 620)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	150 (140 — 180) *490 (460 — 590)*
P11	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (73 — 92) *245 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	150 (150 — 180) *490 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	120 (120 — 140) *395 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (85 — 110) *295 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (64 — 87) *215 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (53 — 72) *180 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (31 — 60) *125 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	30 (25 — 48) *100 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	26 (21 — 41) *85 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	145 (140 — 170) *475 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	110 (110 — 130) *360 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	85 (82 — 100) *280 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	115 (110 — 140) *375 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (65 — 88) *230 (220 — 280)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

Parametri de așchiere – XHF780 Frezare laterală – Inci

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

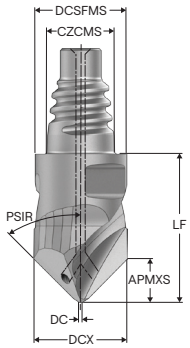
Parametri de aşchiere – XHF780 Frezare de canal – Inci

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = grup de materiale
Lichid de răcire = A=aer D=uscat E=emulsie M=pulverizare fină
v_c= m/min (sf/min)
f_z = mm (in/dinte)
a_p = mm/DC (in/DC) = factor
a_e = mm/DC (in/DC) = factor
Toate regimurile de frezare sunt valori ţintă

XS5021
Înaltă performanţă – Universale – Şanfren –2 Caneluri





N

– Toleranţe:
– DCX= 0,02/-0,04 mm
– PSIR= ±0,5°
– Reascuţire posibilă dacă DC este ≥ Ø12 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm				SIRA
XS5021-E10100N1SZ2T45A	10343896	1	N	E10	0,5	10,0	9,7	7,1	16,0	45,0	2	8,0	■
XS5021-E12120N1SZ2T45A	10343897	1	N	E12	0,6	12,0	11,7	8,6	19,0	45,0	2	10,0	■
XS5021-E16160N1SZ2T45A	10343898	1	N	E16	0,8	16,0	15,5	12,0	26,4	45,0	2	12,0	■

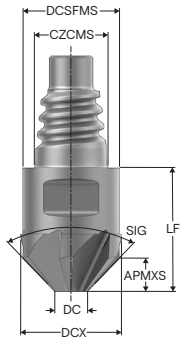
■ **Stoc standard.**

Parametri de aşchiere – XS5021 Şanfrenare

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,07 *0.0028*	0,06 *0.0024*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0037*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	45 (25 — 55) *145 (80 — 185)*

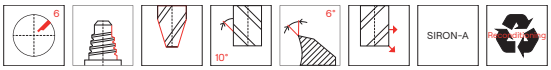
XS5061
Înaltă performanţă – Universale – Şanfren –6 Caneluri





N

—Toleranţe:
—PSIR= ±0,5°
—Reascuţire posibilă dacă DC este ≥ Ø12 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm				SIRA
XS5061-E10100N1SZ6T45	10219277	1	N	E10	1,95	10,1	9,7	4,075	12,3	45,0	6	8,0	■
XS5061-E12120N1SZ6T45	10219278	1	N	E12	2,95	12,1	11,7	4,575	14,4	45,0	6	10,0	■
XS5061-E16160N1SZ6T45	10219279	1	N	E16	3,95	16,1	15,5	6,075	18,6	45,0	6	12,0	■

■ **Stoc standard.**

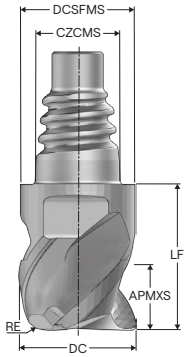
Parametri de așchiere – XS5061 Șanfrenare

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,055 *0.0022*	0,05 *0.0020*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,065 *0.0026*	0,075 *0.0030*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,055 *0.0022*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	45 (25 — 55) *145 (80 — 185)*

XVE540

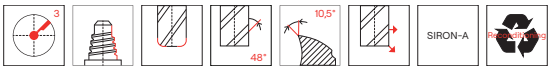
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D

—Toleranţe:
—DC= h9
—RE= ±0,015 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm



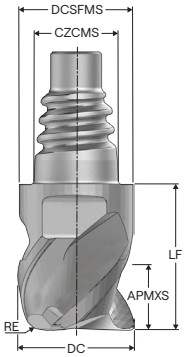
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8,0	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10,0	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12,0	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16,0	■

■ **Stoc standard.**

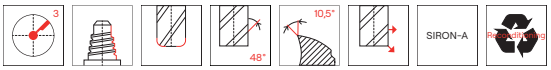
XVE540

Uz general – Universale – Pătrat – 3 Caneluri – Rază la vârf





D



—Toleranţe:
—DC= h9
—RE= .015 Inci= ±.0006 Inci
—RE= .031 Inci= ±.0012 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XVE540E10.375D1R015Z3	10137985	1	D	E10	0.375	0.364	0.209	0.488	0.015	3	8,0	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10,0	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12,0	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16,0	■

■ **Stoc standard.**

Parametri de așchiere – XVE540 – Frezare laterală PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 220) *570 (460 — 720)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (100 — 160) *445 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	145 (110 — 170) *475 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 93) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (45 — 59) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (81 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (67 — 88) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	50 (39 — 60) *165 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 39) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (95 — 120) *360 (320 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	550 (510 — 710) *1800 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	355 (330 — 450) *1175 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.50*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 32) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 79) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Parametri de așchiere – XVE540 – Frezare de canal PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	44 (38 — 49) *145 (130 — 160)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 55) *150 (120 — 180)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (89 — 110) *345 (300 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (85 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (330 — 450) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 300) *750 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 350) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (22 — 34) *90 (73 — 110)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (18 — 29) *75 (60 — 95)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (51 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

Parametri de așchiere – XVE540 – Frezare laterală PCEDC 3 – Inci

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

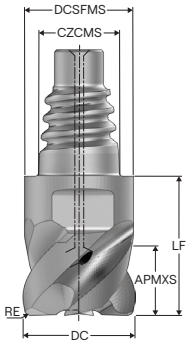
Parametri de așchiere – XVE540 – Frezare de canal PCEDC 3 – Inci

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

XVE540

Uz general – Universale – Pătrat – 4 Caneluri – Rază la vârf





D

—Toleranţe:
—DC= h9
—RE= ±0,015 mm
—Reascuţire posibilă dacă DC este ≥ Ø12 mm



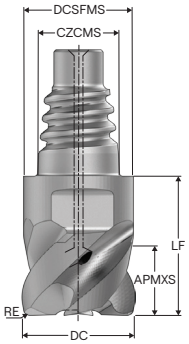
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	■	E10	10,0	9,7	6,0	12,4	0,5	4	8,0	■
XVE540E12120D1R050Z4A	10137990	1	D	■	E12	12,0	11,7	7,5	14,5	0,5	4	10,0	■
XVE540E16160D1R050Z4A	10137991	1	D	■	E16	16,0	15,5	10,0	18,7	0,5	4	12,0	■
XVE540E20200D1R050Z4A	10137992	1	D	■	E20	20,0	19,3	12,0	21,3	0,5	4	16,0	■

■ **Stoc standard.**

XVE540

Uz general – Universale – Pătrat – 4 Caneluri – Rază la vârf – Inci





D



—Toleranţe:
—DC= h9
—RE= .015 Inci= ±.0006 Inci
—RE= .031 Inci= ±.0012 Inci
—Reascuţire posibilă dacă DC este ≥ Ø.500 Inci

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
						Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XVE540E10.375D1R015Z4A	10137993	1	D	■	E10	0.375	0.364	0.236	0.488	0.015	4	8,0	■
XVE540E12.500D1R031Z4A	10137994	1	D	■	E12	0.500	0.484	0.315	0.571	0.031	4	12,0	■
XVE540E16.625D1R031Z4A	10137995	1	D	■	E16	0.625	0.610	0.394	0.736	0.031	4	16,0	■
XVE540E20.750D1R031Z4A	10137996	1	D	■	E20	0.750	0.728	0.453	0.839	0.031	4	18,0	■

■ **Stoc standard.**

Parametri de așchiere – XVE540 – Frezare laterală PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 210) *570 (460 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	130 (99 — 160) *425 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 92) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (44 — 58) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (80 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (66 — 87) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	49 (39 — 60) *160 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 38) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (94 — 120) *360 (310 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (160 — 220) *660 (530 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	350 (330 — 450) *1150 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.55*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 31) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 78) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Parametri de așchiere – XVE540 – Frezare de canal PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 200) *520 (430 — 650)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	155 (120 — 190) *510 (400 — 620)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 160) *445 (370 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (96 — 150) *410 (320 — 490)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (91 — 150) *395 (300 — 490)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (63 — 83) *245 (210 — 270)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	43 (37 — 49) *140 (130 — 160)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (74 — 98) *280 (250 — 320)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	33 (26 — 40) *110 (86 — 130)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (88 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	95 (84 — 110) *310 (280 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	530 (500 — 690) *1750 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (320 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

Parametri de așchiere – XVE540 – Frezare laterală PCEDC 4 – Inci

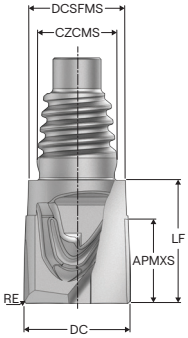
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Parametri de așchiere – XVE540 – Frezare de canal PCEDC 4 Inci

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

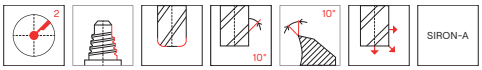
XVE510
Uz general – Universale – Pătrat – 2 Caneluri – Rază la vârf





D

—Toleranţe:
—DC= h10
—RE= ±0,015 mm



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XVE510E10100D1R050Z2	10138003	1	D	E10	10,0	9,7	8,0	11,8	0,5	2	6,0	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8,0	■

■ **Stoc standard.**

Parametri de aşchiere – XVE510 Frezare laterală

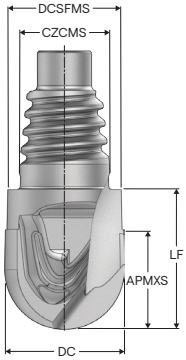
SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	210 (170 — 250) *690 (560 — 820)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	205 (170 — 240) *670 (560 — 780)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (150 — 210) *570 (500 — 680)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (140 — 200) *570 (460 — 650)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	165 (140 — 190) *540 (460 — 620)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	115 (82 — 140) *375 (270 — 450)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,080 *0.0032*	70 (50 — 89) *230 (170 — 290)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (97 — 170) *445 (320 — 550)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	110 (78 — 130) *360 (260 — 420)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (55 — 85) *230 (190 — 270)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	50 (41 — 64) *165 (140 — 200)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	44 (35 — 53) *145 (120 — 170)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (110 — 150) *425 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	230 (190 — 270) *750 (630 — 880)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	100 (83 — 110) *330 (280 — 360)*
N1	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	470 (410 — 530) *1550 (1400 — 1700)*
N2	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	305 (270 — 340) *1000 (890 — 1100)*
N3	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	200 (180 — 230) *660 (600 — 750)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	370 (300 — 440) *1225 (990 — 1400)*
S1	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	60 (39 — 85) *195 (130 — 270)*
S2	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	55 (32 — 77) *180 (110 — 250)*
S3	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	39 (24 — 54) *130 (79 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	95 (78 — 100) *310 (260 — 320)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (61 — 84) *230 (210 — 270)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
GR1	A/D	0,20 *0.20*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	570 (510 — 630) *1875 (1700 — 2000)*

Parametri de așchiere – XVE510 Frezare de canal

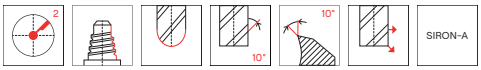
SMG		a_p/DC	f_z		v_c
			10	12	
P1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	135 (110 — 160) *445 (370 — 520)*
P2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	130 (110 — 150) *425 (370 — 490)*
P3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	115 (91 — 130) *375 (300 — 420)*
P4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 110) *330 (270 — 360)*
P5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	75 (53 — 94) *245 (180 — 300)*
P12	E/M/A/D	0,40 *0.40*	0,040 *0.0016*	0,048 *0.0019*	46 (33 — 58) *150 (110 — 190)*
M1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (62 — 110) *280 (210 — 360)*
M2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	70 (50 — 89) *230 (170 — 290)*
M3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	28 (23 — 34) *90 (76 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (70 — 97) *280 (230 — 310)*
K5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 120) *330 (270 — 390)*
K6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	65 (54 — 74) *215 (180 — 240)*
N1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
N2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	225 (200 — 250) *740 (660 — 820)*
N3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (130 — 170) *490 (430 — 550)*
N11	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (200 — 290) *820 (660 — 950)*
S1	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	40 (25 — 54) *130 (83 — 170)*
S2	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	35 (20 — 49) *115 (66 — 160)*
S3	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (65 — 90) *260 (220 — 290)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	60 (50 — 69) *195 (170 — 220)*
S13	E	0,42 *0.42*	0,050 *0.0020*	0,060 *0.0024*	47 (39 — 54) *155 (130 — 170)*
TS1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
TP1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
GR1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	450 (400 — 490) *1475 (1400 — 1600)*

XVB510
Uz general – Universale – Cap sferic – 2 Caneluri





D



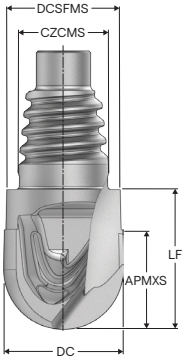
—Toleranţe:
—DC= h9
—RE= ±0,01 mm

Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	5,0	2	6,0	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	6,0	2	8,0	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	8,0	2	10,0	■

■ **Stoc standard.**

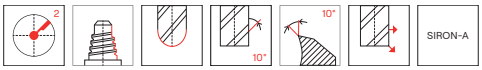
XVB510
Uz general – Universale – Cap sferic – 2 Caneluri – Inci





D

—Toleranţe:
—DC= h9
—RE= ±.0004 Inci



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					Inci	*Inci*	*Inci*	*Inci*	*Inci*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	0.187	2	6,0	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	0.250	2	8,0	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.625	0.610	0.512	0.713	0.313	2	10,0	■

■ **Stoc standard.**

Parametri de așchiere – XVB510 Degroșare pentru frezare prin copiere

SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 180) *490 (430 — 590)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	145 (120 — 170) *475 (400 — 550)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (50 — 78) *215 (170 — 250)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	39 (30 — 47) *130 (99 — 150)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 91) *245 (200 — 290)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	46 (36 — 55) *150 (120 — 180)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	38 (30 — 46) *125 (99 — 150)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 150) *425 (370 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	125 (110 — 150) *410 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (63 — 94) *260 (210 — 300)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	115 (93 — 130) *375 (310 — 420)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (81 — 120) *330 (270 — 390)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	285 (250 — 320) *940 (830 — 1000)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	190 (170 — 210) *620 (560 — 680)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	335 (270 — 400) *1100 (890 — 1300)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	55 (33 — 76) *180 (110 — 240)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	44 (27 — 61) *145 (89 — 200)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	38 (23 — 52) *125 (76 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (88 — 120) *345 (290 — 390)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (68 — 94) *260 (230 — 300)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (53 — 73) *215 (180 — 230)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	630 (570 — 700) *2075 (1900 — 2200)*

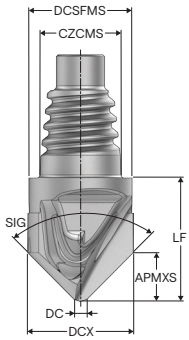
Parametri de așchiere – XVB510 Degroșare pentru frezare prin copiere – Inci

SMG		a_e/DC	a_p/DC	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

XVC506/509/512

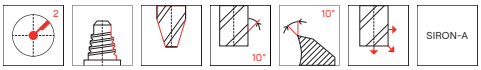
Uz general – Universale – Şanfren – 2 Caneluri





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—Toleranţe:
—SIG= ±1°



Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Calitate
					mm	mm	mm	mm			SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	1,5	9,7	7,23	11,8	2	6,0	■
XVC509E10100N1SZ2	10138014	1	N	E10	1,5	9,7	4,23	11,8	2	6,0	■
XVC506E12120N1SZ2	10138013	1	N	E12	1,5	11,7	7,73	14,0	2	8,0	■
XVC509E12120N1SZ2	10138015	1	N	E12	1,5	11,7	5,23	14,0	2	8,0	■
XVC512E12120N1SZ2	10138017	1	N	E12	1,5	11,7	3,03	14,0	2	8,0	■
XVC509E16160N1SZ2	10138016	1	N	E16	1,5	15,5	7,23	18,1	2	10,0	■

■ **Stoc standard.**

Parametri de așchiere – XVC506 Șanfrenare

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	105 (86 — 120) *345 (290 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,15 *0.0060*	0,16 *0.0065*	65 (52 — 76) *215 (180 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,26 *0.010*	0,28 *0.011*	125 (99 — 140) *410 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	47 (33 — 60) *155 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	150 (130 — 160) *490 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	30 (10 — 49) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	95 (72 — 120) *310 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	55 (43 — 72) *180 (150 — 230)*
H5	M/A	0,050 *0.050*	2,0 *2.0*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,050 *0.050*	1,8 *1.8*	0,070 *0.0028*	0,075 *0.0030*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*

Parametri de așchiere – XVC509 Șanfrenare

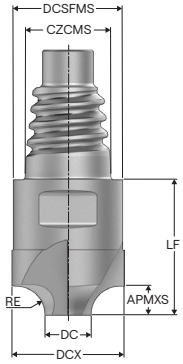
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	150 (130 — 160) *490 (430 — 520)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	105 (85 — 120) *345 (280 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	60 (50 — 74) *195 (170 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	120 (98 — 140) *395 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	125 (110 — 130) *410 (370 — 420)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	30 (10 — 50) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	55 (42 — 72) *180 (140 — 230)*
H5	M/A	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,10 *0.10*	1,8 *1.8*	0,075 *0.0030*	0,080 *0.0032*	0,085 *0.0034*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*

Parametri de așchiere – XVC512 Șanfrenare

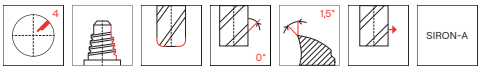
SMG		a_e/DC	a_p/DC	f_z	v_c
				12	
P1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	165 (150 — 180) *540 (500 — 590)*
P2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 170) *520 (460 — 550)*
P3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	135 (120 — 150) *445 (400 — 490)*
P7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	125 (120 — 140) *410 (400 — 450)*
P8	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P11	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	85 (68 — 100) *280 (230 — 320)*
P12	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,22 *0.0085*	50 (41 — 61) *165 (140 — 200)*
M1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	100 (80 — 110) *330 (270 — 360)*
M2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (65 — 96) *260 (220 — 310)*
M3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	50 (37 — 68) *165 (130 — 220)*
M4	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	39 (28 — 51) *130 (92 — 160)*
M5	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	33 (23 — 42) *110 (76 — 130)*
K1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	140 (130 — 150) *460 (430 — 490)*
K3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	115 (110 — 130) *375 (370 — 420)*
K4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	110 (98 — 120) *360 (330 — 390)*
K5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	65 (58 — 75) *215 (200 — 240)*
K6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	85 (74 — 96) *280 (250 — 310)*
N1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*
N2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	310 (260 — 360) *1025 (860 — 1100)*
N3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	205 (180 — 240) *670 (600 — 780)*
N11	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	320 (290 — 360) *1050 (960 — 1100)*
S1	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	35 (12 — 58) *115 (40 — 190)*
S2	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	29 (9,6 — 47) *95 (32 — 150)*
S3	E	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	25 (8,3 — 41) *80 (28 — 130)*
S11	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (58 — 98) *260 (200 — 320)*
S12	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	60 (45 — 76) *195 (150 — 240)*
S13	E	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	47 (35 — 59) *155 (120 — 190)*
H5	M/A	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	100 (83 — 110) *330 (280 — 360)*
H8	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H21	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H31	M/A	0,10 *0.10*	1,3 *1.3*	0,11 *0.0044*	75 (64 — 88) *245 (210 — 280)*
TS1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
TP1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*

XVK310
Uz general – Universale – Concav – 4 Caneluri





– Toleranţe:
– RE= ≤5= ±0,05 mm
– RE= >5= ±0,1 mm



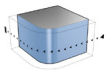
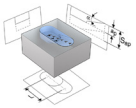
Reper Nr.	Număr reper	Indice lungime	Profilul sculei	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Calitate
					mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K400Z4	10137999	1	D	E12	4,0	11,7	4,0	14,5	4,0	4	10,0	■
XVK310E12120D1K300Z4	10137998	1	D	E12	5,0	11,7	3,0	14,5	3,0	4	10,0	■
XVK310E16160D1K500Z4	10138000	1	D	E16	6,0	15,5	5,0	18,7	5,0	4	12,0	■
XVK310E20200D1K600Z4	10138001	1	D	E20	8,0	19,3	6,0	21,3	6,0	4	16,0	■

■ **Stoc standard.**

Parametri de așchiere – XVK310 Degroșare prin frezare laterală

SMG		a_p/D_c	f_z			v_c
			12	16	20	
P1	E/M/A/D	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A/D	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	105 (70 — 115) *345 (220 — 375)*
N1	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S1	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S2	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S3	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S11	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	265 (180 — 285) *870 (590 — 940)*
S12	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S13	E	0,24 *0,24*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	155 (105 — 165) *510 (345 — 540)*
TS1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*

Recalculare

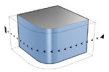
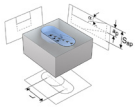
Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!										Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!				
	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal		
Drept														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360º (% din DC)	gaură Ø (≥ % din DC)
										≤ 30° *				
C5121														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
										≤ 10° *				
C5131														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
										≤ 30° *				
C5141														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
LV9	x	x	100%	17%	100%	17%	100%	17%	100%	100%	25%	25%	100%	170%
										≤ 10° *				
C5231														
LV2	100%	100%	100%	100%	100%	100%	80%	100%	80%	100%	100%	100%	100%	100%
LV3	70%	80%	100%	80%	100%	80%	64%	100%	64%	100%	100%	85%	85%	100%
										≤ 10° *				
ST5541														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	90%	100%	85%	70%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	50%	70%	100%	75%	50%	80%	100%	75%	100%	100%	75%	75%	100%	170%
LV4	x	x	100%	65%	40%	70%	100%	65%	100%	100%	65%	65%	100%	170%
										≤ 10° *				
ST5551														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	75%	80%	100%	85%	75%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	x	x	100%	70%	55%	85%	100%	70%	100%	100%	70%	70%	100%	170%
LV4	x	x	100%	55%	25%	75%	100%	55%	100%	100%	55%	55%	100%	170%
LV5	x	x	100%	40%	20%	70%	100%	40%	100%	100%	40%	40%	100%	170%
LV6	x	x	100%	30%	15%	65%	100%	35%	100%	100%	35%	35%	100%	170%
LV8	x	x	100%	15%	10%	60%	100%	25%	100%	100%	25%	25%	100%	170%

*Unghi rampă max.
Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

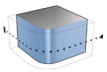
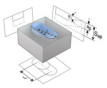
	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal			Găurire	
Drept																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)	f_z	a_p (% din DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
S4521																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 30° *						
S4531																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	X	X	25	60	240	120	3	40	100	70	70	50	10	130	20	10
										≤ 30° *						
S4651																
LV2	X	X	100	100	100	140	3	35	100	X	X	100	2	130	X	X
LV4	X	X	100	85	200	120	3	40	200	X	X	60	1,5	130	X	X
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV1	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
LV4	X	X	38	100	200	110	3	55	200	X	X	X	X	X	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	100	140	110	3	55	140	X	X	60	1,5	130	X	X
LV4	X	X	38	100	200	110	3	55	200	X	X	X	X	X	X	X

*Unghi rampă max.
Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal			Găurire	
Drept																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)	f_z	a_p (% din DC)
										≤ 45° *						
J28 LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36 LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120 LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130 LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142 LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830 LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910 LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930 LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

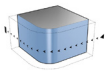
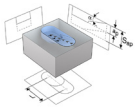
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

Drept	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal			Găurire	
																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)	f_z	a_p (% din DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV1	100	100	100	100	100	110	3	55	150	100	100	100	3	130		
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

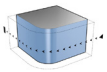
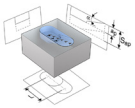
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru frezare laterală și apoi recalculaţi parametrii!

	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal			Găurire	
Drept																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% din DC)	gaură Ø (≥ % din DC)	f_z	a_p (% din DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5º						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

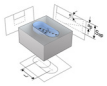
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

Drept	Canelare		Degroșare laterală		Finisare laterală					*Frezare în rampă		Elicoidal			Găurire	
																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360º (% din DC)	gaură Ø (≥ % din DC)	f_z	a_p (% din DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
										≤ 30°						
HP4931																
LV2	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	30	50
										≤ 5°						
S4931																
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	X	X
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
LV5	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

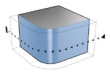
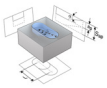
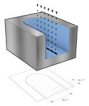
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal			Axial			
Drept																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)	v_c	a_e (% din DC)	f_z	a_e-sd (% din DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

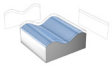
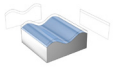
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi parametrii iniţiali standard pentru regimurile de frezare și recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

BILĂ	Canelare		Degroșare laterală			Finisare laterală				Degroșare pentru frezare prin copiere			Finisare frezare prin copiere				Elicoidal		
																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

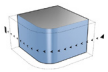
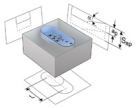
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) inițiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare și apoi recalculaţi parametrii!

	Canelare		Degroșare laterală			Finisare laterală				Frezare în rampă		Elicoidal		
BILĂ														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360º (% din DC)	gaură Ø (≥ % din DC)
C5321														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
C5341														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	x	x	50%	75%	160%
ST5341														
LV2	x	x	100%	100%	100%	100%	100%	100%	100%	x	x	x	x	x
LV3	x	x	100%	85%	100%	85%	100%	85%	100%	x	x	x	x	x

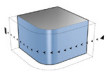
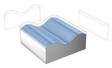
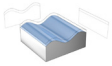
*Unghi rampă max.

Toate valorile sunt procentaje din regimurile de frezare (100%) iniţiale.

Recalculare

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru degroșare laterală
și apoi recalculaţi parametrii!

Utilizaţi versiunea standard iniţială a regimurilor de frezare pentru canelare
și apoi recalculaţi parametrii!

BILĂ	Canelare		Degroșare laterală			Finisare laterală				Degroșare pentru frezare prin copiere			Finisare frezare prin copiere				Elicoidal		
																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% din DC)	f_z	a_p	f_z	a_p/360° (% din DC)	gaură Ø (≥ % din DC)
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

*Unghi rampă max.
Toate valorile sunt procentaje din regimurile de frezare (100%) inițiale.

Nomenclator și formule

RPM

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad \text{(rot/min)}$$

Viteza de așchiere

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad \text{(m/min)}$$

Viteza de avans

$$v_f = n \cdot z_n \cdot f_z \quad \text{(mm/min)}$$

Avans pe rotaţie

$$f = z_n \cdot f_z \quad \text{(mm/rot)}$$

Rata de îndepărtare a metalului

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad \text{(cm}^3\text{/min)}$$

Viteza de așchiere și RPM pentru copiere

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(RPM)}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$

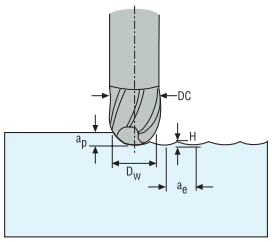
Calcularea a_p în comparaţie cu lungimea extensiei:
Dacă lungimea braţului în consolă (XS) este mai mare decât 4 x DC și sunt utilizate cozile cilindrice, este importantă adoptarea unei alte valori a adâncimii de așchiere (a_p) decât cea indicată în tabel.
Utilizaţi următoarea formulă pentru a calcula noua valoare a_p

$$a_p\text{nou} = a_p \times (4 \times DC/XS)^2$$

Înălţimea profilului

$$H = \frac{D_C}{2} - \frac{\sqrt{D_C^2 - a_e^2}}{2}$$

$$D_W = 2 \cdot \sqrt{a_p (D_C - a_p)} \quad \text{(mm)}$$



Înălţime profil H (mm)

DC	Pas a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

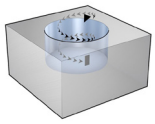
a_p = Adâncime de așchiere mm / adâncime axială de așchiere (mm)
a_e = Lăţime de așchiere mm / adâncime radială de așchiere (mm)
DC = Diametru sculă așchietoare
f = Avans pe rotaţie (mm/rot.)
f_z = Avans pe dinte (mm/dinte)
z_n = Nr. de dinţi
n = Rotaţii pe minut (rot./min)
Q = Rată de evacuare material (cm^3/min)
v_c = Viteză de așchiere (m/min)
v_f = Viteză de avans (mm/min)
D_w = Diametru de lucru

Recomandări privind operaţia

Prelucrarea în rampă prin interpolare elicoidală
Tabelul de mai jos prezintă recomandările privind diametrul pentru interpolare elicoidală în rampă

Diametrul recomandat al găurii la interpolare elicoidală

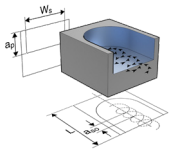
Diametrul frezei cilindro-frontale DC	Diametrul găurii
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC



Metoda trohoidală
Imaginea de mai jos arată o metodă deseori denumită metodă trohoidală de frezare a canelurilor

Recomandări ale lăţimii canalului

Diametrul frezei cilindro-frontale DC	Lăţimea canalului
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC





MINIMASTER™

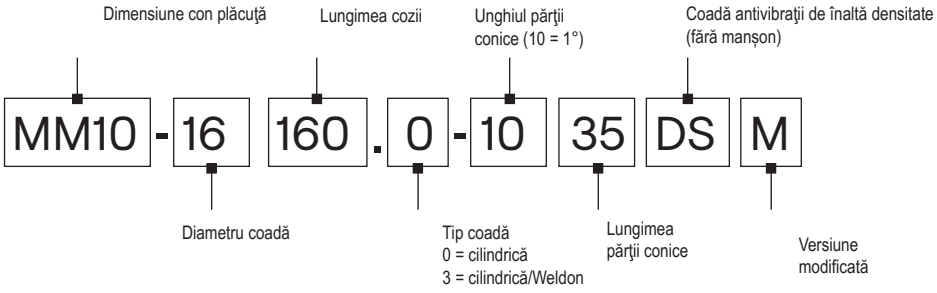
Minimaster™ este un sistem de frezare unic și versatil, care poate combina diverse soluţii pentru accesibilitate optimă și stabilitate și securitate maxime.

Designul flexibil din două piese combină cozi și plăcuţe amovibile, pentru a economisi timp, bani și pentru a crea o sculă versatilă care le permite utilizatorilor să găsească o soluţie pentru aproape orice utilizare, fie că trebuie să minimizeze lungimea extensiei, să obţină stabilitate maximă sau altele.

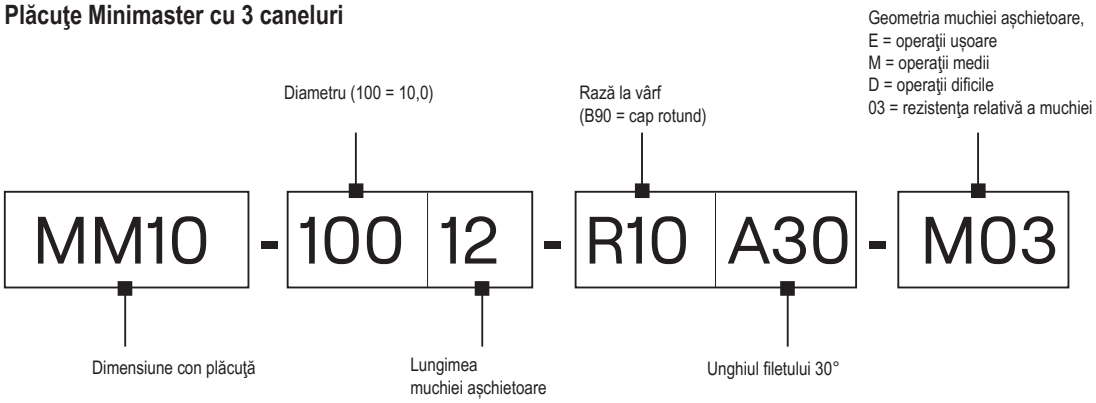
- Gama pentru frezare cilindro-frontalăs 6-20 mm (0,25-0,75 inchi)
- Gama cu cap rotund: 6-20 mm (0,25-0,75 inchi)
- Gama de găurire centrală/șanfrenare: 6-19,05 mm (0,25-0,75 inchi)
- Gama cu avans mare: 8-12 mm (0,375-0,625 inchi)
- Gama axială: 6-16 mm (0,25-0,625 inchi)
- Gama cu rază concavă: 12 mm (0,472 inchi)

Codificări

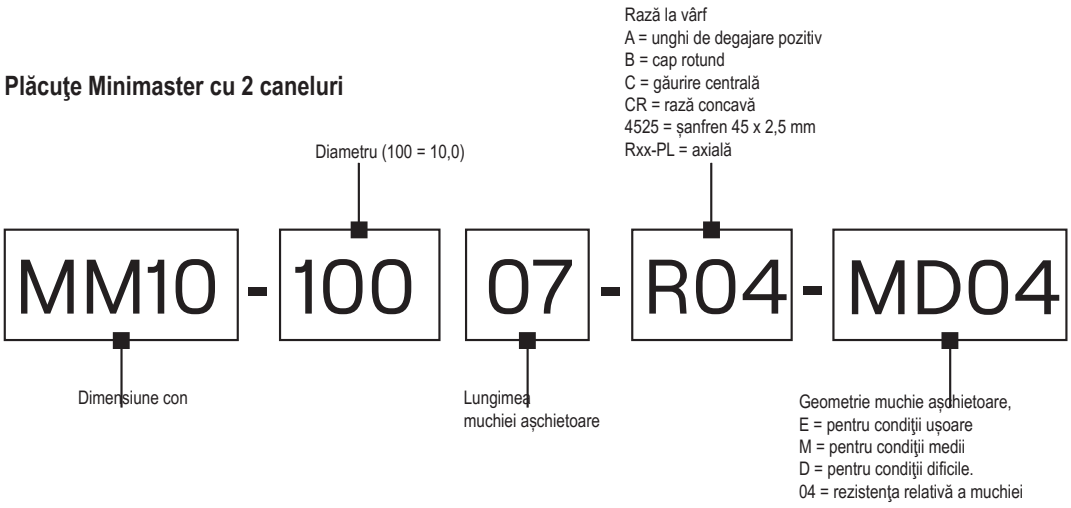
Cozi



Plăcuţe Minimaster cu 3 caneluri



Plăcuţe Minimaster cu 2 caneluri



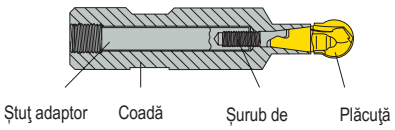
Reţineţi că unele părţi din cod pot varia la diverse tipuri de plăcuţe sau cozi

Agent de răcire prin interior

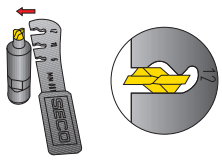


Instrucţiuni de montare pentru Minimaster cu 2 caneluri

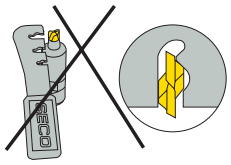
Cheie dinamometrică



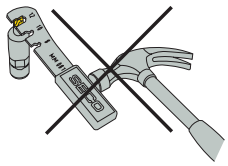
Manșonul trebuie strâns bine în coadă înainte de montarea șurubului de tensionare și a plăcuţei.
Dacă nu poate fi utilizată cheia pentru schimbarea plăcuţei (dacă plăcuța s-a rupt sau s-a blocat în coadă), poate fi eliberat manșonul, ceea ce va elibera și plăcuţa.
Utilizaţi o cheie Allen (rotiţi în sens invers acelor de ceasornic) pentru a retrage manșonul până la eliberarea plăcuţei.
Strângeţi la loc manșonul în coadă înainte de a monta șurubul de tensionare și noua plăcuţă.
Pentru Minimaster cu 3 caneluri, trebuie utilizată o altă cheie (MM0416)
(partea de prindere a cheii pe partea hexagonală a plăcuţei.)



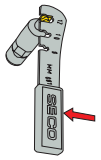
Aveţi grijă să utilizaţi corect cheia



În cazul în care cheia este utilizată pe partea greșită, va provoca daune



Nu utilizaţi forţă excesivă



Puterea normală a mâinii este suficientă

Ghid de selectare

1. Selectaţi dimensiunea conului
Modelul piesei de prelucrat și operaţiile de prelucrare determină dimensiunea adecvată a conului. Pentru cea mai bună rezistenţă și stabilitate, selectaţi cea mai mare dimensiune de con posibilă.

2. Selectaţi plăcuţa
a. Utilizaţi tabelele începând de la pagina 802 pentru a clasifica materialul piesei de prelucrat într-un grup de materiale Seco.
b. Uitaţi-vă pe pagini după dimensiunea selectată a conului și alegeţi o plăcuţă adecvată din tabelul de selectare a plăcuţei.

3. Selectaţi coada
a. Uitaţi-vă pe pagini după dimensiunea selectată a conului și alegeţi o coadă adecvată din tabelul cu date despre scule.
b. Alegeţi întotdeauna cea mai scurtă coadă posibilă pentru a obţine cea mai bună stabilitate posibilă.

4. Selectaţi regimul de frezare
a. Recomandările pentru viteza de așchiere se află în tabelele cu regimuri de frezare pentru dimensiunea selectată a conului. Recomandările privind regimul de frezare
se bazează pe condiţii stabile și, prin urmare, poate fi necesară reglarea în funcţie de stabilitatea din
utilizare (scule, utilaj și prinderea piesei de prelucrat). Regula generală pentru ap max. în canelură este DC x 0,3 = APMXS max. (Vezi figura 1)
b. Recomandările pentru viteza de așchiere și avans se găsesc în tabelul de conversie pentru parmetrii de așchiere
c. Turaţia max. RPM cre din motive de securitate nu poate fi depășită, se găsește la pag. N/A.
d. Dacă capul de frezat nu este angajat total avansul pe dinte și viteza de așchiere trebuiesc mărite în comparaţie cu
recomandările pentru cazul angajării totale. Motivul este menţinerea grosimii medii a așchiei și
temperatura de lucru din zona de așchiere.
e. Împărţiţi adâncimea radială de așchiere la diametru sculei așchietoare pentru a obţine procentul de angajare efectivă a sculei așchietoare (a_e/DC%); pentru freze cu cap rotund, utilizaţi diametrul de lucru efectiv D_w în loc de DC (consultaţi figurile 2 și 6)
f. Utilizaţi procentul pentru a obţine o recomandare corectă privind avansul pe dinte și viteza de așchiere pentru angajarea efectivă a sculei așchietoare.

5. General
– La frezarea în colţuri și pe fundul cavităţilor, rata avansului trebuie redusă, ca urmare a creșterii grosimii medii a așchiei. Utilizaţi recomandările privind avansul pe dinte pentru o sculă așchietoare complet angajată.
– La copierea abruptă în sensul avansului cu un unghi mai mare de 40° sau la copierea abruptă în sens contrar avansului cu un unghi mai mare de 30° în combinaţie cu adâncimi de așchiere mici, utilizaţi diametrul (DC) ca diametru de lucru, în loc de Dw.
– La calcularea avansului pe rotaţie și a vitezei de avans, utilizaţi întotdeauna valoarea ZEFP. Adică numărul efectiv de dinţi de utilizat pentru calcularea regimurilor de frezare. Valoarea ZEFP se află în tabelul de selectare a plăcuţei.

Reţineţi! Va exista o deteriorare a finisajului suprafeţei piesei de prelucrat atunci când este mărită rata avansului. (Consultaţi figurile 3 și 5)

Figuri Minimaster

Figura 1

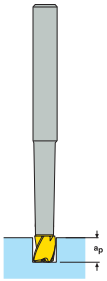


Figura 2

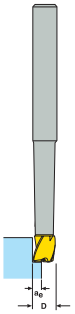


Figura 3

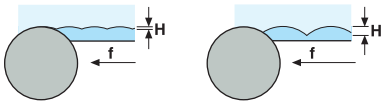


Figura 4

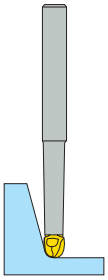


Figura 5

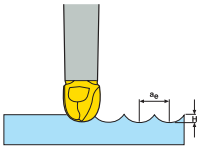
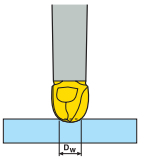
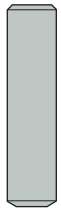
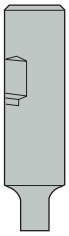
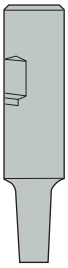
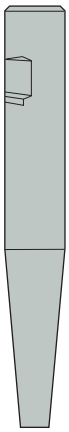
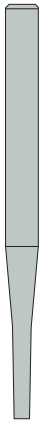


Figura 6

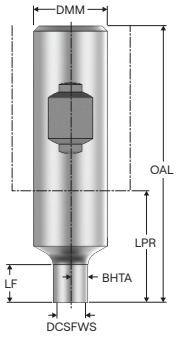


Design coadă

Design 1, Coadă cheie	Design 2, Parte dorsală cilindrică/Weldon și 90º în față
	
Design 3, Parte dorsală cilindrică/Weldon parte frontală conică 87º/89º	**Design 4, Parte dorsală cilindrică/Weldon parte frontală conică 80º/85º/87º**
	
Design 5, Parte dorsală cilindrică parte frontală conică dublă 89º/85º	
	

MM06 Coadă – Metric

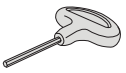




Reper Nr.	Număr reper	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		mm	mm	mm	mm	mm						kg	
MM06-10040.0-0007	00094747	5,75	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM06-10050.0-0007DS	02580666	5,75	10,0	7,0	7,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM06-10075.0-3041DS	02580701	5,75	10,0	40,5	35,0	75,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM06-10100.0-1035DS	02580713	5,75	10,0	35,0	60,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,1	3
MM06-12070.3-0005	75080695	5,75	12,0	5,0	25,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM06-12065.0-0000	75080694	5,7	12,0	0,0	15,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM06-12120.0-1050DS	02580714	5,75	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM06-16075.3-3009	75080696	5,75	16,0	9,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM06-16110.3-5058	75080697	5,75	16,0	58,6	62,0	110,0	5,0	4	■	80000	Weldon	0,2	4
MM06-16140.0-1020M	00027102	5,75	16,0	20,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	5
MM06-16140.0-1035M	00027103	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16140.0-1050M	00094748	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16090.0-0012DS	02580670	5,75	16,0	12,0	42,0	90,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16095.0-0024DS	02580673	5,75	16,0	24,0	47,0	95,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1050DS	02580717	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1035DS	02580716	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM06-20250.0-1035DS	02580718	5,75	20,0	35,0	190,0	250,0	1,0	5	■	80000	Cylindrical Densimet	0,9	3

Piese de schimb, Piese incluse la livrare

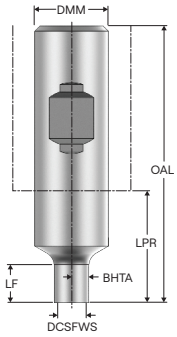
Accesorii

Pentru freza	Manşon	Şurub tensiune	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

MM06 Coadă – inci

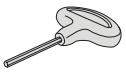




Reper Nr.	Număr reper	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		inci	inci	inci	inci	inci						lbs	
MM06-0.38-1.6-0-0002	00096107	0.224	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	2
MM06-0.50-2.8-3-0002	00096108	0.224	0.500	0.197	0.984	2.756	0,0	2	■	80000	Weldon	0.220	1
MM06-0.50-2.6-0-0000	00096106	0.224	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM06-0.62-3.0-3-3003	00096116	0.224	0.625	0.354	1.063	2.953	3,0	1	■	80000	Weldon	0.220	1
MM06-0.62-4.3-3-5022	00096117	0.224	0.625	2.291	2.441	4.331	5,0	2	■	80000	Weldon	0.440	4
MM06-0.62-5.5-0-1007	00096111	0.224	0.625	0.787	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	5
MM06-0.62-5.5-0-1013	00096112	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-5.5-0-1019	00096114	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	0.224	0.625	0.472	1.654	3.543	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	0.224	0.625	0.945	1.850	3.740	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	0.224	0.750	1.378	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	1.760	3

Piese de schimb, Piese incluse la livrare

Accesorii

Pentru freza	Manșon	Șurub tensiune	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

Frezare de canal/frezare în unghi drept

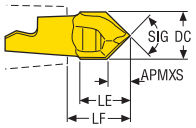


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta		Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								T60M	F15M	F30M	F40M
MM06-05804T-R02-D02	5,8 *0.228*	4,1 *0.161*	0,2 *0.008*	5,1 *0.201*	15,0	7,2	11,0	0	2	MM0612		■			
MM06-05807-R02A30-M02	5,8 *0.228*	7,5 *0.295*	0,2 *0.008*	9,9 *0.390*	15,0	7,2	11,0	30	3	MM0612	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	–	5,1 *0.201*	15,0	7,4	11,8	0	2	MM0612		■			
MM06-06004-R04-MD02	6,0 *0.236*	4,1 *0.161*	0,4 *0.016*	5,1 *0.201*	15,0	7,4	11,0	0	2	MM0612		■		■	
MM06-06004-R10-MD02	6,0 *0.236*	4,1 *0.161*	1,0 *0.039*	5,1 *0.201*	15,0	7,4	9,8	0	2	MM0612				■	
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	–	9,9 *0.390*	15,0	7,4	11,8	30	3	MM0416	✓			■	
MM06-06007-R05A30-M02	6,0 *0.236*	7,5 *0.295*	0,5 *0.020*	9,9 *0.390*	15,0	7,4	10,8	30	3	MM0416	✓				■
MM06-06007-R10A30-D02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-E02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-M02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓				■
MM06-06007-R20A30-M02	6,0 *0.236*	7,5 *0.295*	2,0 *0.079*	9,9 *0.390*	15,0	7,4	7,8	30	3	MM0416	✓				■
MM06-06407-A30-E02	6,35 *0.250*	7,5 *0.295*	–	9,9 *0.390*	15,0	7,8	12,5	30	3	MM0416	✓			■	
MM06-06407-R04A30-M02	6,35 *0.250*	7,5 *0.295*	0,4 *0.016*	9,9 *0.390*	15,0	7,8	11,7	30	3	MM0416	✓				■
MM06-06407-R08A30-M02	6,35 *0.250*	7,5 *0.295*	0,8 *0.031*	9,9 *0.390*	15,0	7,8	10,9	30	3	MM0416	✓				■

Frezare centrală



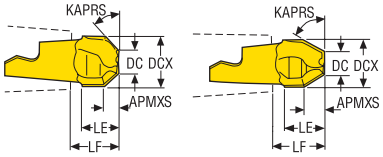


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	LE	LF	SIG°	ZEFP	Varianta	Calităţi			
								Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			

Șanfrenare





—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Varianta	Calităţi			
										Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM06-06004-4515-E02	6,0 *0.236*	1,8 *0.071*	2,1 *0.083*	0,2 *0.008*	4,0 *0.157*	5,1 *0.201*	45,0	2	MM0612	■			
MM06-06004-6015-E02	6,0 *0.236*	3,14 *0.124*	2,4 *0.094*	0,2 *0.008*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

Şanfrenare dublă

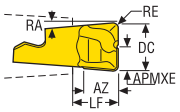


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DCX	DC	APMXS	DN	LF	BEC°	KAPRS°	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM06-08008-D4510P-M02	8,0 *0.315*	0,6 *0.024*	3,7 *0.146*	6,0 *0.236*	8,5 *0.335*	90,0	45,0	2	MM0612		■		

Frezare axială

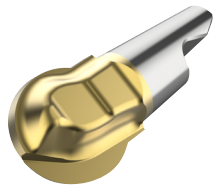




—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM06-06004-R10-PL-MD02	6,0 *0.236*	3,0 *0.118*	1,0 *0.039*	4,3 *0.169*	5,08 *0.200*	5,0	2	MM0612			■	

Plăcuţe de precizie pentru semifinisare în toate materialele



—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM06-08008-B120PF-M01	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612			■	

Frezare prin copiere



—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	FHA	ZEFP	Varianta		Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*		2	MM0612		■		■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612			■		
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612				■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*		2	MM0612				■	
MM06-06007-B90A30-E02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓			■	
MM06-06007-B90A30-M02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓				■
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*		2	MM0612				■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*		2	MM0612				■	

MM06 - Frezare laterală și canelare – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
P2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
P3	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,046 0.0018
P4	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
P5	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P6	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P7	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P8	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,046 0.0018
P11	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P12	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,020 0.00080	0,020 0.00080	0,022 0.00085	0,030 0.0012
M1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
M2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
M3	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
M4	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
M5	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
K1	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,038 0.0015	0,050 0.0020
K2	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K3	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K4	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K5	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
K6	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K7	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
N1	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N2	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N3	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N11	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
S1	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 0.0011	0,026 0.0010	0,025 0.0010	0,032 0.0013
S2	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 0.0011	0,026 0.0010	0,025 0.0010	0,032 0.0013
S3	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,026 0.0010	0,025 0.0010	0,024 0.00095	0,028 0.0012
S11	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
S12	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
S13	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
H5	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 0.0010	0,024 0.00095	0,024 0.00095	0,030 0.0012
H8	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095
H11	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 0.0010	0,024 0.00095	0,024 0.00095	0,030 0.0012
H12	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095
H21	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM06 - Frezare laterală și canelare – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	280 *920*	350 *1150*	395 *1300*	435 *1425*	270 *890*	335 *1100*	375 *1225*	415 *1350*	220 *720*	270 *890*	300 *980*	330 *1075*
P2	275 *900*	340 *1125*	380 *1250*	420 *1375*	260 *850*	325 *1075*	365 *1200*	400 *1300*	210 *690*	260 *850*	295 *970*	320 *1050*
P3	240 *790*	295 *970*	330 *1075*	365 *1200*	225 *740*	285 *940*	315 *1025*	350 *1150*	185 *610*	230 *750*	255 *840*	280 *920*
P4	210 *690*	260 *850*	295 *970*	320 *1050*	200 *660*	250 *820*	280 *920*	305 *1000*	160 *520*	200 *660*	225 *740*	245 *800*
P5	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	295 *970*	155 *510*	190 *620*	215 *710*	235 *770*
P6	225 *740*	285 *940*	315 *1025*	345 *1125*	215 *710*	270 *890*	300 *980*	330 *1075*	175 *570*	215 *710*	240 *790*	265 *870*
P7	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	285 *940*	310 *1025*	165 *540*	205 *670*	230 *750*	250 *820*
P8	200 *660*	250 *820*	280 *920*	305 *1000*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P11	210 *690*	260 *850*	290 *950*	320 *1050*	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	200 *660*	220 *720*	245 *800*
P12	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	100 *330*	125 *410*	135 *445*	150 *490*
M1	— —	— —	— —	— —	210 *690*	265 *870*	295 *970*	320 *1050*	170 *560*	210 *690*	235 *770*	260 *850*
M2	— —	— —	— —	— —	175 *570*	215 *710*	240 *790*	265 *870*	140 *460*	170 *560*	195 *640*	210 *690*
M3	— —	— —	— —	— —	135 *445*	165 *540*	190 *620*	205 *670*	110 *360*	135 *445*	150 *490*	165 *540*
M4	— —	— —	— —	— —	105 *345*	130 *425*	145 *475*	155 *510*	85 *280*	105 *345*	115 *375*	125 *410*
M5	— —	— —	— —	— —	85 *280*	105 *345*	120 *395*	130 *425*	70 *230*	85 *280*	95 *310*	105 *345*
K1	215 *710*	270 *890*	305 *1000*	335 *1100*	205 *670*	260 *850*	290 *950*	315 *1025*	165 *540*	210 *690*	230 *750*	255 *840*
K2	190 *620*	235 *770*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	150 *490*	180 *590*	205 *670*	225 *740*
K3	160 *520*	200 *660*	225 *740*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	125 *410*	155 *510*	175 *570*	190 *620*
K4	155 *510*	190 *620*	215 *710*	235 *770*	145 *475*	180 *590*	205 *670*	225 *740*	120 *395*	145 *475*	165 *540*	180 *590*
K5	95 *310*	115 *375*	130 *425*	145 *475*	90 *295*	110 *360*	125 *410*	135 *445*	70 *230*	90 *295*	100 *330*	110 *360*
K6	135 *445*	170 *560*	190 *620*	210 *690*	130 *425*	160 *520*	180 *590*	200 *660*	105 *345*	130 *425*	145 *475*	160 *520*
K7	120 *395*	150 *490*	165 *540*	180 *590*	115 *375*	140 *460*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
N1	1650 *5425*	2050 *6725*	2325 *7625*	2525 *8275*	1575 *5175*	1975 *6475*	2200 *7225*	2400 *7875*	1275 *4175*	1575 *5175*	1775 *5825*	1950 *6400*
N2	670 *2200*	830 *2725*	930 *3050*	1025 *3375*	640 *2100*	790 *2600*	890 *2925*	970 *3175*	510 *1675*	640 *2100*	710 *2325*	790 *2600*
N3	445 *1450*	560 *1825*	620 *2025*	680 *2225*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	340 *1125*	425 *1400*	475 *1550*	530 *1750*
N11	510 *1675*	630 *2075*	710 *2325*	780 *2550*	485 *1600*	600 *1975*	680 *2225*	740 *2425*	390 *1275*	485 *1600*	540 *1775*	600 *1975*
S1	50 *165*	65 *215*	70 *230*	75 *245*	49 *160*	60 *195*	65 *215*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
S2	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	32 *105*	39 *130*	44 *145*	48 *155*
S3	36 *120*	44 *145*	49 *160*	55 *180*	34 *110*	42 *140*	47 *155*	50 *165*	27 *90*	34 *110*	38 *125*	41 *135*
S11	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	70 *230*	75 *245*	85 *280*
S12	— —	— —	— —	— —	48 *155*	60 *195*	65 *215*	70 *245*	38 *125*	48 *155*	55 *180*	60 *195*
S13	— —	— —	— —	— —	27 *90*	34 *110*	38 *125*	41 *135*	22 *70*	27 *90*	30 *100*	33 *110*
H5	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	33 *110*	41 *135*	45 *150*	50 *165*
H8	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*
H11	55 *180*	65 *215*	75 *245*	85 *280*	50 *165*	65 *215*	70 *230*	80 *260*	42 *140*	50 *165*	60 *195*	65 *215*
H12	80 *260*	95 *310*	110 *360*	120 *395*	75 *245*	90 *295*	105 *345*	115 *375*	60 *195*	75 *245*	85 *280*	90 *295*
H21	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*

MM06 Z3-Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
P2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
P3	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,046 0.0018
P4	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P8	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,046 0.0018
P11	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P12	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
M1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
M2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
M3	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,028 0.0011	0,026 0.0010	0,028 0.0011	0,036 0.0014
M4	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
M5	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
K6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
S1	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
S2	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
S3	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,024 0.00095	0,022 0.00085	0,022 0.00085	0,028 0.0012
S11	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 0.0011	0,028 0.0011	0,028 0.0011	0,036 0.0014
S12	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 0.0011	0,028 0.0011	0,028 0.0011	0,036 0.0014
S13	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM06 Z3-Frezare prin copiere – Alegerea plăcuţelor – Finisare – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
P5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P8	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P12	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
M2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
M3	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
M4	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
M5	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,090 0.0036
K6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,090 0.0036
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
S2	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
S3	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
S12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
S13	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM06 Z3-Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	295 *970*	350 *1150*	370 *1225*	405 *1325*	400 *1300*	280 *920*	330 *1075*	355 *1175*	385 *1275*	380 *1250*
P2	285 *940*	340 *1125*	360 *1175*	395 *1300*	390 *1275*	275 *900*	325 *1075*	345 *1125*	375 *1225*	370 *1225*
P3	250 *820*	295 *970*	315 *1025*	340 *1125*	340 *1125*	235 *770*	280 *920*	300 *980*	320 *1050*	325 *1075*
P4	220 *720*	260 *850*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*
P5	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*
P6	235 *770*	275 *900*	295 *970*	320 *1050*	320 *1050*	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*
P7	225 *740*	260 *850*	280 *920*	305 *1000*	300 *980*	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*
P8	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P11	215 *710*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*
P12	135 *445*	160 *520*	165 *560*	180 *590*	180 *590*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M1	230 *750*	275 *900*	290 *950*	315 *1025*	315 *1025*	220 *720*	260 *850*	280 *920*	300 *980*	300 *980*
M2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*
M3	150 *490*	180 *590*	185 *610*	200 *660*	200 *660*	140 *460*	170 *560*	175 *590*	190 *620*	190 *620*
M4	105 *345*	145 *475*	140 *490*	150 *490*	150 *490*	100 *330*	135 *445*	135 *460*	145 *475*	145 *475*
M5	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*	85 *280*	115 *375*	110 *395*	120 *395*	120 *395*
K1	230 *750*	270 *890*	285 *940*	310 *1025*	310 *1025*	215 *710*	255 *840*	275 *900*	295 *970*	295 *970*
K2	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
K3	170 *560*	200 *660*	210 *690*	230 *750*	230 *750*	160 *520*	190 *620*	200 *660*	220 *720*	220 *720*
K4	160 *520*	190 *620*	205 *670*	220 *720*	220 *720*	155 *510*	180 *590*	195 *640*	210 *690*	210 *690*
K5	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
K6	140 *460*	165 *540*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K7	125 *410*	145 *475*	155 *510*	170 *560*	170 *560*	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*
N1	1750 *5750*	2075 *6800*	2200 *7225*	2375 *7800*	2375 *7800*	1675 *5500*	1975 *6475*	2100 *6900*	2275 *7475*	2250 *7375*
N2	710 *2325*	830 *2725*	890 *2925*	960 *3150*	950 *3125*	670 *2200*	790 *2600*	850 *2800*	920 *3025*	910 *2975*
N3	470 *1550*	560 *1825*	590 *1925*	640 *2100*	640 *2100*	450 *1475*	530 *1750*	570 *1875*	610 *2000*	610 *2000*
N11	540 *1775*	630 *2075*	680 *2225*	730 *2400*	730 *2400*	510 *1675*	600 *1975*	650 *2125*	700 *2300*	690 *2275*
S1	49 *160*	65 *215*	65 *230*	70 *230*	70 *230*	46 *150*	65 *215*	65 *215*	70 *230*	65 *215*
S2	39 *130*	55 *180*	55 *180*	55 *180*	55 *180*	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*
S3	34 *110*	47 *155*	46 *155*	50 *165*	49 *160*	32 *105*	44 *145*	44 *150*	47 *155*	47 *155*
S11	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*
S12	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*
S13	27 *90*	38 *125*	37 *130*	40 *130*	40 *130*	26 *85*	36 *120*	35 *120*	38 *125*	38 *125*
H5	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	42 *140*	50 *165*	55 *180*	55 *180*	55 *180*
H8	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H11	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	55 *180*	65 *215*	65 *230*	70 *230*	75 *245*
H12	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
H21	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*

MM06 Z2-Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 0.0012	0,032 0.0013	0,036 0.0014	0,048 0.0019
P2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
P3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
P4	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
P5	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
P6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P8	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
P11	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P12	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
M1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
M2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M3	MM06-06006-B90S-E02 F30M	2,0 *0.080*	0,024 0.00095	0,024 0.00095	0,028 0.0011	0,036 0.0014
M4	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
M5	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
K1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
K2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K4	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K5	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,026 0.0010	0,026 0.0010	0,030 0.0012	0,040 0.0016
K6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,026 0.0010	0,026 0.0010	0,030 0.0012	0,040 0.0016
N1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N11	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
S1	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
S2	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
S3	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,020 0.00080	0,020 0.00080	0,022 0.00085	0,028 0.0012
S11	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 0.0010	0,024 0.00095	0,028 0.0011	0,036 0.0014
S12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 0.0010	0,024 0.00095	0,028 0.0011	0,036 0.0014
S13	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
H5	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
H8	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095
H11	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
H12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095
H21	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM06 Z2-Frezare prin copiere – Alegerea plăcuţelor – Finisare – Metric/ Inci

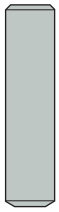
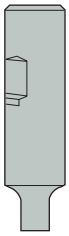
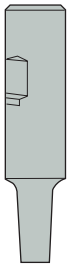
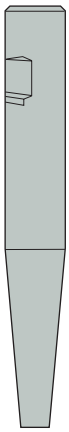
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P8	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P12	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
M1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
M2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
M3	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
M4	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
M5	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
K1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
K2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
K6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
N1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
S1	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
S2	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
S3	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,013 0.00050	0,014 0.00060	0,020 0.00080	0,032 0.0013
S11	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
S12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
S13	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
H5	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H8	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010
H11	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010
H21	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM06 Z2-Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

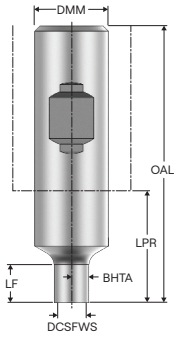
SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	455 *1500*	265 *870*	335 *1100*	365 *1200*	395 *1300*	395 *1300*	215 *710*	270 *890*	295 *970*	320 *1050*	320 *1050*
P3	275 *900*	345 *1125*	360 *1175*	395 *1300*	395 *1300*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
P4	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	205 *670*	255 *840*	280 *920*	305 *1000*	300 *980*	165 *540*	205 *670*	225 *740*	245 *800*	245 *800*
P5	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	290 *950*	290 *950*	160 *520*	200 *660*	215 *710*	235 *770*	235 *770*
P6	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	220 *720*	275 *900*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P7	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	210 *690*	260 *850*	285 *940*	305 *1000*	305 *1000*	170 *560*	210 *690*	230 *750*	250 *820*	245 *800*
P8	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	285 *940*	290 *950*	160 *520*	200 *660*	215 *710*	230 *750*	235 *770*
P11	240 *790*	300 *980*	315 *1025*	340 *1125*	340 *1125*	200 *660*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
P12	145 *475*	185 *610*	190 *620*	205 *670*	205 *670*	130 *425*	160 *520*	170 *560*	180 *590*	180 *590*	105 *345*	130 *425*	135 *445*	145 *475*	145 *475*
M1	255 *840*	325 *1075*	340 *1125*	365 *1200*	365 *1200*	215 *710*	270 *890*	295 *970*	320 *1050*	315 *1025*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*
M2	210 *690*	265 *870*	275 *900*	300 *980*	300 *980*	175 *570*	220 *720*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
M3	165 *540*	210 *690*	210 *710*	230 *750*	230 *750*	140 *460*	180 *590*	185 *620*	205 *670*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	165 *540*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	140 *490*	155 *510*	155 *510*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*
M5	105 *345*	135 *445*	130 *475*	145 *475*	145 *475*	95 *310*	120 *395*	120 *410*	130 *425*	130 *425*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
K1	250 *820*	320 *1050*	335 *1100*	360 *1175*	360 *1175*	210 *690*	265 *870*	290 *950*	315 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*
K2	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	185 *610*	230 *750*	255 *840*	275 *900*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
K3	185 *610*	235 *770*	245 *800*	265 *870*	265 *870*	160 *520*	195 *640*	215 *710*	230 *750*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*
K4	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	150 *490*	185 *610*	205 *670*	220 *720*	220 *720*	120 *395*	150 *490*	165 *540*	180 *590*	180 *590*
K5	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*	90 *295*	115 *375*	125 *410*	135 *445*	135 *445*	75 *245*	90 *295*	100 *330*	110 *360*	105 *345*
K6	155 *510*	195 *640*	205 *670*	225 *740*	225 *740*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	105 *345*	135 *445*	145 *475*	160 *520*	155 *510*
K7	135 *445*	170 *560*	180 *590*	195 *640*	195 *640*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	140 *460*
N1	1975 *6475*	2475 *8125*	2600 *8525*	2800 *9175*	2800 *9175*	1625 *5325*	2050 *6725*	2225 *7300*	2400 *7875*	2375 *7800*	1325 *4350*	1650 *5425*	1800 *5900*	1950 *6400*	1925 *6325*
N2	790 *2600*	1000 *3275*	1050 *3450*	1125 *3700*	1125 *3700*	660 *2175*	820 *2700*	900 *2950*	970 *3175*	960 *3150*	530 *1750*	670 *2200*	730 *2400*	790 *2600*	780 *2550*
N3	530 *1750*	670 *2200*	700 *2300*	760 *2500*	750 *2450*	440 *1450*	550 *1800*	600 *1975*	650 *2125*	640 *2100*	355 *1175*	445 *1450*	485 *1600*	520 *1700*	520 *1700*
N11	600 *1975*	760 *2500*	800 *2625*	860 *2825*	860 *2825*	500 *1650*	630 *2075*	680 *2225*	740 *2425*	730 *2400*	405 *1325*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	43 *150*	47 *155*	47 *155*
S3	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*	36 *120*	46 *150*	46 *160*	50 *165*	50 *165*	29 *95*	37 *120*	38 *130*	40 *130*	40 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	75 *245*	95 *310*	95 *310*	105 *345*	100 *330*	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*
S12	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	41 *135*	55 *180*	55 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	29 *95*	37 *120*	37 *130*	40 *130*	40 *130*	24 *80*	30 *100*	30 *105*	33 *110*	33 *110*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	45 *150*	49 *160*	49 *160*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*

Design coadă

Design 1, Coadă cheie	Design 2, Parte dorsală cilindrică/Weldon şi 90º în faţă
	
Design 3, Parte dorsală cilindrică/Weldon parte frontală conică 87º/89º	**Design 4, Parte dorsală cilindrică/Weldon parte frontală conică 80º/85º/87º**
	
Design 5, Parte dorsală cilindrică parte frontală conică dublă 89º/85º	
	

MM08 Coadă

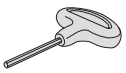




Reper Nr.	Număr reper	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		mm	mm	mm	mm	mm						kg	
MM08-10040.0-0007	00083980	7,6	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM08-10050.0-0007DS	02580665	7,6	10,0	7,0	10,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM08-10080.0-3023DS	02580702	7,6	10,0	22,9	40,0	80,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM08-12065.0-0000	75034240	7,6	12,0	0,0	20,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM08-12100.0-1035DS	02580719	7,6	12,0	35,0	55,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-12120.0-1050DS	02580720	7,6	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-16070.3-0007	75034241	7,6	16,0	7,6	22,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM08-16075.3-3012	75034242	7,6	16,0	12,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM08-16120.3-5048M	00042863	7,6	16,0	48,0	72,0	120,0	5,0	4	■	80000	Weldon	0,2	5
MM08-16150.0-1030M	00094751	7,6	16,0	30,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	5
MM08-16150.0-1050M	00094752	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16150.0-1070M	00094754	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16085.0-0016DS	02580675	7,6	16,0	16,0	37,0	85,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16100.0-0032DS	02580687	7,6	16,0	32,0	52,0	100,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16150.0-1050DS	02580722	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM08-16150.0-1070DS	02580727	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3

Piese de schimb, Piese incluse la livrare

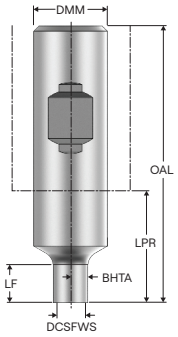
Accesorii

Pentru freza	Manșon	Șurub tensiune	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
2	MM-05019	MM08-0524	H05-4
3	–	MM08-0524	–
4	MM-05044	MM08-0582	H05-4
5	MM-05044	MM08-0543	H05-4

Cheia Allen H05-4 pentru manșoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

MM08 Coadă – inci





Reper Nr.	Număr reper	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		inci	inci	inci	inci	inci						lbs	
MM08-0.38-1.6-0-0002	00096119	0.299	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	3
MM08-0.50-2.6-0-0000	75054599	0.299	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM08-0.62-2.8-3-0003	75054600	0.299	0.625	0.299	0.866	2.756	0,0	2	■	80000	Weldon	0.220	1
MM08-0.62-3.0-3-3004	75054601	0.299	0.625	0.472	1.063	2.953	3,0	3	■	80000	Weldon	0.220	1
MM08-0.62-4.7-3-5018	75054602	0.299	0.625	1.850	2.835	4.724	5,0	4	■	80000	Weldon	0.440	2
MM08-0.62-5.9-0-1011	75054604	0.299	0.625	1.181	4.016	5.906	1,0	3	■	80000	Cylindrical	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	0.299	0.625	0.630	1.457	3.346	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	0.299	0.625	1.260	2.047	3.937	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	0.299	0.625	1.969	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	0.299	0.625	2.756	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	0.299	0.750	1.969	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	1.980	4

Piese de schimb, Piese incluse la livrare

Accesorii

Pentru freza	Manşon	Şurub tensiune	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
2	MM-05044	MM08-0543	H05-4
3	MM-05019	MM08-0524	H05-4
4	–	MM08-0524	–

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

Frezare de canal/frezare în unghi drept

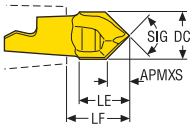


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Varianta**		Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								T60M	F15M	F30M	F40M
MM08-07805T-R02-D03	7,8 *0.307*	5,4 *0.213*	0,2 *0.008*	6,8 *0.268*	15,0	9,6	15,0	0	2	MM0612		■			
MM08-07809-R02A30-M03	7,8 *0.307*	10,0 *0.394*	0,2 *0.008*	13,0 *0.512*	15,0	9,6	15,0	30	3	MM0416	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	–	6,8 *0.268*	15,0	9,8	15,8	0	2	MM0612		■			
MM08-08005-R04A8-E03	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	8	2	MM0612		■		■	
MM08-08005-R04-MD03	8,0 *0.315*	5,5 *0.217*	0,4 *0.016*	6,8 *0.268*	15,0	9,8	15,0	0	2	MM0612		■		■	
MM08-08005-R04P-M02	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	0	2	MM0612				■	
MM08-08005-R10-MD03	8,0 *0.315*	5,4 *0.213*	1,0 *0.039*	6,8 *0.268*	15,0	9,8	13,8	0	2	MM0612				■	
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	–	13,0 *0.512*	15,0	9,8	15,0	30	3	MM0416	✓			■	
MM08-08009-R05A30-M03	8,0 *0.315*	10,0 *0.394*	0,5 *0.020*	13,0 *0.512*	15,0	9,8	14,8	30	3	MM0416	✓				■
MM08-08009-R10A30-D03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-E03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-M03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓				■
MM08-08009-R20A30-M03	8,0 *0.315*	10,0 *0.394*	2,0 *0.079*	13,0 *0.512*	15,0	9,8	11,8	30	3	MM0416	✓				■
MM08-08009-R30A30-M03	8,0 *0.315*	10,0 *0.394*	3,0 *0.118*	13,0 *0.512*	15,0	9,8	9,8	30	3	MM0416	✓				■

Frezare centrală



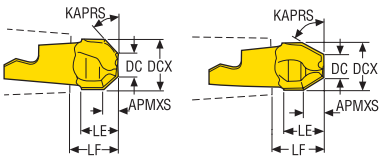


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

								Calităţi			
Reper Nr.	DC	APMXS	LE	LF	SIG°	ZEFP	Varianta	Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM08-08004-C90-M03	8,0 *0.315*	3,79 *0.149*	8,0 *0.315*	9,5 *0.374*	90,0	2	MM0612	■			
MM08-08006-C120-M03	8,0 *0.315*	2,15 *0.085*	8,32 *0.328*	9,46 *0.372*	120,0	2	MM0612	■			

Şanfrenare



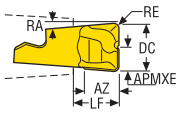


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

									Calităţi			
Reper Nr.	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Varianta	Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM08-08005-4520-E03	8,0 *0.315*	3,87 *0.152*	2,1 *0.083*	0,2 *0.008*	5,5 *0.217*	6,7 *0.264*	45,0	2	MM0612	■			
MM08-08006-6030-E03	8,0 *0.315*	4,19 *0.165*	3,3 *0.130*	0,24 *0.009*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

Frezare axială

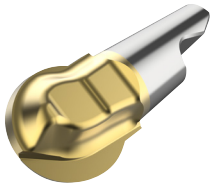




—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

									Calităţi			
Reper Nr.	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Varianta	Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM08-08005-R10-PL-MD03	8,0 *0.315*	4,0 *0.157*	1,0 *0.039*	5,7 *0.224*	6,78 *0.267*	5,0	2	MM0612			■	

Plăcuţe de precizie pentru semifinisare în toate materialele



—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

										Calităţi			
Reper Nr.	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Varianta	Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM08-10010-B120PF-M02	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612			■	

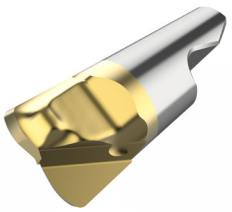
Frezare prin copiere

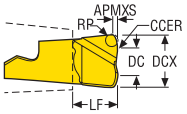


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	FHA	ZEFP	Varianta		Calităţi: Acoperită T60M	F15M	F30M	F40M
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		2	MM0612		■		■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612			■		
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612				■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		2	MM0612				■	
MM08-08009-B90A30-E03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓			■	
MM08-08009-B90A30-M03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓				■

Avans mare





—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Varianta	Calităţi: Acoperită T60M	F15M	F30M	F40M
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*									
MM08-08.40-HF-MD06	8,0 *0.315*	4,0 *0.157*	0,37 *0.015*	0,88 *0.035*	4,0 *0.157*	6,84 *0.269*	5,0	9,8	14,6	2	MM0612			■	

MM08 - Frezare laterală și canelare – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,046 0.0018	0,055 0.0022	0,070 0.0028
P3	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P4	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P5	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,042 0.0017	0,050 0.0020	0,065 0.0026
P6	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P7	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P8	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P11	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P12	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,046 0.0018	0,055 0.0022	0,070 0.0028
M2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,042 0.0017	0,050 0.0020	0,065 0.0026
M3	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
M4	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
M5	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
K1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K4	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K5	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
K6	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K7	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
S12	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
S13	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
H5	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0018
H8	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013
H11	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0018
H12	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013
H21	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 - Frezare laterală și canelare – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	370 *1225*	410 *1350*	255 *840*	315 *1025*	350 *1150*	385 *1275*	205 *670*	250 *820*	280 *920*	310 *1025*
P2	255 *840*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	195 *640*	245 *800*	275 *900*	300 *980*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	170 *560*	210 *690*	240 *790*	260 *850*
P4	195 *640*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	290 *950*	150 *490*	185 *610*	210 *690*	230 *750*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	145 *475*	180 *590*	200 *660*	220 *720*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	280 *920*	310 *1025*	160 *520*	200 *660*	225 *740*	250 *820*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	145 *475*	180 *590*	200 *660*	220 *720*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	150 *490*	185 *610*	210 *690*	230 *750*
P12	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	95 *310*	115 *375*	130 *425*	145 *475*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	195 *640*	220 *720*	240 *790*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	130 *425*	160 *520*	180 *590*	200 *660*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	105 *345*	130 *425*	145 *475*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	80 *260*	100 *330*	110 *360*	120 *395*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	85 *280*	90 *295*	100 *330*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	155 *510*	195 *640*	215 *710*	235 *770*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	135 *445*	170 *560*	190 *620*	210 *690*
K3	155 *510*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	115 *375*	145 *475*	160 *520*	180 *590*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	110 *360*	140 *460*	155 *510*	170 *560*
K5	90 *295*	110 *360*	120 *395*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	85 *280*	95 *310*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	150 *490*
K7	115 *375*	140 *460*	155 *510*	170 *560*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1550 *5075*	1950 *6400*	2150 *7050*	2350 *7700*	1475 *4850*	1850 *6075*	2025 *6650*	2250 *7375*	1175 *3850*	1475 *4850*	1625 *5325*	1800 *5900*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	750 *2450*	820 *2700*	910 *2975*	475 *1550*	590 *1925*	660 *2175*	720 *2350*
N3	420 *1375*	520 *1700*	580 *1900*	630 *2075*	400 *1300*	495 *1625*	550 *1800*	610 *2000*	315 *1025*	395 *1300*	440 *1450*	485 *1600*
N11	480 *1575*	600 *1975*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	630 *2075*	690 *2275*	360 *1175*	455 *1500*	500 *1650*	550 *1800*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
S2	39 *130*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	30 *100*	37 *120*	41 *135*	45 *150*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	26 *85*	32 *105*	36 *120*	39 *130*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	75 *245*	80 *260*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	21 *70*	26 *85*	29 *95*	31 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	31 *100*	39 *130*	43 *140*	47 *155*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	60 *195*	70 *230*	80 *260*	90 *295*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*

MM08 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P3	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P4	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P8	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P11	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P12	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
M1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
M2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
M3	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,040 0.0016	0,040 0.0016	0,040 0.0016	0,055 0.0022
M4	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
M5	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
K6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
S1	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
S12	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
S13	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Finisare – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
P3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
P4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,095 0.0038	0,15 0.0060
P5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P8	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
P11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P12	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
M1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
M2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
K6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
S1	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,038 0.0015	0,042 0.0017	0,060 0.0024	0,095 0.0038
S11	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 Z3 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	265 *870*	315 *1025*	335 *1100*	360 *1175*	360 *1175*
P2	270 *890*	325 *1075*	345 *1125*	370 *1225*	365 *1200*	260 *850*	310 *1025*	325 *1075*	350 *1150*	350 *1150*
P3	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*	225 *740*	270 *890*	280 *920*	305 *1000*	300 *980*
P4	210 *690*	250 *820*	265 *870*	280 *920*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P6	225 *740*	265 *870*	280 *920*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P7	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*	200 *660*	240 *790*	255 *840*	275 *900*	270 *890*
P8	200 *660*	235 *770*	250 *820*	270 *890*	265 *870*	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*
P11	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	260 *850*	275 *900*	300 *980*	295 *970*	210 *690*	250 *820*	265 *870*	285 *940*	280 *920*
M2	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*	170 *560*	205 *670*	215 *710*	235 *770*	230 *750*
M3	145 *475*	170 *560*	175 *570*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	180 *590*	180 *590*
M4	100 *330*	135 *445*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	80 *260*	110 *360*	105 *375*	115 *375*	115 *375*
K1	215 *710*	255 *840*	270 *890*	295 *970*	290 *950*	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*
K2	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*
K4	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	185 *610*	200 *660*	195 *640*
K5	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	180 *590*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	110 *360*	135 *445*	140 *460*	155 *510*	155 *510*
N1	1625 *5325*	1950 *6400*	2075 *6800*	2225 *7300*	2200 *7225*	1550 *5075*	1850 *6075*	1975 *6475*	2125 *6975*	2100 *6900*
N2	660 *2175*	790 *2600*	830 *2725*	900 *2950*	890 *2925*	630 *2075*	750 *2450*	790 *2600*	850 *2800*	840 *2750*
N3	440 *1450*	520 *1700*	560 *1825*	600 *1975*	590 *1925*	420 *1375*	500 *1650*	530 *1750*	570 *1875*	560 *1825*
N11	500 *1650*	600 *1975*	640 *2100*	680 *2225*	670 *2200*	480 *1575*	570 *1875*	610 *2000*	650 *2125*	640 *2100*
S1	46 *150*	65 *215*	65 *215*	70 *230*	70 *230*	44 *145*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	31 *100*	43 *140*	42 *150*	45 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	35 *125*	38 *125*	38 *125*	25 *80*	34 *110*	34 *120*	36 *120*	37 *120*
H5	43 *140*	50 *165*	55 *180*	60 *195*	55 *180*	41 *135*	49 *160*	50 *165*	55 *180*	55 *180*
H8	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	100 *330*	105 *345*	105 *345*	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*
H21	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*

MM08 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,046 0.0018	0,055 0.0022	0,070 0.0028
P2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
P3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,046 0.0018	0,044 0.0017	0,050 0.0020	0,070 0.0028
P4	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
P5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P8	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,046 0.0018	0,044 0.0017	0,050 0.0020	0,070 0.0028
P11	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
M1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
M2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
M3	MM08-08008-B90S-E03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,040 0.0016	0,055 0.0022
M4	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
M5	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
K1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K4	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 0.0016	0,038 0.0015	0,046 0.0018	0,060 0.0024
K6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 0.0016	0,038 0.0015	0,046 0.0018	0,060 0.0024
N1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
S2	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
S3	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,032 0.0013	0,030 0.0012	0,034 0.0013	0,042 0.0017
S11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,042 0.0017	0,055 0.0022
S12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,042 0.0017	0,055 0.0022
S13	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
H5	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
H8	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013
H11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
H12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013
H21	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Finisare – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P8	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P12	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
M1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
M2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
M3	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
M4	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
M5	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
K1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
K2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
K6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
N1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
S1	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
S2	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
S3	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,014 0.00060	0,020 0.00080	0,030 0.0012
S11	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
S12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
S13	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
H5	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H8	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010
H11	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010
H21	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 Z2 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	320 *1050*	405 *1325*	430 *1400*	465 *1525*	465 *1525*	265 *870*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	215 *710*	265 *870*	290 *950*	315 *1025*	310 *1025*
P2	315 *1025*	395 *1300*	420 *1375*	450 *1475*	450 *1475*	260 *850*	320 *1050*	345 *1125*	375 *1225*	370 *1225*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*
P3	270 *890*	340 *1125*	360 *1175*	390 *1275*	390 *1275*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P4	240 *790*	300 *980*	320 *1050*	345 *1125*	345 *1125*	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
P5	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*
P6	255 *840*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	305 *1000*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*
P7	240 *790*	300 *980*	320 *1050*	350 *1150*	350 *1150*	200 *660*	250 *820*	270 *890*	295 *970*	290 *950*	160 *520*	200 *660*	220 *720*	235 *770*	235 *770*
P8	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	250 *820*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P11	235 *770*	295 *970*	315 *1025*	340 *1125*	340 *1125*	195 *640*	240 *790*	260 *850*	285 *940*	280 *920*	160 *520*	195 *640*	210 *690*	230 *750*	230 *750*
P12	145 *475*	185 *610*	185 *620*	200 *660*	200 *660*	125 *410*	155 *510*	165 *540*	175 *570*	175 *570*	100 *330*	125 *410*	130 *445*	145 *475*	140 *460*
M1	250 *820*	315 *1025*	335 *1100*	365 *1200*	365 *1200*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*	170 *560*	210 *690*	225 *740*	245 *800*	240 *790*
M2	205 *670*	255 *840*	275 *900*	295 *970*	295 *970*	170 *560*	210 *690*	230 *750*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
M3	165 *540*	205 *670*	210 *710*	225 *740*	225 *740*	135 *445*	175 *570*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	135 *475*	150 *490*	150 *490*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*
M5	105 *345*	135 *445*	130 *460*	140 *460*	140 *460*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*	75 *245*	95 *310*	90 *330*	100 *330*	100 *330*
K1	250 *820*	310 *1025*	330 *1075*	360 *1175*	355 *1175*	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
K2	215 *710*	270 *890*	290 *950*	310 *1025*	310 *1025*	180 *590*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
K3	180 *590*	230 *750*	245 *800*	265 *870*	265 *870*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*	125 *410*	155 *510*	165 *540*	180 *590*	180 *590*
K4	175 *570*	220 *720*	235 *770*	250 *820*	250 *820*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	145 *475*	160 *520*	170 *560*	170 *560*
K5	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	90 *295*	110 *360*	120 *395*	125 *410*	125 *410*	70 *230*	90 *295*	95 *310*	105 *345*	105 *345*
K6	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	130 *425*	160 *520*	170 *560*	185 *610*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K7	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*	90 *295*	110 *360*	120 *395*	130 *425*	130 *425*
N1	1925 *6325*	2425 *7950*	2575 *8450*	2800 *9175*	2775 *9100*	1550 *5075*	1925 *6325*	2075 *6800*	2250 *7375*	2225 *7300*	1250 *4100*	1550 *5075*	1675 *5500*	1825 *6000*	1800 *5900*
N2	780 *2550*	980 *3225*	1050 *3450*	1125 *3700*	1125 *3700*	630 *2075*	780 *2550*	840 *2750*	910 *2975*	900 *2950*	510 *1675*	630 *2075*	680 *2225*	740 *2425*	730 *2400*
N3	520 *1700*	650 *2125*	700 *2300*	750 *2450*	750 *2450*	420 *1375*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	340 *1125*	420 *1375*	455 *1500*	490 *1600*	485 *1600*
N11	590 *1925*	740 *2425*	800 *2625*	860 *2825*	860 *2825*	480 *1575*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	390 *1275*	480 *1575*	520 *1700*	560 *1825*	560 *1825*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *145*	45 *150*	45 *150*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	45 *150*	45 *155*	48 *155*	48 *155*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*
S12	60 *195*	75 *245*	75 *245*	80 *260*	80 *260*	48 *155*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*	23 *75*	29 *95*	29 *100*	31 *100*	32 *105*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	60 *195*	33 *110*	42 *140*	44 *145*	47 *155*	47 *155*
H8	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *280*	85 *280*	85 *280*
H21	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*

MM08 Avans mare – Alegerea plăcuţelor – Metric/ Inci

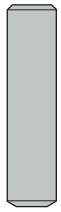
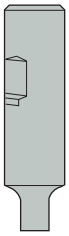
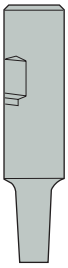
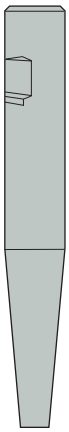
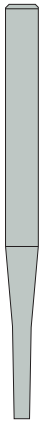
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
P4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,38 0.015	0,48 0.019
P5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
P6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P8	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
P11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P12	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
M1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
M2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
M3	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
M4	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
M5	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
K1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
K2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 0.010	0,26 0.010	0,34 0.013	0,42 0.017
K6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 0.010	0,26 0.010	0,34 0.013	0,42 0.017
N1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
S1	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
S2	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
S3	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,19 0.0075	0,19 0.0075	0,24 0.0095	0,30 0.012
S11	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
S12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
S13	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
H5	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
H8	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095
H11	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
H12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095
H21	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM08 Avans mare Regim de așchiere

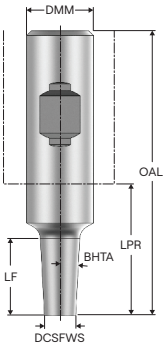
SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *620*	235 *770*	270 *890*	285 *940*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	230 *750*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	195 *640*	240 *790*	275 *900*	295 *970*
M2	165 *540*	195 *640*	230 *750*	240 *790*
M3	130 *425*	155 *510*	180 *590*	190 *620*
M4	100 *330*	120 *395*	140 *460*	145 *475*
M5	85 *280*	100 *330*	115 *375*	120 *395*
K1	195 *640*	235 *770*	270 *890*	290 *950*
K2	170 *560*	210 *690*	240 *790*	255 *840*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	125 *410*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1475 *4850*	1800 *5900*	2050 *6725*	2125 *6975*
N2	590 *1925*	720 *2350*	820 *2700*	860 *2825*
N3	395 *1300*	480 *1575*	550 *1800*	570 *1875*
N11	450 *1475*	550 *1800*	630 *2075*	650 *2125*
S1	48 *155*	55 *180*	65 *215*	70 *230*
S2	39 *130*	46 *150*	50 *165*	55 *180*
S3	33 *110*	40 *130*	46 *150*	48 *155*
S11	65 *215*	80 *260*	90 *295*	95 *310*
S12	46 *150*	55 *180*	65 *215*	65 *215*
S13	27 *90*	32 *105*	36 *120*	38 *125*
H5	40 *130*	47 *155*	55 *180*	60 *195*
H8	41 *135*	50 *165*	55 *180*	60 *195*
H11	50 *165*	60 *195*	70 *230*	75 *245*
H12	75 *245*	90 *295*	100 *330*	105 *345*
H21	41 *135*	50 *165*	55 *180*	60 *195*

Design coadă

Design 1, Coadă cheie	Design 2, Parte dorsală cilindrică/Weldon și 90º în față
	
Design 3, Parte dorsală cilindrică/Weldon parte frontală conică 87º/89º	**Design 4, Parte dorsală cilindrică/Weldon parte frontală conică 80º/85º/87º**
	
Design 5, Parte dorsală cilindrică parte frontală conică dublă 89º/85º	
	

MM10 Coadă





Reper Nr.	Număr reper	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		mm	mm	mm	mm	mm						kg	
MM10-10045.0-0007	00083979	9,6	10,0	7,0	7,0	45,0	0,0	2	■	80000	Cylindrical	0,1	2
MM10-12060.0-0007DS	02580667	9,6	12,0	7,0	15,0	60,0	0,0	2	■	76300	Cylindrical Densimet	0,1	3
MM10-12085.0-3024DS	02580704	9,5	12,0	23,8	40,0	85,0	3,0	4	■	76300	Cylindrical Densimet	0,2	3
MM10-12100.0-1035DS	02580733	9,5	12,0	35,0	55,0	100,0	1,0	3	■	76300	Cylindrical Densimet	0,2	3
MM10-14120.0-1050DS	02580736	9,5	14,0	50,0	75,0	120,0	1,0	3	■	76300	Cylindrical Densimet	0,3	3
MM10-16065.0-0000	75004925	9,5	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM10-16160.0-1035M	00094757	9,5	16,0	35,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	6
MM10-16160.0-1055M	00094758	9,5	16,0	55,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16160.0-1075M	00094760	9,5	16,0	75,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16085.0-0020DS	02580688	9,5	16,0	20,0	37,0	85,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16105.0-0040DS	02580689	9,5	16,0	40,0	57,0	105,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16160.0-1055DS	02580748	9,5	16,0	55,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-16160.0-1075DS	02580749	9,5	16,0	75,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-20075.3-0010	75012787	9,5	20,0	10,0	25,0	75,0	0,0	2	■	80000	Weldon	0,2	4
MM10-20085.3-3023	75012788	9,5	20,0	23,0	35,0	85,0	3,0	3	■	80000	Weldon	0,2	4
MM10-20140.3-5060	75012789	9,5	20,0	60,0	90,0	140,0	5,0	4	■	80000	Weldon	0,3	5
MM10-20250.0-1055DS	02580750	9,5	20,0	55,0	200,0	250,0	1,0	5	■	76300	Cylindrical Densimet	1,0	3
MM10-32250.0-10063	75069366	9,5	32,0	63,8	190,0	250,0	10,0	4	■	80000	Cylindrical	1,3	5

Piese de schimb, Piese incluse la livrare

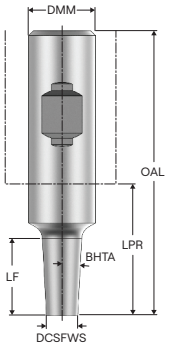
Accesorii

Pentru freza	Manşon	Şurub tensiune	Sleeve key
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	–	MM10-061027	–
4	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
6	MM-06048	MM10-0651	H06-4
7	MM-06032	MM10-0688	H06-4

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

MM10 Coadă – inci





Reper Nr.	Număr reper	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		inci	inci	inci	inci	inci						lbs	
MM10-0.38-1.8-0-0002	00096126	0.360	0.375	0.276	0.276	1.772	0,0	2	■	80000	Cylindrical	0.220	2
MM10-0.62-2.6-0-0000	75005069	0.374	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM10-0.62-6.3-0-1021	75054608	0.360	0.625	2.165	4.409	6.299	1,0	3	■	80000	Cylindrical	0.440	7
MM10-0.75-3.0-3-0004	75015052	0.360	0.750	0.394	0.984	2.953	0,0	2	■	80000	Weldon	0.440	3
MM10-0.75-3.3-3-3009	75015053	0.374	0.750	0.906	1.378	3.346	3,0	3	■	80000	Weldon	0.440	3
MM10-0.75-5.5-3-5021	75015054	0.374	0.750	2.150	3.543	5.512	5,0	4	■	80000	Weldon	0.660	5
MM10-0.75-10.0-0-1021DS	02593420	0.360	0.750	2.165	7.874	9.843	1,0	5	■	76300	Cylindrical Densimet	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	0.360	0.750	1.575	2.165	4.134	0,0	2	■	76300	Cylindrical Densimet	0.660	4
MM10-1.25-10.0-0-10024	00096132	0.374	1.250	2.484	7.480	9.843	10,0	4	■	80000	Cylindrical	2.870	5

Piese de schimb, Piese incluse la livrare

Accesorii

Pentru freza	Manșon	Șurub tensiune	Sleeve key
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	MM-06048	MM10-0627	H06-4
4	–	MM10-061027	–
5	MM-06116	MM10-0627	H06-4
7	MM-06032	MM10-0688	H06-4

Cheia Allen H05-4 pentru manșoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

Frezare de canal/frezare în unghi drept

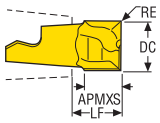


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta		Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								T60M	F15M	F30M	F40M
MM10-09512-A30-E03	9,525 *0.375*	11,8 *0.465*	–	15,72 *0.619*	15,0	11,6	18,8	30	3	MM0416	✓			■	
MM10-09512-R03A30-M03	9,525 *0.375*	11,8 *0.465*	0,3 *0.012*	15,72 *0.619*	15,0	11,6	18,2	30	3	MM0416	✓				■
MM10-09512-R04A30-M03	9,525 *0.375*	11,8 *0.465*	0,4 *0.016*	15,72 *0.619*	15,0	11,6	18,0	30	3	MM0416	✓				■
MM10-09512-R08A30-M03	9,525 *0.375*	11,8 *0.465*	0,8 *0.031*	15,72 *0.619*	15,0	11,6	17,2	30	3	MM0416	✓				■
MM10-09512-R16A30-M03	9,525 *0.375*	11,8 *0.465*	1,6 *0.063*	15,72 *0.619*	15,0	11,6	15,6	30	3	MM0416	✓				■
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	–	15,72 *0.619*	15,0	12,2	19,8	30	3	MM0416	✓			■	
MM10-10012-R05A30-M03	10,0 *0.394*	11,8 *0.465*	0,5 *0.020*	15,72 *0.619*	15,0	12,2	18,8	30	3	MM0416	✓				■
MM10-10012-R10A30-D03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-E03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-M03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓				■
MM10-10012-R20A30-M03	10,0 *0.394*	11,8 *0.465*	2,0 *0.079*	15,72 *0.619*	15,0	12,2	15,8	30	3	MM0416	✓				■
MM10-10012-R30A30-M03	10,0 *0.394*	11,8 *0.465*	3,0 *0.118*	15,72 *0.619*	15,0	12,2	13,8	30	3	MM0416	✓				■

Frezare de canal/frezare în unghi drept



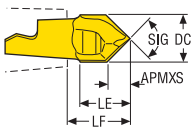


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*							T60M	F15M	F30M	F40M
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	–	8,5 *0.335*	15,0	11,6	18,8	0	2	MM0612	■			
MM10-09510-R04-MD04	9,525 *0.375*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	11,6	18,0	0	2	MM0612	■			
MM10-09510-R08A8-E03	9,525 *0.375*	6,6 *0.260*	0,8 *0.031*	8,37 *0.330*	15,0	11,6	17,2	8	2	MM0612			■	
MM10-09807T-R03-D04	9,8 *0.386*	6,8 *0.268*	0,3 *0.012*	8,49 *0.334*	15,0	11,9	18,8	0	2	MM0612	■			
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	–	8,5 *0.335*	15,0	12,2	19,8	0	2	MM0612	■			
MM10-10007-R04A8-E03	10,0 *0.394*	6,6 *0.260*	0,4 *0.016*	8,44 *0.332*	15,0	12,2	19,0	8	2	MM0612	■		■	
MM10-10007-R04-MD04	10,0 *0.394*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	12,2	19,0	0	2	MM0612	■		■	
MM10-10007-R04P-M03	10,0 *0.394*	6,7 *0.264*	0,4 *0.016*	8,38 *0.330*	15,0	12,2	19,0	0	2	MM0612			■	
MM10-10007-R10-MD04	10,0 *0.394*	6,8 *0.268*	1,0 *0.039*	8,48 *0.334*	15,0	12,2	17,8	0	2	MM0612	■		■	
MM10-10007-R20-MD04	10,0 *0.394*	6,8 *0.268*	2,0 *0.079*	8,46 *0.333*	15,0	12,2	15,8	0	2	MM0612			■	
MM10-10007-R30-MD04	10,0 *0.394*	6,8 *0.268*	3,0 *0.118*	8,44 *0.332*	15,0	12,2	13,8	0	2	MM0612			■	

Frezare centrală



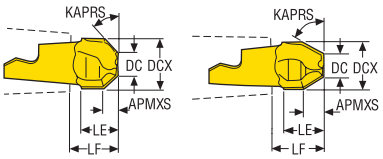


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	SIG°	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	– –	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	– –	11,8 *0.465*	120,0	2	MM0612	■			

Şanfrenare



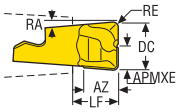


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

										Calităţi			
										Acoperită			
Reper Nr.	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Varianta				
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	0,3 *0.012*	6,94 *0.273*	8,48 *0.334*	45,0	2	MM0612	■			
MM10-10008-6040-E03	10,0 *0.394*	5,24 *0.206*	4,0 *0.157*	0,3 *0.012*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

Frezare axială

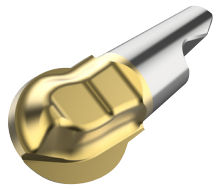




—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

									Calităţi			
									Acoperită			
Reper Nr.	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Varianta				
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM10-10007-R10-PL-MD04	10,0 *0.394*	5,0 *0.197*	1,0 *0.039*	7,1 *0.280*	8,48 *0.334*	5,0	2	MM0612			■	

Plăcuţe de precizie pentru semifinisare în toate materialele



—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM10-12012-B120P-M05	12,0 *0.472*	6,0 *0.236*	6,0 *0.236*	12,0 *0.472*	10,0 *0.394*	13,2 *0.520*	247,0	2	MM0612			■	
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	10,0 *0.394*	13,56 *0.534*	256,0	2	MM1420			■	

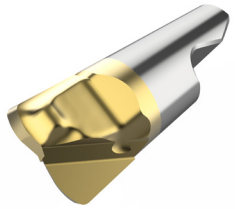
Frezare prin copiere

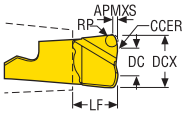


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	FHA	ZEFP	Varianta		Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM10-09510-B90P-M04	9,525 *0.375*	8,7 *0.343*	4,763 *0.188*	11,74 *0.462*		2	MM0612		■		■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		2	MM0612		■		■	
MM10-10010-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612			■		
MM10-10010-B90P-M04	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612				■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		2	MM0612				■	
MM10-10012-B90A30-D03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-E03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-M03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓				■

Avans mare





—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*						T60M	F15M	F30M	F40M
MM10-10.50-HF-MD08	10,0 *0.394*	5,0 *0.197*	0,44 *0.017*	1,13 *0.044*	5,0 *0.197*	8,5 *0.335*	5,0	12,2	18,2	2	MM0612		■	■	

MM10 - Frezare laterală și canelare – Alegerea plăcuțelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P3	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P4	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P5	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,050 0.0020	0,065 0.0026
P6	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P7	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P8	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P11	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P12	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
M2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,050 0.0020	0,065 0.0026
M3	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,032 0.0013	0,032 0.0013	0,040 0.0016	0,050 0.0020
M4	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
M5	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
K1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K4	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K5	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 0.0016	0,038 0.0015	0,044 0.0017	0,060 0.0024
K6	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K7	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 0.0016	0,038 0.0015	0,044 0.0017	0,060 0.0024
N1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,046 0.0018
S2	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,046 0.0018
S3	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,042 0.0017
S11	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,050 0.0020
S12	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,050 0.0020
S13	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
H5	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
H8	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013
H11	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
H12	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013
H21	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 - Frezare laterală și canelare – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	365 *1200*	405 *1325*	250 *820*	315 *1025*	345 *1125*	385 *1275*	190 *620*	240 *790*	270 *890*	295 *970*
P2	260 *850*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	185 *610*	235 *770*	260 *850*	290 *950*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	165 *540*	205 *670*	230 *750*	250 *820*
P4	200 *660*	245 *800*	275 *900*	305 *1000*	190 *620*	235 *770*	260 *850*	290 *950*	145 *475*	180 *590*	200 *660*	225 *740*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	140 *460*	175 *570*	195 *640*	215 *710*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	220 *720*	240 *790*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	145 *475*	185 *610*	205 *670*	225 *740*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	140 *460*	175 *570*	190 *620*	210 *690*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
P12	125 *410*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	150 *490*	190 *620*	210 *690*	235 *770*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	125 *410*	155 *510*	175 *570*	190 *620*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	100 *330*	125 *410*	140 *460*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	75 *245*	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	95 *310*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	150 *490*	185 *610*	205 *670*	230 *750*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	235 *770*	260 *850*	130 *425*	165 *540*	185 *610*	200 *660*
K3	150 *490*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	110 *360*	140 *460*	155 *510*	170 *560*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	150 *490*	165 *540*
K5	90 *295*	110 *360*	125 *410*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	115 *375*	130 *425*	145 *475*
K7	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	115 *375*	125 *410*
N1	1550 *5075*	1925 *6325*	2150 *7050*	2350 *7700*	1475 *4850*	1825 *6000*	2025 *6650*	2250 *7375*	1125 *3700*	1400 *4600*	1550 *5075*	1725 *5650*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	740 *2425*	820 *2700*	910 *2975*	450 *1475*	570 *1875*	630 *2075*	690 *2275*
N3	415 *1350*	520 *1700*	580 *1900*	630 *2075*	395 *1300*	495 *1625*	550 *1800*	610 *2000*	300 *980*	380 *1250*	420 *1375*	460 *1500*
N11	475 *1550*	590 *1925*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	620 *2025*	690 *2275*	345 *1125*	430 *1400*	480 *1575*	530 *1750*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S2	38 *125*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	25 *80*	32 *105*	35 *115*	38 *125*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	35 *115*	43 *140*	49 *160*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	20 *65*	25 *80*	28 *90*	30 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	38 *125*	42 *140*	46 *150*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	38 *125*	48 *155*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	55 *180*	70 *230*	80 *260*	85 *280*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*

MM10 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
P3	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P4	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P5	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P6	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P7	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P8	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P11	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P12	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
M1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
M2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
M3	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
M4	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
M5	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K5	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
K6	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K7	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
S1	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 0.0017	0,042 0.0017	0,042 0.0017	0,055 0.0022
S12	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 0.0017	0,042 0.0017	0,042 0.0017	0,055 0.0022
S13	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
H5	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
H8	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H11	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
H12	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H21	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
P3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,095 0.0038	0,15 0.0060
P5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P8	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P12	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
M1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
M2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
K6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
S1	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,038 0.0015	0,042 0.0017	0,060 0.0024	0,095 0.0038
S11	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
H8	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H11	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
H12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H21	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 Z3 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	270 *890*	310 *1025*	335 *1100*	365 *1200*	360 *1175*
P2	275 *900*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	260 *850*	305 *1000*	325 *1075*	355 *1175*	355 *1175*
P3	240 *790*	280 *920*	295 *970*	320 *1050*	320 *1050*	230 *750*	265 *870*	280 *920*	305 *1000*	305 *1000*
P4	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	260 *850*
P6	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	250 *820*	270 *890*	290 *950*	290 *950*
P7	215 *710*	250 *820*	265 *870*	290 *950*	285 *940*	205 *670*	235 *770*	255 *840*	275 *900*	275 *900*
P8	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	260 *850*
P11	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	160 *520*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	255 *840*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	260 *850*	285 *940*	285 *940*
M2	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*	175 *570*	200 *660*	215 *710*	235 *770*	230 *750*
M3	145 *475*	175 *570*	175 *590*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	185 *610*	180 *590*
M4	95 *310*	140 *460*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	75 *245*	110 *360*	105 *375*	115 *375*	115 *375*
K1	220 *720*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	255 *840*	280 *920*	280 *920*
K2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	230 *750*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*
K4	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*	145 *475*	170 *560*	185 *610*	200 *660*	195 *640*
K5	95 *310*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	115 *375*	130 *425*	140 *460*	155 *510*	155 *510*
N1	1650 *5425*	1925 *6325*	2050 *6725*	2225 *7300*	2200 *7225*	1575 *5175*	1825 *6000*	1950 *6400*	2125 *6975*	2100 *6900*
N2	670 *2200*	780 *2550*	830 *2725*	900 *2950*	890 *2925*	640 *2100*	740 *2425*	790 *2600*	860 *2825*	850 *2800*
N3	445 *1450*	520 *1700*	550 *1800*	600 *1975*	590 *1925*	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*
N11	510 *1675*	590 *1925*	630 *2075*	690 *2275*	680 *2225*	485 *1600*	560 *1825*	600 *1975*	650 *2125*	650 *2125*
S1	45 *150*	65 *215*	65 *215*	70 *230*	70 *230*	43 *140*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	30 *100*	43 *140*	42 *150*	46 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	45 *150*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	36 *125*	38 *125*	38 *125*	24 *80*	34 *110*	34 *120*	37 *120*	37 *120*
H5	43 *140*	55 *180*	55 *180*	60 *195*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H8	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
H12	75 *245*	100 *330*	100 *330*	105 *345*	105 *345*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*
H21	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*

MM10 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
P2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
P3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P4	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
P6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P8	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P11	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P12	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
M1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
M2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
M3	MM10-10010-B90S-E04 F30M	3,5 *0.14*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
M4	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
M5	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
K1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
K2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K4	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,080 0.0032
K6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,080 0.0032
N1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N11	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
S1	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
S2	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
S3	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,042 0.0017	0,042 0.0017	0,044 0.0017	0,055 0.0024
S11	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
S12	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
S13	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
H5	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
H8	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018
H11	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
H12	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018
H21	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
P3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
P6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P8	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P12	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
M2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
M3	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
M4	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
M5	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
K1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
K2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
K6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
N1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
S2	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
S3	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
S12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
S13	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
H5	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H11	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H21	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 Z2 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	305 *1000*	390 *1275*	405 *1325*	440 *1450*	440 *1450*	250 *820*	320 *1050*	340 *1125*	370 *1225*	365 *1200*	205 *670*	260 *850*	275 *900*	300 *980*	295 *970*
P2	295 *970*	380 *1250*	395 *1300*	425 *1400*	425 *1400*	240 *790*	305 *1000*	330 *1075*	355 *1175*	355 *1175*	195 *640*	250 *820*	270 *890*	285 *940*	285 *940*
P3	260 *850*	330 *1075*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*
P4	225 *740*	290 *950*	300 *980*	325 *1075*	325 *1075*	185 *610*	235 *770*	255 *840*	270 *890*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P5	215 *710*	275 *900*	290 *950*	315 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	265 *870*	260 *850*	145 *475*	185 *610*	195 *640*	215 *710*	210 *690*
P6	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P7	230 *750*	295 *970*	305 *1000*	330 *1075*	330 *1075*	190 *620*	240 *790*	260 *850*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P11	225 *740*	285 *940*	295 *970*	325 *1075*	320 *1050*	185 *610*	235 *770*	250 *820*	270 *890*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	215 *710*
P12	140 *460*	175 *570*	180 *610*	195 *640*	195 *640*	120 *395*	150 *490*	155 *510*	170 *560*	170 *560*	95 *310*	120 *395*	125 *410*	135 *445*	135 *445*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	195 *640*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
M2	195 *640*	250 *820*	260 *850*	280 *920*	280 *920*	160 *520*	205 *670*	215 *710*	235 *770*	235 *770*	130 *425*	165 *540*	175 *570*	190 *620*	190 *620*
M3	155 *510*	200 *660*	200 *670*	220 *720*	220 *720*	130 *425*	165 *540*	175 *570*	185 *610*	185 *610*	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*
M4	120 *395*	155 *510*	155 *560*	165 *540*	165 *540*	105 *345*	135 *445*	130 *460*	145 *475*	140 *460*	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	335 *1100*	335 *1100*	190 *620*	245 *800*	260 *850*	280 *920*	280 *920*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
K2	205 *670*	265 *870*	275 *900*	295 *970*	295 *970*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*
K3	175 *570*	225 *740*	230 *750*	250 *820*	250 *820*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	150 *490*	155 *510*	170 *560*	170 *560*
K4	165 *540*	215 *710*	220 *720*	240 *790*	240 *790*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	160 *520*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
K6	145 *475*	185 *610*	195 *640*	210 *690*	210 *690*	120 *395*	155 *510*	165 *540*	180 *590*	175 *570*	95 *310*	125 *410*	130 *425*	145 *475*	145 *475*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	105 *345*	135 *445*	145 *475*	155 *510*	155 *510*	85 *280*	110 *360*	115 *375*	125 *410*	125 *410*
N1	1800 *5900*	2300 *7550*	2425 *7950*	2600 *8525*	2600 *8525*	1450 *4750*	1825 *6000*	1975 *6475*	2150 *7050*	2100 *6900*	1175 *3850*	1475 *4850*	1600 *5250*	1725 *5650*	1700 *5575*
N2	730 *2400*	930 *3050*	970 *3175*	1050 *3450*	1050 *3450*	590 *1925*	740 *2425*	800 *2625*	870 *2850*	850 *2800*	475 *1550*	600 *1975*	650 *2125*	700 *2300*	680 *2225*
N3	485 *1600*	620 *2025*	650 *2125*	700 *2300*	700 *2300*	390 *1275*	495 *1625*	530 *1750*	580 *1900*	560 *1825*	315 *1025*	400 *1300*	435 *1425*	465 *1525*	455 *1500*
N11	550 *1800*	710 *2325*	740 *2425*	800 *2625*	800 *2625*	450 *1475*	570 *1875*	610 *2000*	660 *2175*	640 *2100*	360 *1175*	460 *1500*	495 *1625*	530 *1750*	520 *1700*
S1	55 *180*	70 *230*	70 *260*	80 *260*	75 *245*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S2	46 *150*	60 *195*	60 *215*	65 *215*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	32 *105*	40 *130*	40 *140*	43 *140*	43 *140*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	34 *110*	43 *140*	43 *150*	47 *155*	46 *150*	27 *90*	35 *115*	35 *120*	38 *125*	38 *125*
S11	80 *260*	100 *330*	100 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *295*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	49 *165*	55 *180*	55 *180*
S13	32 *105*	41 *135*	40 *145*	44 *145*	43 *140*	27 *90*	35 *115*	35 *120*	37 *120*	37 *120*	22 *70*	28 *90*	28 *100*	30 *100*	30 *100*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	32 *105*	41 *135*	42 *140*	45 *150*	45 *150*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	40 *130*	50 *165*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*

MM10 Avans mare Alegerea plăcuţei – Metric/ Inci

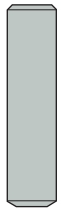
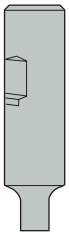
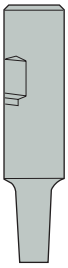
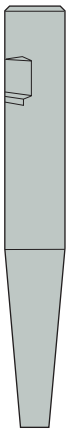
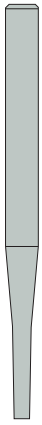
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 0.019	0,48 0.019	0,65 0.026	0,80 0.032
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
P6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P8	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P12	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
M1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
M2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
M3	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
M4	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
M5	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
K1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
K2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 0.016	0,40 0.016	0,55 0.022	0,65 0.026
K6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 0.016	0,40 0.016	0,55 0.022	0,65 0.026
N1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
S1	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
S2	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
S3	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,30 0.012	0,30 0.012	0,38 0.015	0,46 0.018
S11	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
S12	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
S13	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
H5	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
H8	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
H11	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
H12	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
H21	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM10 Avans mare Regim de așchiere

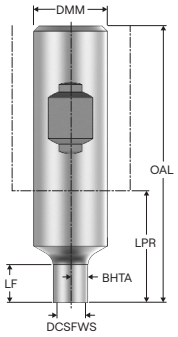
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P6	—	—	—	—	185	225	260	270
	—	—	—	—	*610*	*740*	*850*	*890*
P7	—	—	—	—	175	215	245	255
	—	—	—	—	*570*	*710*	*800*	*840*
P8	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P11	—	—	—	—	170	210	240	250
	—	—	—	—	*560*	*690*	*790*	*820*
P12	—	—	—	—	110	135	150	160
	—	—	—	—	*360*	*445*	*490*	*520*
M1	—	—	—	—	180	220	255	265
	—	—	—	—	*590*	*720*	*840*	*870*
M2	—	—	—	—	150	180	210	220
	—	—	—	—	*490*	*590*	*690*	*720*
M3	—	—	—	—	120	145	165	175
	—	—	—	—	*395*	*475*	*540*	*570*
M4	—	—	—	—	95	110	130	135
	—	—	—	—	*310*	*360*	*425*	*445*
M5	—	—	—	—	80	95	110	115
	—	—	—	—	*260*	*310*	*360*	*375*
K1	190	230	270	280	175	215	250	260
	620	*750*	*890*	*920*	*570*	*710*	*820*	*850*
K2	170	205	235	245	160	190	220	230
	560	*670*	*770*	*800*	*520*	*620*	*720*	*750*
K3	145	175	200	210	135	160	185	195
	475	*570*	*660*	*690*	*445*	*520*	*610*	*640*
K4	135	165	190	200	125	155	175	185
	445	*540*	*620*	*660*	*410*	*510*	*570*	*610*
K5	85	100	115	125	75	95	105	115
	280	*330*	*375*	*410*	*245*	*310*	*345*	*375*
K6	120	145	170	175	110	135	155	165
	395	*475*	*560*	*570*	*360*	*445*	*510*	*540*
K7	105	130	150	155	100	120	140	145
	345	*425*	*490*	*510*	*330*	*395*	*460*	*475*
N1	—	—	—	—	1325	1600	1850	1925
	—	—	—	—	*4350*	*5250*	*6075*	*6325*
N2	—	—	—	—	530	650	750	780
	—	—	—	—	*1750*	*2125*	*2450*	*2550*
N3	—	—	—	—	355	430	500	520
	—	—	—	—	*1175*	*1400*	*1650*	*1700*
N11	—	—	—	—	405	495	570	590
	—	—	—	—	*1325*	*1625*	*1875*	*1925*
S1	—	—	—	—	45	50	60	65
	—	—	—	—	*150*	*165*	*195*	*215*
S2	—	—	—	—	36	42	49	50
	—	—	—	—	*120*	*140*	*160*	*165*
S3	—	—	—	—	31	37	42	45
	—	—	—	—	*100*	*120*	*140*	*150*
S11	—	—	—	—	60	75	85	90
	—	—	—	—	*195*	*245*	*280*	*295*
S12	—	—	—	—	43	50	60	60
	—	—	—	—	*140*	*165*	*195*	*195*
S13	—	—	—	—	25	29	34	36
	—	—	—	—	*80*	*95*	*110*	*120*
H5	40	48	55	60	37	44	50	55
	130	*155*	*180*	*195*	*120*	*145*	*165*	*180*
H8	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*
H11	50	60	70	75	47	55	65	70
	165	*195*	*230*	*245*	*155*	*180*	*215*	*230*
H12	75	90	105	110	70	85	95	100
	245	*295*	*345*	*360*	*230*	*280*	*310*	*330*
H21	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*

Design coadă

Design 1, Coadă cheie	Design 2, Parte dorsală cilindrică/Weldon și 90º în față
	
Design 3, Parte dorsală cilindrică/Weldon parte frontală conică 87º/89º	**Design 4, Parte dorsală cilindrică/Weldon parte frontală conică 80º/85º/87º**
	
Design 5, Parte dorsală cilindrică parte frontală conică dublă 89º/85º	
	

MM12 Coadă

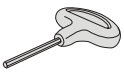




Reper Nr.	Număr reper	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		mm	mm	mm	mm	mm						kg	
MM12-12055.0-0008	00083978	11,5	12,0	8,5	10,0	55,0	0,0	2	■	80000	Cylindrical	0,1	2
MM12-12070.0-0008DS	02580668	11,5	12,0	8,5	25,0	70,0	0,0	2	■	63600	Cylindrical Densimet	0,1	3
MM12-16065.0-0000	75004926	11,4	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM12-16170.0-1040	75034505	11,4	16,0	40,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,3	5
MM12-16170.0-1060	75034506	11,4	16,0	60,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16170.0-1080	75034507	11,4	16,0	80,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16095.0-0024DS	02580690	11,4	16,0	24,0	47,0	95,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16090.0-3044DS	02580705	11,4	16,0	43,9	42,0	90,0	3,0	4	■	63600	Cylindrical Densimet	0,3	3
MM12-16120.0-1045DS	02580752	11,4	16,0	45,0	72,0	120,0	1,0	3	■	63600	Cylindrical Densimet	0,3	3
MM12-16115.0-0048DS	02580691	11,4	16,0	48,0	67,0	115,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16170.0-1060DS	02580753	11,4	16,0	60,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-16170.0-1080DS	02580755	11,4	16,0	80,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-20080.3-0012	75012864	11,4	20,0	12,0	30,0	80,0	0,0	2	■	80000	Weldon	0,2	4
MM12-20095.3-3027	75012865	11,4	20,0	27,0	45,0	95,0	3,0	3	■	80000	Weldon	0,2	4
MM12-20150.3-5049	75012866	11,4	20,0	49,1	100,0	150,0	5,0	4	■	80000	Weldon	0,3	5
MM12-20250.0-1060DS	02580756	11,4	20,0	60,0	200,0	250,0	1,0	5	■	63600	Cylindrical Densimet	1,0	3

Piese de schimb, Piese incluse la livrare

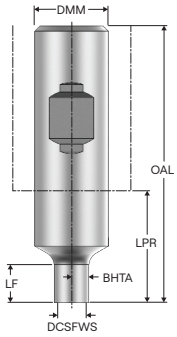
Accesorii

Pentru freza	Manşon	Şurub tensiune	Sleeve key
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	–	MM12-061037	–
4	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

MM12 Coadă – inci





Reper Nr.	Număr reper	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		inci	inci	inci	inci	inci						lbs	
MM12-0.50-2.2-0-0003	00096133	0.453	0.500	0.335	0.394	2.165	0,0	2	■	80000	Cylindrical	0.220	2
MM12-0.62-2.6-0-0000	75005070	0.449	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM12-0.62-6.7-0-1015	75054728	0.449	0.625	1.575	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023	75054729	0.449	0.625	2.362	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	0.449	0.625	2.362	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	0.449	0.625	3.150	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.75-3.1-3-0004	75015055	0.449	0.750	0.472	1.181	3.150	0,0	2	■	80000	Weldon	0.440	3
MM12-0.75-3.7-3-3010	75015056	0.449	0.750	1.063	1.772	3.740	3,0	3	■	80000	Weldon	0.440	3
MM12-0.75-5.9-3-5017	75015057	0.449	0.750	1.720	3.937	5.906	5,0	4	■	80000	Weldon	0.660	5
MM12-0.75-10.0-0-1023DS	02593427	0.449	0.750	2.362	7.874	9.843	1,0	5	■	63600	Cylindrical Densimet	1.980	4
MM12-0.75-3.8-0-0009DS	02593428	0.449	0.750	0.945	1.772	3.740	0,0	2	■	63600	Cylindrical Densimet	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	0.449	0.750	1.890	2.559	4.528	0,0	2	■	63600	Cylindrical Densimet	0.880	4

Piese de schimb, Piese incluse la livrare

Accesorii

Pentru freza	Manșon	Șurub tensiune	Sleeve key
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	MM-06048	MM12-0637	H06-4
4	–	MM12-061037	–
5	MM-06116	MM12-0637	H06-4

Cheia Allen H05-4 pentru manșoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

Frezare de canal/frezare în unghi drept

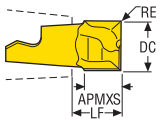


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta		Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								T60M	F15M	F30M	F40M
MM12-11715-R03A30-M04	11,7 *0.461*	15,35 *0.604*	0,3 *0.012*	19,9 *0.783*	15,0	14,2	22,6	30	3	MM0416	✓				■
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	–	19,9 *0.783*	15,0	14,6	23,8	30	3	MM0416	✓			■	
MM12-12015-R05A30-M04	12,0 *0.472*	15,35 *0.604*	0,5 *0.020*	19,9 *0.783*	15,0	14,6	22,8	30	3	MM0416	✓				■
MM12-12015-R10A30-E04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓			■	
MM12-12015-R10A30-M04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓				■
MM12-12015-R15A30-D04	12,0 *0.472*	15,35 *0.604*	1,5 *0.059*	19,9 *0.783*	15,0	14,6	20,8	30	3	MM0416	✓			■	
MM12-12015-R20A30-M04	12,0 *0.472*	15,35 *0.604*	2,0 *0.079*	19,9 *0.783*	15,0	14,6	19,8	30	3	MM0416	✓				■
MM12-12015-R30A30-E04	12,0 *0.472*	15,3 *0.602*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓			■	
MM12-12015-R30A30-M04	12,0 *0.472*	15,35 *0.604*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓				■
MM12-12015-R40A30-M04	12,0 *0.472*	15,35 *0.604*	4,0 *0.157*	19,9 *0.783*	15,0	14,6	15,8	30	3	MM0416	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	–	19,9 *0.783*	15,0	15,4	25,2	30	3	MM0416	✓			■	
MM12-12715-R08A30-M04	12,7 *0.500*	15,35 *0.604*	0,8 *0.031*	19,9 *0.783*	15,0	15,4	23,6	30	3	MM0416	✓				■
MM12-12715-R16A30-M04	12,7 *0.500*	15,35 *0.604*	1,6 *0.063*	19,9 *0.783*	15,0	15,4	22,0	30	3	MM0416	✓				■

Frezare de canal/frezare în unghi drept



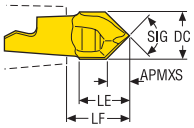


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*							T60M	F15M	F30M	F40M
MM12-11708T-R03-D05	11,7 *0.461*	8,2 *0.323*	0,3 *0.012*	10,18 *0.401*	15,0	14,2	22,6	0	2	MM0612	■			
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	–	10,2 *0.402*	15,0	14,6	23,8	0	2	MM0612	■			
MM12-12008-R08A8-E04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,15 *0.400*	15,0	14,6	22,2	8	2	MM0612	■			
MM12-12008-R08-MD05	12,0 *0.472*	8,2 *0.323*	0,8 *0.031*	10,18 *0.401*	15,0	14,6	22,2	0	2	MM0612	■		■	
MM12-12008-R08P-M04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,05 *0.396*	15,0	14,6	22,2	0	2	MM0612			■	
MM12-12008-R20-MD05	12,0 *0.472*	8,2 *0.323*	2,0 *0.079*	10,16 *0.400*	15,0	14,6	19,8	0	2	MM0612			■	
MM12-12008-R30-MD05	12,0 *0.472*	8,2 *0.323*	3,0 *0.118*	10,14 *0.399*	15,0	14,6	17,8	0	2	MM0612			■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	–	11,25 *0.443*	15,0	15,4	25,2	0	2	MM1420	■			
MM12-12708-R08-MD05	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420	■			
MM12-12708-R08P-M04	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420			■	
MM12-13709T-R03-D05	13,7 *0.539*	9,3 *0.366*	0,3 *0.012*	11,25 *0.443*	15,0	16,6	26,6	0	2	MM1420	■			
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	–	11,26 *0.443*	15,0	17,0	27,8	0	2	MM1420	■			
MM12-14009-R08A8-E04	14,0 *0.551*	9,2 *0.362*	0,8 *0.031*	11,06 *0.435*	15,0	17,0	26,2	8	2	MM1420	■		■	
MM12-14009-R08-MD05	14,0 *0.551*	9,3 *0.366*	0,8 *0.031*	11,26 *0.443*	15,0	17,0	26,2	0	2	MM1420	■		■	

Frezare centrală



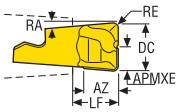


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

								Calităţi			
								Acoperită			
Reper Nr.	DC	APMXS	RE	LF	SIG°	ZEFP	Varianta	T60M	F15M	F30M	F40M
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*							
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	– –	14,64 *0.576*	90,0	2	MM0612	■			

Frezare axială



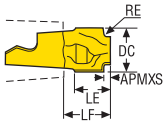


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

									Calităţi			
									Acoperită			
Reper Nr.	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Varianta	T60M	F15M	F30M	F40M
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*							
MM12-12008-R10-PL-MD05	12,0 *0.472*	6,0 *0.236*	1,0 *0.039*	8,5 *0.335*	10,2 *0.402*	5,0	2	MM0612			■	

Rază concavă





—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LE	LF	ZEFP	Varianta	Calităţi			
								Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			T60M	F15M	F30M	F40M
MM12-12010-CR10-MD05	12,0 *0.472*	2,2 *0.087*	1,0 *0.039*	10,6 *0.417*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	10,7 *0.421*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	10,6 *0.417*	12,2 *0.480*	2	MM0612	■			

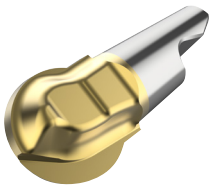
Șanfrenare



—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

Reper Nr.	DCX	DC	APMXS	DN	LF	KAPRS°	BEC°	ZEFP	Varianta	Calităţi			
										Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM12-16016-D3020P-M02	16,0 *0.630*	1,0 *0.039*	4,3 *0.169*	11,5 *0.453*	15,2 *0.598*	30,0	60,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	11,5 *0.453*	17,2 *0.677*	45,0	90,0	2	MM1420		■		

Plăcuţe de precizie pentru semifinisare în toate materialele



—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM12-14014-B120P-M05	14,0 *0.551*	7,0 *0.276*	7,0 *0.276*	14,0 *0.551*	12,0 *0.472*	15,45 *0.608*	242,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420		■		
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420			■	

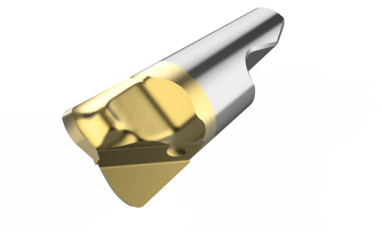
Frezare prin copiere

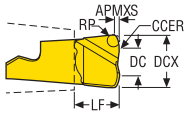


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	FHA	ZEFP	Varianta		Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM12-12012-B90-MD05	12,0 *0.472*	12,2 *0.480*	6,0 *0.236*	14,12 *0.556*		2	MM0612		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612			■		
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612				■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*		2	MM0612				■	
MM12-12015-B90A30-E04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓			■	
MM12-12015-B90A30-M04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓				■
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*		2	MM1420		■		■	
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*		2	MM1420				■	

Avans mare





—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	**DCX**	**DC**	**APMXS**	**RP**	**CCER**	**LF**	**RMPX°**	**C min**	**C max**	**ZEFP**	**Varianta**	**Acoperită**			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*						T60M	F15M	F30M	F40M
MM12-12.60-HF-MD10	12,0 *0.472*	6,0 *0.236*	0,51 *0.020*	1,21 *0.048*	6,5 *0.256*	10,25 *0.404*	5,0	14,6	22,2	2	MM0612		■	■	

MM12 - Frezare laterală și canelare – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,060 0.0024	0,070 0.0028	0,095 0.0038
P2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
P3	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
P4	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
P5	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P6	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P7	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P8	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
P11	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P12	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,036 0.0014	0,036 0.0014	0,044 0.0017	0,060 0.0024
M1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
M2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
M3	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,042 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
M4	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
M5	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
K1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
K2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K4	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K5	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
K6	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,065 0.0026	0,090 0.0036
K7	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
N1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N11	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
S1	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S2	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S3	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,046 0.0018	0,044 0.0017	0,044 0.0017	0,055 0.0024
S11	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
S12	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
S13	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
H5	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
H8	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018
H11	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
H12	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018
H21	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 - Frezare laterală și canelare – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	250 *820*	315 *1025*	350 *1150*	385 *1275*	240 *790*	300 *980*	335 *1100*	365 *1200*	185 *610*	225 *740*	255 *840*	280 *920*
P2	245 *800*	305 *1000*	340 *1125*	375 *1225*	235 *770*	290 *950*	325 *1075*	355 *1175*	175 *570*	220 *720*	250 *820*	275 *900*
P3	210 *690*	265 *870*	295 *970*	325 *1075*	200 *660*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	215 *710*	235 *770*
P4	190 *620*	235 *770*	260 *850*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P5	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	240 *790*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P6	205 *670*	250 *820*	280 *920*	310 *1025*	195 *640*	240 *790*	270 *890*	295 *970*	150 *490*	185 *610*	205 *670*	225 *740*
P7	190 *620*	240 *790*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	215 *710*
P8	175 *570*	220 *720*	245 *800*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P11	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	220 *720*	245 *800*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P12	115 *375*	145 *475*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	170 *560*	85 *280*	110 *360*	120 *395*	130 *425*
M1	200 *660*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
M2	160 *520*	200 *660*	225 *740*	245 *800*	155 *510*	195 *640*	215 *710*	235 *770*	120 *395*	145 *475*	165 *540*	180 *590*
M3	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	145 *475*
M4	100 *330*	125 *410*	140 *460*	150 *490*	95 *310*	115 *375*	130 *425*	145 *475*	75 *245*	90 *295*	100 *330*	110 *360*
M5	80 *260*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K1	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	230 *750*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	220 *720*
K2	170 *560*	215 *710*	240 *790*	260 *850*	165 *540*	205 *670*	225 *740*	245 *800*	125 *410*	155 *510*	175 *570*	190 *620*
K3	145 *475*	180 *590*	200 *660*	220 *720*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	145 *475*	160 *520*
K4	140 *460*	170 *560*	190 *620*	210 *690*	130 *425*	165 *540*	185 *610*	200 *660*	100 *330*	125 *410*	140 *460*	155 *510*
K5	85 *280*	105 *345*	115 *375*	125 *410*	80 *260*	100 *330*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K6	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	110 *360*	125 *410*	135 *445*
K7	105 *345*	135 *445*	150 *490*	165 *540*	100 *330*	125 *410*	140 *460*	155 *510*	80 *260*	100 *330*	110 *360*	120 *395*
N1	1450 *4750*	1800 *5900*	2025 *6650*	2225 *7300*	1375 *4500*	1725 *5650*	1925 *6325*	2125 *6975*	1050 *3450*	1300 *4275*	1450 *4750*	1600 *5250*
N2	580 *1900*	730 *2400*	820 *2700*	900 *2950*	560 *1825*	690 *2275*	780 *2550*	860 *2825*	420 *1375*	530 *1750*	590 *1925*	650 *2125*
N3	390 *1275*	485 *1600*	550 *1800*	600 *1975*	370 *1225*	460 *1500*	520 *1700*	570 *1875*	280 *920*	350 *1150*	395 *1300*	435 *1425*
N11	445 *1450*	550 *1800*	620 *2025*	690 *2275*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	320 *1050*	405 *1325*	450 *1475*	495 *1625*
S1	46 *150*	55 *180*	65 *215*	70 *230*	44 *145*	55 *180*	60 *195*	65 *215*	34 *110*	43 *140*	47 *155*	50 *165*
S2	37 *120*	46 *150*	50 *165*	55 *180*	35 *115*	44 *145*	49 *160*	55 *180*	28 *90*	34 *110*	38 *125*	42 *140*
S3	32 *105*	40 *130*	45 *150*	50 *165*	31 *100*	38 *125*	43 *140*	47 *155*	24 *80*	30 *100*	33 *110*	37 *120*
S11	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	95 *310*	48 *155*	60 *195*	65 *215*	75 *245*
S12	45 *150*	55 *180*	60 *195*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	33 *110*	41 *135*	47 *155*	50 *165*
S13	26 *85*	32 *105*	36 *120*	40 *130*	25 *80*	31 *100*	34 *110*	38 *125*	19 *60*	24 *80*	27 *90*	29 *95*
H5	39 *130*	49 *160*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
H8	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*
H11	49 *160*	60 *195*	70 *230*	75 *245*	47 *155*	60 *195*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
H12	75 *245*	90 *295*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H21	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*

MM12 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,095 0.0038
P2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
P3	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
P4	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,070 0.0028	0,090 0.0036
P5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
P6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P8	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
P11	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P12	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
M1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
M2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
M3	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
M4	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
M5	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,055 0.0022	0,060 0.0024	0,080 0.0032
K6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,055 0.0022	0,060 0.0024	0,080 0.0032
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
S1	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S2	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S3	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,046 0.0018	0,046 0.0018	0,046 0.0018	0,055 0.0024
S11	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
S12	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
S13	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Finisare – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
P2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
P3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,13 0.0050	0,20 0.0080
P4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
P5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
P6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P8	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,13 0.0050	0,20 0.0080
P11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P12	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
M1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
M2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
M3	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
M4	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
M5	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,080 0.0032	0,11 0.0044	0,18 0.0070
K6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,080 0.0032	0,11 0.0044	0,18 0.0070
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
S1	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
S2	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
S3	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,050 0.0020	0,055 0.0024	0,080 0.0032	0,13 0.0050
S11	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
S12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
S13	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 Z3 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	270 *890*	315 *1025*	335 *1100*	365 *1200*	360 *1175*	255 *840*	300 *980*	320 *1050*	345 *1125*	340 *1125*
P2	265 *870*	305 *1000*	325 *1075*	355 *1175*	350 *1150*	250 *820*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P3	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P4	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*
P5	195 *640*	225 *740*	240 *790*	260 *850*	255 *840*	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*
P6	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*
P7	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*	195 *640*	230 *750*	240 *790*	260 *850*	260 *850*
P8	190 *620*	225 *740*	240 *790*	255 *840*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
P11	200 *660*	235 *770*	245 *800*	265 *870*	265 *870*	190 *620*	220 *720*	235 *770*	255 *840*	255 *840*
P12	125 *410*	150 *490*	155 *510*	170 *560*	165 *540*	120 *395*	140 *460*	145 *490*	160 *520*	160 *520*
M1	210 *690*	245 *800*	265 *870*	285 *940*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
M2	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*	165 *540*	195 *640*	205 *670*	220 *720*	220 *720*
M3	140 *460*	165 *540*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	160 *540*	175 *570*	175 *570*
M4	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M5	80 *260*	110 *360*	110 *375*	115 *375*	115 *375*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
K1	210 *690*	240 *790*	260 *850*	280 *920*	275 *900*	200 *660*	230 *750*	245 *800*	265 *870*	265 *870*
K2	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*
K3	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	180 *590*	200 *660*	195 *640*
K4	150 *490*	175 *570*	180 *590*	200 *660*	195 *640*	140 *460*	165 *540*	175 *570*	190 *620*	185 *610*
K5	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K6	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	145 *475*	155 *510*	165 *540*	165 *540*
K7	115 *375*	135 *445*	140 *460*	155 *510*	155 *510*	110 *360*	125 *410*	135 *445*	145 *475*	145 *475*
N1	1575 *5175*	1825 *6000*	1950 *6400*	2100 *6900*	2100 *6900*	1500 *4925*	1750 *5750*	1850 *6075*	2000 *6550*	2000 *6550*
N2	640 *2100*	740 *2425*	790 *2600*	850 *2800*	840 *2750*	610 *2000*	700 *2300*	750 *2450*	810 *2650*	800 *2625*
N3	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*	405 *1325*	470 *1550*	500 *1650*	540 *1775*	540 *1775*
N11	485 *1600*	560 *1825*	600 *1975*	650 *2125*	640 *2100*	460 *1500*	540 *1775*	570 *1875*	620 *2025*	610 *2000*
S1	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	60 *195*	60 *195*	65 *215*	60 *195*
S2	37 *120*	50 *165*	49 *165*	55 *180*	55 *180*	35 *115*	47 *155*	47 *165*	50 *165*	50 *165*
S3	32 *105*	43 *140*	43 *150*	46 *150*	46 *150*	31 *100*	41 *135*	41 *140*	44 *145*	44 *145*
S11	70 *230*	85 *280*	85 *295*	95 *310*	90 *295*	65 *215*	80 *260*	80 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*	46 *150*	55 *180*	55 *195*	60 *195*	60 *195*
S13	26 *85*	35 *115*	34 *120*	37 *120*	37 *120*	25 *80*	33 *110*	33 *115*	35 *115*	35 *115*
H5	42 *140*	50 *165*	50 *165*	55 *180*	55 *180*	40 *130*	47 *155*	49 *160*	55 *180*	55 *180*
H8	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H11	55 *180*	65 *215*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	75 *245*	90 *295*	90 *310*	100 *330*	100 *330*
H21	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*

MM12 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Degroșare – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 0.0030	0,080 0.0032	0,090 0.0036	0,12 0.0048
P2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
P3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P4	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
P6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P8	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P11	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P12	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
M1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
M2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
M3	MM12-12012-B90S-E05 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
M4	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
M5	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
K1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
K2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K4	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,10 0.0040
K6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,10 0.0040
N1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N11	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
S1	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
S2	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
S3	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,050 0.0020	0,050 0.0020	0,055 0.0022	0,070 0.0030
S11	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
S12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
S13	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
H5	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
H8	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024
H11	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
H12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024
H21	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
P3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P8	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P12	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
M2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
M3	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
M4	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
M5	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
K1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
K2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
K6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
N1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
S2	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
S3	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
S12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
S13	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
H5	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
H11	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
H21	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 Z2 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	310 *1025*	390 *1275*	410 *1350*	445 *1450*	440 *1450*	240 *790*	300 *980*	325 *1075*	350 *1150*	345 *1125*	195 *640*	240 *790*	265 *870*	285 *940*	280 *920*
P2	300 *980*	380 *1250*	400 *1300*	430 *1400*	430 *1400*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	275 *900*
P3	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	205 *670*	225 *740*	240 *790*	240 *790*
P4	230 *750*	290 *950*	305 *1000*	325 *1075*	330 *1075*	175 *570*	225 *740*	245 *800*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P5	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*	140 *460*	170 *560*	190 *620*	205 *670*	200 *660*
P6	245 *800*	310 *1025*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	260 *850*	285 *940*	280 *920*	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*
P7	230 *750*	295 *970*	310 *1025*	335 *1100*	335 *1100*	180 *590*	230 *750*	245 *800*	270 *890*	265 *870*	145 *475*	185 *610*	200 *660*	215 *710*	215 *710*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*	135 *445*	170 *560*	190 *620*	200 *660*	200 *660*
P11	225 *740*	285 *940*	300 *980*	325 *1075*	325 *1075*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*
P12	140 *460*	180 *590*	180 *610*	195 *640*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	160 *520*	95 *310*	120 *395*	120 *410*	135 *445*	130 *425*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	225 *740*	220 *720*
M2	195 *640*	250 *820*	260 *850*	285 *940*	285 *940*	155 *510*	190 *620*	210 *690*	225 *740*	225 *740*	125 *410*	155 *510*	170 *560*	185 *610*	180 *590*
M3	155 *510*	200 *660*	205 *670*	220 *720*	220 *720*	125 *410*	160 *520*	165 *560*	180 *590*	180 *590*	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*
M4	120 *395*	155 *510*	155 *540*	165 *540*	165 *540*	100 *330*	130 *425*	130 *445*	135 *445*	140 *460*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	105 *375*	115 *375*	115 *375*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	340 *1125*	340 *1125*	180 *590*	230 *750*	250 *820*	270 *890*	270 *890*	145 *475*	185 *610*	205 *670*	220 *720*	215 *710*
K2	205 *670*	265 *870*	275 *900*	300 *980*	300 *980*	160 *520*	200 *660*	220 *720*	240 *790*	235 *770*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*
K3	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	135 *445*	170 *560*	185 *610*	205 *670*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*
K4	165 *540*	215 *710*	225 *740*	240 *790*	240 *790*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*	105 *345*	130 *425*	145 *475*	155 *510*	155 *510*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	80 *260*	100 *330*	110 *360*	115 *375*	115 *375*	65 *215*	80 *260*	85 *280*	95 *310*	95 *310*
K6	145 *475*	185 *610*	195 *640*	215 *710*	215 *710*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	135 *445*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	100 *330*	125 *410*	140 *460*	150 *490*	150 *490*	80 *260*	105 *345*	110 *360*	120 *395*	120 *395*
N1	1825 *6000*	2300 *7550*	2425 *7950*	2625 *8600*	2600 *8525*	1375 *4500*	1725 *5650*	1900 *6225*	2025 *6650*	2000 *6550*	1100 *3600*	1400 *4600*	1525 *5000*	1650 *5425*	1625 *5325*
N2	730 *2400*	930 *3050*	980 *3225*	1050 *3450*	1050 *3450*	550 *1800*	690 *2275*	760 *2500*	820 *2700*	810 *2650*	450 *1475*	560 *1825*	620 *2025*	660 *2175*	660 *2175*
N3	490 *1600*	620 *2025*	650 *2125*	710 *2325*	700 *2300*	370 *1225*	465 *1525*	510 *1675*	550 *1800*	540 *1775*	300 *980*	375 *1225*	410 *1350*	440 *1450*	440 *1450*
N11	560 *1825*	710 *2325*	750 *2450*	810 *2650*	800 *2625*	425 *1400*	530 *1750*	580 *1900*	620 *2025*	620 *2025*	340 *1125*	430 *1400*	470 *1550*	500 *1650*	500 *1650*
S1	55 *180*	70 *230*	70 *260*	80 *260*	80 *260*	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
S2	45 *150*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	39 *130*	39 *135*	42 *140*	42 *140*
S3	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	43 *140*	42 *145*	45 *150*	45 *150*	27 *90*	34 *110*	34 *120*	37 *120*	36 *120*
S11	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	45 *150*	60 *195*	60 *195*	65 *215*	60 *195*	37 *120*	47 *155*	47 *160*	50 *165*	50 *165*
S13	32 *105*	41 *135*	40 *145*	44 *145*	44 *145*	26 *85*	34 *110*	34 *120*	36 *120*	36 *120*	21 *70*	28 *90*	27 *95*	29 *95*	29 *95*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	50 *165*	55 *180*	55 *180*	31 *100*	39 *130*	41 *135*	44 *145*	44 *145*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*

MM12 Avans mare Alegerea plăcuţei – Metric/ Inci

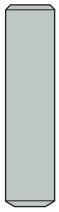
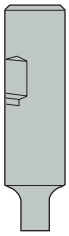
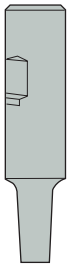
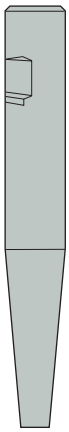
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,75 0.030	0,95 0.038
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
P6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P8	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P12	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
M1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
M2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
M3	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
M4	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
M5	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
K1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
K2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 0.019	0,48 0.019	0,60 0.024	0,75 0.030
K6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 0.019	0,48 0.019	0,60 0.024	0,75 0.030
N1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
S1	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
S2	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
S3	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,34 0.013	0,34 0.013	0,44 0.017	0,55 0.022
S11	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
S12	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
S13	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
H5	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
H8	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017
H11	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
H12	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017
H21	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM12 Avans mare Regimuri de așchiere v_c = (m/min)/(sf/min)

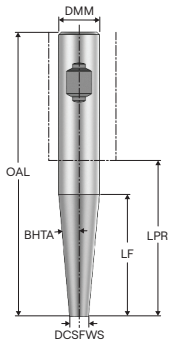
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	225	275	315	330
	—	—	—	—	*740*	*900*	*1025*	*1075*
P2	—	—	—	—	220	265	310	320
	—	—	—	—	*720*	*870*	*1025*	*1050*
P3	—	—	—	—	190	230	270	280
	—	—	—	—	*620*	*750*	*890*	*920*
P4	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P5	—	—	—	—	165	195	225	240
	—	—	—	—	*540*	*640*	*740*	*790*
P6	—	—	—	—	185	225	255	270
	—	—	—	—	*610*	*740*	*840*	*890*
P7	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P8	—	—	—	—	160	195	225	235
	—	—	—	—	*520*	*640*	*740*	*770*
P11	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P12	—	—	—	—	110	130	150	160
	—	—	—	—	*360*	*425*	*490*	*520*
M1	—	—	—	—	175	215	250	260
	—	—	—	—	*570*	*710*	*820*	*850*
M2	—	—	—	—	145	175	205	215
	—	—	—	—	*475*	*570*	*670*	*710*
M3	—	—	—	—	120	140	165	175
	—	—	—	—	*395*	*460*	*540*	*570*
M4	—	—	—	—	95	110	125	130
	—	—	—	—	*310*	*360*	*410*	*425*
M5	—	—	—	—	80	90	105	110
	—	—	—	—	*260*	*295*	*345*	*360*
K1	185	225	260	275	175	210	245	255
	610	*740*	*850*	*900*	*570*	*690*	*800*	*840*
K2	165	200	230	245	155	185	215	225
	540	*660*	*750*	*800*	*510*	*610*	*710*	*740*
K3	140	170	195	205	130	155	180	190
	460	*560*	*640*	*670*	*425*	*510*	*590*	*620*
K4	135	160	185	195	125	150	175	185
	445	*520*	*610*	*640*	*410*	*490*	*570*	*610*
K5	80	100	115	120	75	90	105	110
	260	*330*	*375*	*395*	*245*	*295*	*345*	*360*
K6	120	140	165	175	110	130	155	160
	395	*460*	*540*	*570*	*360*	*425*	*510*	*520*
K7	105	125	145	155	95	115	135	145
	345	*410*	*475*	*510*	*310*	*375*	*445*	*475*
N1	—	—	—	—	1275	1575	1800	1875
	—	—	—	—	*4175*	*5175*	*5900*	*6150*
N2	—	—	—	—	520	630	730	750
	—	—	—	—	*1700*	*2075*	*2400*	*2450*
N3	—	—	—	—	345	420	485	500
	—	—	—	—	*1125*	*1375*	*1600*	*1650*
N11	—	—	—	—	395	480	550	570
	—	—	—	—	*1300*	*1575*	*1800*	*1875*
S1	—	—	—	—	44	50	60	60
	—	—	—	—	*145*	*165*	*195*	*195*
S2	—	—	—	—	35	41	47	50
	—	—	—	—	*115*	*135*	*155*	*165*
S3	—	—	—	—	31	36	42	44
	—	—	—	—	*100*	*120*	*140*	*145*
S11	—	—	—	—	60	70	85	90
	—	—	—	—	*195*	*230*	*280*	*295*
S12	—	—	—	—	42	50	55	60
	—	—	—	—	*140*	*165*	*180*	*195*
S13	—	—	—	—	25	29	33	35
	—	—	—	—	*80*	*95*	*110*	*115*
H5	39	46	55	55	36	43	50	55
	130	*150*	*180*	*180*	*120*	*140*	*165*	*180*
H8	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*
H11	49	60	70	70	46	55	65	65
	160	*195*	*230*	*230*	*150*	*180*	*215*	*215*
H12	75	90	100	105	70	80	95	100
	245	*295*	*330*	*345*	*230*	*260*	*310*	*330*
H21	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*

Design coadă

Design 1, Coadă cheie	Design 2, Parte dorsală cilindrică/Weldon şi 90º în faţă
	
Design 3, Parte dorsală cilindrică/Weldon parte frontală conică 87º/89º	**Design 4, Parte dorsală cilindrică/Weldon parte frontală conică 80º/85º/87º**
	
Design 5, Parte dorsală cilindrică parte frontală conică dublă 89º/85º	
	

MM16 Coadă





Reper Nr.	Număr reper	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		mm	mm	mm	mm	mm						kg	
MM16-16070.0-0011M	00023547	15,2	16,0	11,3	22,0	70,0	0,0	2	■	63600	Cylindrical	0,1	1
MM16-16150.0-0080DS	02580692	15,2	16,0	80,0	102,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,4	2
MM16-20115.3-3045	75014109	15,2	20,0	45,8	65,0	115,0	3,0	4	■	63600	Weldon	0,2	3
MM16-20070.0-0000	00023548	15,2	20,0	0,0	20,0	70,0	60,0	1	■	63600	Cylindrical	0,2	1
MM16-20190.0-1055M	00094766	15,2	20,0	55,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1075M	00094768	15,2	20,0	75,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1095M	00094770	15,2	20,0	95,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	6
MM16-20080.0-0011DS	02580669	15,2	20,0	11,3	30,0	80,0	0,0	2	■	47600	Cylindrical Densimet	0,3	2
MM16-20150.0-0038DS	02580695	15,2	20,0	38,0	100,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20160.0-0076DS	02580699	15,2	20,0	76,0	110,0	160,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20130.0-1045DS	02580757	15,2	20,0	45,0	80,0	130,0	1,0	3	■	47600	Cylindrical Densimet	0,5	2
MM16-20190.0-1075DS	02580758	15,2	20,0	75,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-20190.0-1095DS	02580760	15,2	20,0	95,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-25100.3-0019	75012790	15,2	25,0	19,0	40,0	100,0	0,0	2	■	63600	Weldon	0,3	3
MM16-25115.3-3035	75012791	15,2	25,0	35,0	59,0	115,0	3,0	3	■	63600	Weldon	0,3	3
MM16-25170.3-5056	75012792	15,2	25,0	56,0	114,0	170,0	5,0	4	■	63600	Weldon	0,6	4
MM16-25170.0-1060	00094767	19,0	25,0	60,0	114,0	170,0	1,0	3	■	63600	Cylindrical	0,5	5
MM16-25250.0-1075DS	02580761	15,2	25,0	75,0	194,0	250,0	1,0	5	■	47600	Cylindrical Densimet	1,5	2
MM16-32250.0-10047	75069368	15,2	32,0	47,6	190,0	250,0	10,0	4	■	63600	Cylindrical	1,3	4

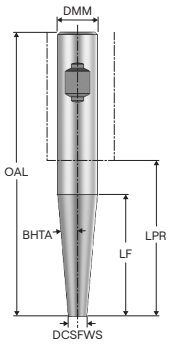
Piese de schimb, Piese incluse la livrare

Pentru freza	Manșon	Șurub tensiune
		
1	MM-10030	MM16-1045
2	–	MM16-1045
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113

Cheia Allen H05-4 pentru manșoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

MM16 Coadă – inci





Reper Nr.	Număr reper	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Varianta	CSP	RPMX	Coada	Greutate	Piesă de schimb nr.
		inci	inci	inci	inci	inci						lbs	
MM16-0.62-2.8-0M-0004	00037209	0.598	0.625	0.445	0.866	2.756	0,0	2	■	63600	Cylindrical	0.220	1
MM16-0.75-4.5-3-3018	75054603	0.598	0.750	1.445	2.559	4.528	3,0	3	■	63600	Weldon	0.440	4
MM16-0.75-2.8-0-0000	00037175	0.598	0.750	0	0.787	2.756	60,0	1	■	63600	Cylindrical	0.440	1
MM16-0.75-7.5-0-1021	75054731	0.598	0.750	2.165	5.512	7.480	1,0	3	■	63600	Cylindrical	0.660	6
MM16-0.75-7.5-0-1037	75054733	0.598	0.750	3.740	5.512	7.480	1,0	3	■	63600	Cylindrical	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	0.598	0.750	2.953	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	0.598	0.750	3.740	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.540	3
MM16-1.00-3.9-3-0007	75015058	0.598	1.000	0.748	1.732	3.937	0,0	2	■	63600	Weldon	0.660	4
MM16-1.00-4.5-3-3013	75015059	0.598	1.000	1.378	2.323	4.528	3,0	3	■	63600	Weldon	0.880	4
MM16-1.00-6.7-3-5022	75015060	0.598	1.000	2.295	4.488	6.693	5,0	4	■	63600	Weldon	1.320	5
MM16-1.00-5.9-0-0015DS	02593433	0.598	1.000	1.496	3.701	5.906	0,0	2	■	47600	Cylindrical Densimet	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	0.598	1.000	2.992	4.094	6.299	0,0	2	■	47600	Cylindrical Densimet	1.980	3

Piese de schimb, Piese incluse la livrare

Pentru freza	Manşon	Şurub tensiune
		
1	MM-10030	MM16-1045
3	–	MM16-1045
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113

Cheia Allen H05-4 pentru manşoane se comandă separat.
Pentru tipurile de chei, consultaţi paginile de plăcuţe

Frezare de canal/frezare în unghi drept

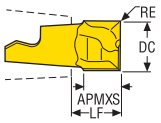


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

												Calităţi			
Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta		Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*								T60M	F15M	F30M	F40M
MM16-15719-R03A30-M06	15,7 *0.618*	19,05 *0.750*	0,3 *0.012*	24,5 *0.965*	15,0	19,0	30,6	30	3	MM0416	✓				■
MM16-15919-R08A30-M06	15,875 *0.625*	19,05 *0.750*	0,8 *0.031*	24,5 *0.965*	15,0	19,2	29,9	30	3	MM0416	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	–	24,5 *0.965*	15,0	19,4	31,8	30	3	MM0416	✓			■	
MM16-16019-R05A30-M06	16,0 *0.630*	19,05 *0.750*	0,5 *0.020*	24,5 *0.965*	15,0	19,4	30,8	30	3	MM0416	✓				■
MM16-16019-R10A30-E06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓			■	
MM16-16019-R10A30-M06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓				■
MM16-16019-R20A30-M06	16,0 *0.630*	19,05 *0.750*	2,0 *0.079*	24,5 *0.965*	15,0	19,4	27,8	30	3	MM0416	✓				■
MM16-16019-R30A30-E06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓			■	
MM16-16019-R30A30-M06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓				■
MM16-16019-R40A30-M06	16,0 *0.630*	19,05 *0.750*	4,0 *0.157*	24,5 *0.965*	15,0	19,4	23,8	30	3	MM0416	✓				■
MM16-16019-R50A30-M06	16,0 *0.630*	19,05 *0.750*	5,0 *0.197*	24,5 *0.965*	15,0	19,4	21,8	30	3	MM0416	✓				■
MM16-16019-R60A30-M06	16,0 *0.630*	19,05 *0.750*	6,0 *0.236*	24,5 *0.965*	15,0	19,4	19,8	30	3	MM0416	✓				■
MM16-20015-A30-E06	20,0 *0.787*	15,0 *0.591*	–	20,15 *0.793*	15,0	24,2	39,8	30	3	MM0416	✓			■	
MM16-20015-R05A30-M06	20,0 *0.787*	15,0 *0.591*	0,5 *0.020*	20,15 *0.793*	15,0	24,2	38,8	30	3	MM0416	✓				■
MM16-20015-R10A30-M06	20,0 *0.787*	15,0 *0.591*	1,0 *0.039*	20,15 *0.793*	15,0	24,2	37,8	30	3	MM0416	✓				■
MM16-20015-R20A30-D06	20,0 *0.787*	15,0 *0.591*	2,0 *0.079*	20,15 *0.793*	15,0	24,2	35,8	30	3	MM0416	✓			■	
MM16-20015-R30A30-M06	20,0 *0.787*	15,0 *0.591*	3,0 *0.118*	20,15 *0.793*	15,0	24,2	33,8	30	3	MM0416	✓				■
MM16-20015-R50A30-M06	20,0 *0.787*	15,0 *0.591*	5,0 *0.197*	20,15 *0.793*	15,0	24,2	29,8	30	3	MM0416	✓				■

Frezare de canal/frezare în unghi drept



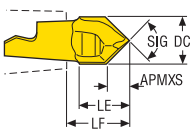


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Varianta	Calităţi / Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*							T60M	F15M	F30M	F40M
MM16-15711T-R03-D07	15,7 *0.618*	11,0 *0.433*	0,3 *0.012*	13,6 *0.535*	15,0	19,0	30,6	0	2	MM1420	■			
MM16-16011-M06	16,0 *0.630*	11,0 *0.433*	–	13,6 *0.535*	15,0	19,4	31,8	0	2	MM1420	■			
MM16-16011-R08A8-E06	16,0 *0.630*	10,5 *0.413*	0,8 *0.031*	13,62 *0.536*	15,0	19,4	30,2	8	2	MM1420	■		■	
MM16-16011-R08-MD07	16,0 *0.630*	11,0 *0.433*	0,8 *0.031*	13,58 *0.535*	15,0	19,4	30,2	0	2	MM1420	■		■	
MM16-16011-R08P-M05	16,0 *0.630*	10,8 *0.425*	0,8 *0.031*	13,41 *0.528*	15,0	19,4	30,2	0	2	MM1420			■	
MM16-16011-R20-MD07	16,0 *0.630*	10,9 *0.429*	2,0 *0.079*	13,55 *0.533*	15,0	19,4	27,8	0	2	MM1420			■	
MM16-16011-R30-MD07	16,0 *0.630*	10,9 *0.429*	3,0 *0.118*	13,54 *0.533*	15,0	19,4	25,8	0	2	MM1420			■	
MM16-16011-R40-MD07	16,0 *0.630*	10,9 *0.429*	4,0 *0.157*	13,52 *0.532*	15,0	19,4	23,8	0	2	MM1420	■			
MM16-16011-R50-MD07	16,0 *0.630*	10,9 *0.429*	5,0 *0.197*	13,5 *0.531*	15,0	19,4	21,8	0	2	MM1420	■			
MM16-19013-R08A8-E06	19,05 *0.750*	12,7 *0.500*	0,8 *0.031*	15,39 *0.606*	15,0	23,1	36,3	8	2	MM1420			■	
MM16-20013-R08A8-E06	20,0 *0.787*	12,7 *0.500*	0,8 *0.031*	15,42 *0.607*	15,0	24,2	38,2	8	2	MM1420	■		■	

Frezare centrală



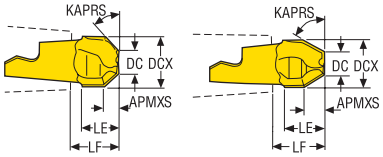


—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	SIG°	ZEFP	Varianta	Calităţi / Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM16-16008-C90-M06	16,0 *0.630*	7,53 *0.296*	– –	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	– –	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	– –	22,15 *0.872*	90,0	2	MM1420	■			

Șanfrenare



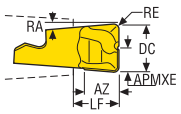


—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

										Calităţi			
Reper Nr.	**DCX**	**DC**	**APMXS**	**RE**	**LE**	**LF**	**KAPRS°**	**ZEFP**	**Varianta**	**Acoperită**			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM16-16011-4540-E06	16,0 *0.630*	7,69 *0.303*	3,9 *0.154*	0,4 *0.016*	10,9 *0.429*	13,25 *0.522*	45,0	2	MM1420	■			
MM16-16012-6060-E06	16,0 *0.630*	8,38 *0.330*	6,7 *0.264*	0,5 *0.020*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

Frezare axială

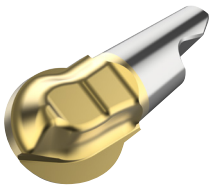




—Pentru cheile dinamometrice și valorile de cuplu, consultaţi pagina 799

									Calităţi			
Reper Nr.	**DC**	**APMXE**	**RE**	**AZ**	**LF**	**RA°**	**ZEFP**	**Varianta**	**Acoperită**			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM16-16011-R10-PL-MD07	16,0 *0.630*	8,0 *0.315*	1,0 *0.039*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	
MM16-16011-R20-PL-MD07	16,0 *0.630*	8,0 *0.315*	2,0 *0.079*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	

Plăcuţe de precizie pentru semifinisare în toate materialele



—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Varianta	Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				T60M	F15M	F30M	F40M
MM16-20020-B120PF-M04	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420			■	

Frezare prin copiere



—Pentru cheile dinamometrice şi valorile de cuplu, consultaţi pagina 799

Reper Nr.	DC	APMXS	RE	LF	FHA	ZEFP	Varianta		Calităţi Acoperită			
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*					T60M	F15M	F30M	F40M
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*		2	MM1420				■	
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*		2	MM1420		■		■	
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		2	MM1420			■		
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		2	MM1420				■	
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓			■	
MM16-16019-B90A30-M06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓				■
MM16-19020-B90P-M07	19,05 *0.750*	17,4 *0.685*	9,525 *0.375*	22,12 *0.871*		2	MM1420		■			
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓			■	
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓				■
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*		2	MM1420		■		■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*		2	MM1420				■	

MM16 - Frezare laterală și canelare – Alegerea plăcuțelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,085 0.0034	0,11 0.0044	0,14 0.0055
P2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,090 0.0036	0,11 0.0044	0,14 0.0055
P3	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,085 0.0034	0,10 0.0040	0,14 0.0055
P4	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
P5	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
P6	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P7	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P8	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,085 0.0034	0,10 0.0040	0,14 0.0055
P11	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
M1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,090 0.0036	0,11 0.0044	0,14 0.0055
M2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
M3	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
M4	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
M5	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
K1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
K2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K4	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K5	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 0.0030	0,075 0.0030	0,090 0.0036	0,12 0.0048
K6	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K7	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 0.0030	0,075 0.0030	0,090 0.0036	0,12 0.0048
N1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N11	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
S1	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
S2	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
S3	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
S11	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
S12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
S13	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
H5	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
H8	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
H11	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
H12	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
H21	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM16 - Frezare laterală și canelare – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	230 *750*	285 *940*	315 *1025*	350 *1150*	215 *710*	270 *890*	300 *980*	335 *1100*	200 *660*	250 *820*	275 *900*	310 *1025*
P2	220 *720*	275 *900*	310 *1025*	345 *1125*	210 *690*	260 *850*	290 *950*	325 *1075*	195 *640*	240 *790*	270 *890*	295 *970*
P3	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	225 *740*	255 *840*	280 *920*	170 *560*	210 *690*	235 *770*	260 *850*
P4	170 *560*	215 *710*	240 *790*	265 *870*	160 *520*	205 *670*	225 *740*	250 *820*	150 *490*	185 *610*	205 *670*	225 *740*
P5	165 *540*	205 *670*	230 *750*	250 *820*	155 *510*	195 *640*	215 *710*	240 *790*	140 *460*	175 *570*	200 *660*	220 *720*
P6	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	215 *710*	245 *800*	270 *890*	160 *520*	200 *660*	220 *720*	245 *800*
P7	175 *570*	220 *720*	245 *800*	265 *870*	165 *540*	205 *670*	230 *750*	255 *840*	150 *490*	190 *620*	210 *690*	235 *770*
P8	160 *520*	205 *670*	230 *750*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	140 *460*	175 *570*	200 *660*	215 *710*
P11	170 *560*	210 *690*	235 *770*	260 *850*	160 *520*	200 *660*	225 *740*	245 *800*	145 *475*	185 *610*	205 *670*	225 *740*
P12	110 *360*	135 *445*	150 *490*	165 *540*	105 *345*	130 *425*	145 *475*	155 *510*	95 *310*	120 *395*	130 *425*	145 *475*
M1	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	155 *510*	190 *620*	215 *710*	240 *790*
M2	150 *490*	185 *610*	205 *670*	225 *740*	140 *460*	175 *570*	195 *640*	215 *710*	125 *410*	160 *520*	180 *590*	200 *660*
M3	120 *395*	150 *490*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	175 *570*	105 *345*	130 *425*	145 *475*	155 *510*
M4	90 *295*	115 *375*	130 *425*	140 *460*	85 *280*	110 *360*	120 *395*	135 *445*	80 *260*	100 *330*	110 *360*	120 *395*
M5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	85 *280*	95 *310*	100 *330*
K1	175 *570*	220 *720*	245 *800*	270 *890*	165 *540*	205 *670*	230 *750*	260 *850*	150 *490*	190 *620*	210 *690*	235 *770*
K2	155 *510*	195 *640*	215 *710*	240 *790*	145 *475*	185 *610*	205 *670*	225 *740*	135 *445*	170 *560*	190 *620*	210 *690*
K3	130 *425*	165 *540*	185 *610*	205 *670*	125 *410*	155 *510*	175 *570*	190 *620*	115 *375*	145 *475*	160 *520*	175 *570*
K4	125 *410*	160 *520*	175 *570*	195 *640*	120 *395*	150 *490*	165 *540*	185 *610*	110 *360*	135 *445*	150 *490*	170 *560*
K5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	80 *260*	95 *310*	100 *330*
K6	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	130 *425*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	150 *490*
K7	100 *330*	120 *395*	135 *445*	150 *490*	95 *310*	115 *375*	130 *425*	140 *460*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1325 *4350*	1650 *5425*	1825 *6000*	2025 *6650*	1225 *4025*	1550 *5075*	1725 *5650*	1925 *6325*	1125 *3700*	1425 *4675*	1575 *5175*	1750 *5750*
N2	530 *1750*	670 *2200*	730 *2400*	820 *2700*	500 *1650*	630 *2075*	690 *2275*	770 *2525*	455 *1500*	570 *1875*	640 *2100*	700 *2300*
N3	355 *1175*	445 *1450*	490 *1600*	540 *1775*	335 *1100*	420 *1375*	465 *1525*	520 *1700*	305 *1000*	385 *1275*	425 *1400*	470 *1550*
N11	405 *1325*	510 *1675*	560 *1825*	620 *2025*	380 *1250*	475 *1550*	530 *1750*	590 *1925*	345 *1125*	435 *1425*	485 *1600*	540 *1775*
S1	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	38 *125*	46 *150*	50 *165*	55 *180*
S2	35 *115*	43 *140*	48 *155*	55 *180*	33 *110*	41 *135*	45 *150*	50 *165*	30 *100*	37 *120*	42 *140*	46 *150*
S3	30 *100*	38 *125*	42 *140*	46 *150*	29 *95*	35 *115*	40 *130*	44 *145*	27 *90*	33 *110*	37 *120*	40 *130*
S11	60 *195*	75 *245*	85 *280*	90 *295*	55 *180*	70 *230*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*	80 *260*
S12	42 *140*	50 *165*	60 *195*	65 *215*	39 *130*	49 *160*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*
S13	24 *80*	30 *100*	34 *110*	37 *120*	23 *75*	29 *95*	32 *105*	35 *115*	21 *70*	26 *85*	29 *95*	32 *105*
H5	36 *120*	45 *150*	50 *165*	55 *180*	34 *110*	43 *140*	48 *155*	50 *165*	31 *100*	39 *130*	44 *145*	48 *155*
H8	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*
H11	46 *150*	60 *195*	65 *215*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*
H12	70 *230*	85 *280*	95 *310*	105 *345*	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	90 *295*
H21	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*

MM16 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,14 0.0055
P2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
P3	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,10 0.0040	0,10 0.0040	0,14 0.0055
P4	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
P5	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
P6	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P7	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P8	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,10 0.0040	0,10 0.0040	0,14 0.0055
P11	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
M1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
M2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
M3	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,080 0.0032	0,11 0.0044
M4	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
M5	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,085 0.0034	0,090 0.0036	0,12 0.0048
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,085 0.0034	0,090 0.0036	0,12 0.0048
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
S1	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
S2	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
S3	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,085 0.0036
S11	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,085 0.0034	0,11 0.0044
S12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,085 0.0034	0,11 0.0044
S13	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM16 Z3 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,20 0.0080	0,32 0.013
P2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
P3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,19 0.0075	0,32 0.013
P4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,19 0.0075	0,30 0.012
P5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P8	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,19 0.0075	0,32 0.013
P11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
M1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
M2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
M3	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
M4	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
M5	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,26 0.010
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,26 0.010
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
S1	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
S2	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
S3	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,075 0.0030	0,085 0.0036	0,12 0.0048	0,19 0.0075
S11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
S12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
S13	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM16 Z3 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	245 *800*	295 *970*	310 *1025*	335 *1100*	335 *1100*	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*
P2	240 *790*	285 *940*	300 *980*	325 *1075*	320 *1050*	230 *750*	270 *890*	285 *940*	310 *1025*	305 *1000*
P3	210 *690*	250 *820*	260 *850*	285 *940*	280 *920*	200 *660*	240 *790*	250 *820*	270 *890*	265 *870*
P4	185 *610*	220 *720*	235 *770*	250 *820*	250 *820*	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*
P5	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*	170 *560*	200 *660*	215 *710*	230 *750*	230 *750*
P6	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P7	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	240 *790*
P8	175 *570*	210 *690*	220 *720*	240 *790*	235 *770*	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*
P11	185 *610*	215 *710*	230 *750*	250 *820*	245 *800*	175 *570*	205 *670*	220 *720*	235 *770*	235 *770*
P12	115 *375*	145 *475*	145 *475*	160 *520*	155 *510*	110 *360*	140 *460*	140 *460*	150 *490*	150 *490*
M1	195 *640*	230 *750*	240 *790*	265 *870*	260 *850*	185 *610*	220 *720*	230 *750*	250 *820*	245 *800*
M2	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	150 *490*	180 *590*	190 *620*	205 *670*	205 *670*
M3	130 *425*	160 *520*	160 *520*	170 *560*	170 *560*	120 *395*	150 *490*	150 *490*	165 *540*	165 *540*
M4	90 *295*	125 *410*	125 *425*	130 *425*	135 *445*	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*
M5	75 *245*	105 *345*	100 *360*	110 *360*	110 *360*	70 *230*	100 *330*	100 *345*	105 *345*	105 *345*
K1	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K2	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*
K3	140 *460*	170 *560*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K4	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	165 *540*	175 *570*	175 *570*
K5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*
K6	120 *395*	140 *460*	150 *490*	165 *540*	160 *520*	115 *375*	135 *445*	145 *475*	155 *510*	155 *510*
K7	105 *345*	125 *410*	130 *425*	145 *475*	145 *475*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
N1	1425 *4675*	1700 *5575*	1775 *5825*	1925 *6325*	1900 *6225*	1350 *4425*	1625 *5325*	1700 *5575*	1850 *6075*	1800 *5900*
N2	580 *1900*	690 *2275*	720 *2350*	780 *2550*	770 *2525*	550 *1800*	650 *2125*	680 *2225*	740 *2425*	730 *2400*
N3	385 *1275*	455 *1500*	480 *1575*	520 *1700*	510 *1675*	365 *1200*	435 *1425*	455 *1500*	495 *1625*	485 *1600*
N11	440 *1450*	520 *1700*	550 *1800*	600 *1975*	580 *1900*	420 *1375*	495 *1625*	520 *1700*	570 *1875*	560 *1825*
S1	42 *140*	60 *195*	55 *195*	60 *195*	60 *195*	40 *130*	55 *180*	55 *195*	60 *195*	60 *195*
S2	34 *110*	48 *155*	46 *160*	50 *165*	50 *165*	33 *110*	45 *150*	44 *155*	47 *155*	48 *155*
S3	30 *100*	41 *135*	40 *140*	43 *140*	43 *140*	28 *90*	39 *130*	38 *135*	41 *135*	41 *135*
S11	65 *215*	80 *260*	80 *280*	85 *280*	85 *280*	60 *195*	80 *260*	75 *260*	85 *280*	80 *260*
S12	45 *150*	55 *180*	55 *195*	60 *195*	60 *195*	43 *140*	55 *180*	55 *180*	55 *180*	55 *180*
S13	24 *80*	33 *110*	32 *110*	35 *115*	35 *115*	23 *75*	32 *105*	31 *110*	33 *110*	33 *110*
H5	39 *130*	48 *155*	48 *160*	55 *180*	50 *165*	37 *120*	46 *150*	46 *150*	50 *165*	50 *165*
H8	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
H11	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
H21	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*

MM16 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Metric/ Inci

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
P2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
P3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,10 0.0040	0,12 0.0048	0,16 0.0065
P4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,16 0.0065
P5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P8	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,10 0.0040	0,12 0.0048	0,16 0.0065
P11	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P12	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
M1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
M2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
M3	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,085 0.0034	0,080 0.0032	0,095 0.0038	0,12 0.0050
M4	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
M5	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
K1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
K2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
K6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
S2	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
S3	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0040
S11	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 0.0034	0,085 0.0034	0,095 0.0038	0,12 0.0050
S12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 0.0034	0,085 0.0034	0,095 0.0038	0,12 0.0050
S13	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
H5	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
H8	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
H11	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
H12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
H21	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM16 Z2 – Frezare prin copiere – Alegerea plăcuţelor – Finisare – mm/Inci

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
P3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,070 0.0028	0,095 0.0038	0,15 0.0060
P5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P8	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P12	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
M1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
M2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
K2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,13 0.0050
K6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,13 0.0050
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
S1	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
S11	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
H8	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030
H11	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
H12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030
H21	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030

SMG = grup material Seco
f_z = mm/dinte (in/dinte), v_c = m/min (sf/min), a_e/DC = %
Toate regimurile de așchiere sunt valori de început

MM16 Z2 – Frezare prin copiere – Regimuri de așchiere v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	285 940	360 1175	390 1275	420 1375	415 1350	225 740	280 920	300 980	325 1075	325 1075	185 610	225 740	245 800	265 870	265 870
P2	275 900	350 1150	375 1225	405 1325	405 1325	220 720	270 890	295 970	315 1025	315 1025	180 590	220 720	240 790	255 840	255 840
P3	240 790	305 1000	325 1075	355 1175	355 1175	190 620	240 790	255 840	280 920	275 900	155 510	195 640	210 690	225 740	225 740
P4	215 710	270 890	285 940	310 1025	310 1025	170 560	210 690	225 740	245 800	245 800	140 460	170 560	185 610	200 660	195 640
P5	205 670	255 840	275 900	300 980	295 970	165 540	200 660	220 720	235 770	230 750	130 425	160 520	175 570	190 620	190 620
P6	230 750	290 950	310 1025	335 1100	335 1100	180 590	225 740	245 800	265 870	265 870	150 490	180 590	200 660	215 710	215 710
P7	215 710	275 900	290 950	315 1025	315 1025	170 560	210 690	230 750	250 820	250 820	140 460	170 560	190 620	200 660	200 660
P8	200 660	255 840	275 900	295 970	295 970	160 520	200 660	215 710	235 770	230 750	130 425	160 520	175 570	190 620	190 620
P11	210 690	265 870	285 940	310 1025	310 1025	165 540	205 670	225 740	240 790	240 790	135 445	165 540	180 590	195 640	195 640
P12	135 445	175 570	175 590	190 620	190 620	110 360	140 460	145 475	155 510	155 510	90 295	110 360	115 375	125 410	125 410
M1	225 740	285 940	300 980	330 1075	325 1075	175 570	220 720	235 770	255 840	250 820	145 475	180 590	190 620	205 670	205 670
M2	185 610	230 750	250 820	270 890	265 870	145 475	180 590	195 640	210 690	210 690	120 395	145 475	160 520	170 560	170 560
M3	150 490	190 620	195 660	210 690	210 690	120 395	150 490	155 520	170 560	170 560	95 310	125 410	125 425	135 445	135 445
M4	115 375	150 490	150 520	160 520	160 520	95 310	125 410	120 425	130 425	130 425	75 245	100 330	95 345	105 345	105 345
M5	95 310	125 410	125 445	135 445	135 445	80 260	100 330	100 345	110 360	110 360	65 215	85 280	80 280	90 295	85 280
K1	220 720	280 920	295 970	320 1050	320 1050	175 570	215 710	235 770	250 820	250 820	140 460	175 570	190 620	205 670	200 660
K2	195 640	245 800	260 850	285 940	280 920	155 510	190 620	210 690	220 720	220 720	125 410	155 510	170 560	180 590	180 590
K3	165 540	205 670	220 720	240 790	240 790	130 425	160 520	175 570	190 620	185 610	105 345	130 425	140 460	150 490	150 490
K4	155 510	195 640	210 690	230 750	225 740	125 410	155 510	170 560	180 590	180 590	100 330	125 410	135 445	145 475	145 475
K5	95 310	120 395	125 410	135 445	140 460	75 245	95 310	100 330	110 360	110 360	60 195	75 245	80 260	90 295	90 295
K6	135 445	175 570	185 610	200 660	200 660	110 360	135 445	150 490	160 520	155 510	90 295	110 360	120 395	130 425	125 410
K7	120 395	150 490	165 540	175 570	175 570	95 310	120 395	130 425	140 460	140 460	80 260	95 310	105 345	115 375	115 375
N1	1675 5500	2125 6975	2250 7375	2450 8050	2450 8050	1300 4275	1625 5325	1725 5650	1875 6150	1850 6075	1050 3450	1325 4350	1400 4600	1525 5000	1500 4925
N2	680 2225	860 2825	910 2975	990 3250	990 3250	530 1750	660 2175	700 2300	760 2500	750 2450	425 1400	530 1750	570 1875	620 2025	610 2000
N3	450 1475	570 1875	610 2000	660 2175	660 2175	350 1150	435 1425	465 1525	510 1675	500 1650	285 940	355 1175	380 1250	410 1350	405 1325
N11	520 1700	650 2125	690 2275	750 2450	760 2500	400 1300	500 1650	530 1750	580 1900	570 1875	325 1075	405 1325	430 1400	470 1550	465 1525
S1	55 180	70 230	70 245	75 245	75 245	44 145	55 180	55 195	60 195	60 195	36 120	46 150	45 160	49 160	49 160
S2	44 145	55 180	55 195	60 195	60 195	35 115	46 150	45 155	49 160	49 160	29 95	37 120	36 130	40 130	39 130
S3	38 125	49 160	48 165	50 165	50 165	31 100	40 130	39 140	43 140	43 140	25 80	32 105	32 110	35 115	35 115
S11	75 245	100 330	100 345	105 345	105 345	60 195	80 260	80 260	85 280	85 280	50 165	65 215	65 215	70 230	70 230
S12	55 180	70 230	70 230	75 245	75 245	43 140	55 180	55 180	60 195	60 195	35 115	44 145	44 150	48 155	48 155
S13	31 100	39 130	39 140	42 140	42 140	25 80	32 105	31 110	34 110	34 110	20 65	26 85	25 90	28 90	28 90
H5	45 150	55 180	60 195	65 215	65 215	36 120	46 150	48 155	50 165	50 165	30 100	37 120	39 130	41 135	41 135
H8	46 150	60 195	60 215	65 215	65 215	39 130	50 165	50 165	55 180	55 180	31 100	40 130	40 140	44 145	43 140
H11	55 180	75 245	75 245	80 260	80 260	46 150	60 195	60 195	65 215	65 215	38 125	47 155	49 165	55 180	50 165
H12	85 280	105 345	105 375	115 375	115 375	70 230	90 295	90 310	95 310	95 310	55 180	70 230	70 245	80 260	80 260
H21	46 150	60 195	60 215	65 215	65 215	39 130	50 165	50 165	55 180	55 180	31 100	40 130	40 140	44 145	43 140

Informaţii cheie dinamometrică și valoare maximă a rotaţilor pe minut

Cheie dinamometrică

Valoarea rotaţiilor pe minut recomandată pentru toate sculele aşchietoare Seco este indicată
pe fiecare pagină a catalogului.
În mod normal, nu este necesară echilibrarea sculelor pentru valori ale rotaţiilor pe minut de până la 10.000.
Totuși, în unele cazuri este necesară echilibrarea,
de exemplu, la utilizarea unor scule și port-scule grele cu utilaje mici



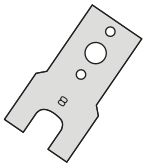
Utilizaţi cheia dinamometrică cu valori de cuplu fixe pentru a asigura forţa de strângere
corectă când montaţi plăcuţa Minimaster în suport.
Cheile dinamometrice sunt calibrate conform cu ISO 6789.
Codificare: MM02-4006
MM02 = 2 caneluri (MM03 = 3 caneluri)
40 = valoare cuplu 4 Nm
06 = dimensiunea plăcuţei

Peste 10 000 RPM:
Recomandăm echilibrarea sculei și port-sculelor cel puţin separat.
Peste 20 000 RPM:
Atât scula, cât și port-sculele trebuie echilibrate cel puţin separat.
Peste 30 000 RPM:
Scula și port-sculele trebuie echilibrate împreună.
Valorile maxime de rotaţii pe minut din tabele nu trebuie depășite niciodată.

Plăcuţe cu 2 caneluri

Dimensiunea plăcuţei	Cheie dinamometrică-metrică (include capătul)	Cap cu cheie înlocuibil	Valoare cuplu
			
MM06	MM02-4006	MM02-06	4 Nm
MM08	MM02-8008	MM02-08	8 Nm
MM10	MM02-1201012	MM02-1012	12 Nm
MM12	MM02-1201012	MM02-1012	12 Nm
MM12 DC= Ø 14,0	MM02-16014	MM02-14	16 Nm
MM12 DCX= Ø 16,0	MM02-1601620	MM02-1620	16 Nm
MM16	MM02-1601620	MM02-1620	16 Nm

Plăcuţe cu 3 caneluri

Dimensiunea plăcuţei	Cheie dinamometrică-metrică (include capătul)	Cap cu cheie înlocuibil	Valoare cuplu
			
MM06	MM03-4006	MM03-06	4 Nm
MM08	MM03-8008	MM03-08	8 Nm
MM10	MM03-1201012	MM03-1012	12 Nm
MM12	MM03-1201012	MM03-1012	12 Nm
MM16	MM03-16016	MM03-16	16 Nm



SMG – Introducere

Baza pentru SMG constă în clasificarea materialelor pieselor de lucru în funcţie de tip mai degrabă decât de uşurinţa relativă a prelucrării; prin urmare, aceasta conţine şi materiale compozite ale pieselor de lucru. Clasificarea este suficient de cuprinzătoare, identificarea SMG pentru un anumit material putând însă fi efectuată cu uşurinţă.
Fiecare SMG are un standard specific pentru materialul aflat într-o anumită stare, determinat ca referinţă pentru a facilita reglarea parametrilor de aşchiere pentru orice material prin comparaţia cu orice material de referinţă Seco, a se vedea pagina 802 - 805.
Pentru exemple privind materialele de referinţă EN C45E pentru SMG P4 şi EN 42 CrMo 4 pentru SMG P5 şi SMG H5, consultaţi detaliile din tabelele de mai jos.
În SMG, clasificarea materialelor pieselor de lucru implică un anumit standard pentru materialul aflat într-o anumită stare, furnizat ca referinţă pentru reglarea facilă şi clară a parametrilor de aşchiere pentru orice material efectiv, comparat cu orice material de referinţă Seco. Vom lua ca exemple materialele de referinţă EN C45E pentru SMG P4 şi EN 42 CrMo 4 pentru SMG P5 şi SMG H5, prezentate mai jos în tabelul 1, unde sunt indicate nivelurile de referinţă pentru proprietăţile materialului.

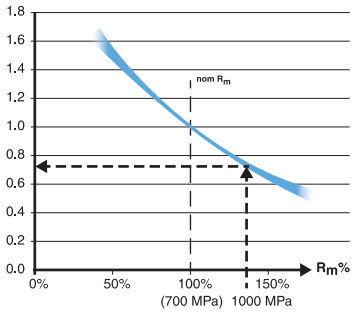
P4	Oţeluri structurale slab aliate, 0.25% < C < 0.67%wt Oţeluri slab aliate călite şi temperate	520 < R_m < 1200	C 45E R_m = 660 N/mm^2
P5	Oţeluri structurale, 0.25% < C < 0.67%wt Oţeluri călite şi revenite	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm^2

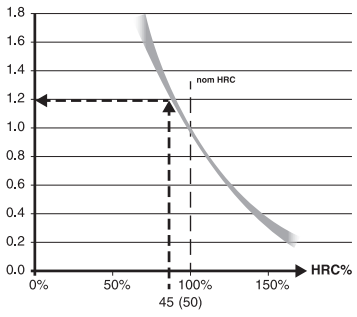
H5	Oţeluri călite	38 < HRC < 56	42 CrMo 4 50 HRC

Dacă ne referim numai la EN 42 CrMo 4 în stare recoaptă, rezistenţa maximă la întindere R_m poate varia, în mod normal, între Rm = 630 N/mm^2 şi R_m = 780 N/mm^2, ceea ce oferă nivelul de referinţă pentru SMG P5. În starea călită şi temperată, rezistenţa maximă la întindere R_m poate varia, în mod normal, între R_m = 900 N/mm^2 şi R_m = 1100 N/mm^2, rămânând în continuare în intervalul SMG P5. Dacă, însă, materialul este călit la o duritate ce depăşeşte R_m = 1200 N/mm^2, acesta va fi inclus în categoria SMG H5.

P5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Recopt	700	
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit şi temperat	1000	
H5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit şi temperat		45
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit şi temperat		50

Oţelul EN 42CrMo4 călit şi temperat poate fi utilizat pentru a ilustra modul în care uşurinţa de prelucrare depinde de starea materialelor.
Graficele de mai jos indică modul în care pot fi reglate recomandările de viteză pentru un material nominal în funcţie de valoarea relativă a R_m (diagrama din stânga se referă la ISO-P) şi pentru valoarea relativă a HRC (valabil pentru ISO-H).





Pentru a exemplifica modul în care valoarea nominală v_c a SMG P5 din poate fi reglată la o valoare mai precisă, recomandată, a v_c, avem nevoie de rezistenţa maximă la întindere R_m; în acest caz, vom utiliza valoarea pentru EN 42 CrMo 4 călit şi temperat, respectiv R_m = 1000 N/mm^2, conform tabelului de mai sus (săgeţile albastre aldine).
Să presupunem că determinăm o valoare nominală SMG P5 v_c = 280 m/min, pentru un anumit produs şi mod de prelucrare.
Apoi, vom folosi formula recomandată v_c = 280 m/min x 0,75 = 210 m/min.
În consecinţă, pentru SMG H5, valoarea nominală v_c poate fi reglată pe baza valorii pentru EN 42 CrMo 4 călit la HRC 45 (săgeţile gri mici).
Presupunând că valoarea nominală SMG H5 v_c = 50 m/min pentru un anumit produs şi mod de prelucrare care utilizează scule din carbură, acoperite şi cimentate, valoarea recomandată efectivă a v_c = 50 m/min x 1,2 = 60 m/min.
Pentru mai multe detalii privind materialele pieselor de lucru, consultaţi pagina 806-813 şi parametrii de aşchiere recomandaţi la paginile aplicabile.
Pentru o abordare mai facilă a parametrilor de aşchiere, recomandăm sculele aplicabile în secţiunea My Pages – Suggest (Paginile mele – Sugestii) a site-ului www.secotools.com

Oţeluri, oţeluri inoxidabile feritice și martensitice.

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
P1	Oţeluri cu așchiere ușoară	360 < R_m < 880	11 SMn30 R_m = 385 N/mm²	1500	0,14
P2	Oţeluri feritice slab aliate, C < 0.25%wt Oţeluri structurale generale slab liate	320 < R_m < 600	S235JRG2 R_m = 420 N/mm²	1600	0,23
P3	Oţeluri feritice și ferito-perlitice, C < 0.25%wt Oţeluri structurale generale Oţeluri de cementare	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm²	1800	0,14
P4	Oţeluri structurale slab aliate, 0.25% < C < 0.67%wt Oţeluri slab aliate călite și temperate	520 < R_m < 1200	C 45E R_m = 660 N/mm²	2000	0,15
P5	Oţeluri structurale, 0.25% < C < 0.67%wt Oţeluri călite și revenite	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²	2020	0,18
P6	Oţeluri căliteslab aliate, C > 0.67%wt Oţeluri pentru arcuri și bile slab aliate	520 < R_m < 1200	C 100S R_m = 600 N/mm²	2100	0,17
P7	Oţeluri călite, C > 0.67%wt Oţeluri pentru arcuri și bile	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm²	2160	0,17
P8	Oţeluri pentru scule Oţeluri rapide (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Oţeluri inoxidabile feritice și martensitice	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm²	2000	0,15
P12	Oţeluri inoxidabile durificate prin precipitare	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm²	2100	0,17

Oţeluri inoxidabile austenitice și duplex cu așchiere ușoară

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
M1	Oţeluri inoxidabile austenitice cu așchiere ușoară		X 10 CrNiS 18 9	1700	0,14
M2	Oţeluri inoxidabile austenitice slab aliate		X 5 CrNi 18 10	1920	0,18
M3	Oţeluri inoxidabile austenitice mediu aliate		X 2 CrNiMo 18 14 3	2070	0,17
M4	Oţeluri inoxidabile austenitice și duplex înalt aliate		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Oţeluri inoxidabile austenitice și duplex înalt aliate dificile		X 2 CrNiMoN 25 7 4	2510	0,13

Fonte

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
K1	Fonte cenușii (GCI)		EN-GJL-250	930	0,32
K2	Fontă cu grafit compact (CGI)		EN-GJV-400	1000	0,35
K3	Fonte maleabile (MCI)		EN-GJMB-550-4	1050	0,37
K4	Fonte cu grafit nodular (SGI)		EN-GJS-500-7	1160	0,37
K5	Fonte ductiel călite (ADI)		EN-GJS-1000-5	0	
K6	Fontă cenușie austenitică cu grafit lamelar		EN-GJLA-XNiCuCr15-6-2	0	
K7	Fontă cenușie austenitică cu grafit nodular		EN-GJSA-XNiMn23-4	0	

Metale neferoase

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
N1	Aliaje de aluminiu, Si < 9%		AW-7075	0	
N2	Aliaje de aluminiu, 9% < Si < 16%		AC-44200 Si = 12%	0	
N3	Aliaje de aluminiu, Si >16%		AlSi17Cu5	0	
N11	Aliaje de cupru		CW614N	740	0,26

Super aliaje și aliaje din titan

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
S1	Superaliaje pe bază de fier		Discalloy	0	
S2	Superaliaje pe bază de cobalt		Stellite 21	0	
S3	Superaliaje pe bază de nichel		Inconel 718	2530	0,21
S11	Titan, slab aliat, (α)		Ti	0	
S12	Titan, mediu aliat, (α+β)		TiAl6V4	1500	0,24
S13	Titan, înalt aliat, (similar β și β)		Ti10V2Fe3Al	0	

Materiale dure

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
H3	Oţeluri tratat termic	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Oţeluri călite	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Oţeluri călite și temperate Oţeluri pentru rulmenţi	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Oţeluri pentru scule Oţeluri rapide (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Oţeluri inoxidabile martensitice	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Oţeluri inoxidabile durificate prin precipitare	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Oţel manganos	23 < HRC < 64	X 120 Mn 12 50 HRC	0	
H31	Fortă albă	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC	0	

Alte materiale dificile

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
PM1	Materiale PM slab aliate		F-0008 Fe-0.7C	0	
PM2	Materiale PM mediu aliate		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C	0	
PM3	Materiale PM înalt aliate Materiale pentru scaunul supapei de evacuare, etc.			0	
HF1	Aliaje ecruisate Aliaje pe bază de fier sudate sau îmbinate cu plasmă			0	
HF2	Aliaje ecruisate Aliaje pe bază de cobalt și pe bază de nichel sudate sau îmbinate cu plasmă			0	
CC1	Carbură de tungsten sinterizată		G50	0	

Plastic și compozite

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
TS1	Polimeri termoset		Uree formaldehidică (UF)	0	
TS2	Compozite termoset din fibră de carbon		T300 T700 T800 HTA-S IMA - Epoxy (M21)...	0	
TS3	Compozite termoset din fibră de sticlă		Epoxy - HX..(42..)/E glass (7781...)...	0	
TS4	Compozite termoset din fibre aramide		Kevlar 49	0	
TP1	Polimeri termoplastici		Policarbonat (PC)	0	
TP2	Compozite termoplast din fibră de carbon		PPS/PEEK - T300..	0	
TP3	Compozite termoplast din fibră de sticlă		Sticlă PPS/PEEK - E sau sticlă A...	0	
TP4	Compozite termoplast din fibre aramide			0	

Grafit

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
GR1	Grafit		R 8500	0	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
	1213				Recopt	
	12 L 13				Recopt	
	1108				Recopt	
	11 L 08				Recopt	
					Recopt	
	1140	40			Recopt	
	1146				Recopt	
	1215				Recopt	
	12 L 14				Recopt	
		16D			Recopt	
	A573 Grade 58	18kp	11 378		Recopt	
	A573 Grade 70	St14kP	11 448		Recopt	
	1010	10			Recopt	
F.1110	1015	15			Recopt	
	1020, 1023	20	12 024		Recopt	
		17G1S	11 523		Recopt	
F.1511	1015	15			Recopt	
F.1120	1025	25			Recopt	
					Recopt	
	A204 Grade A		15 020		Recopt	
	4520				Recopt	
	3310, 9314	20X2H4A	16 420		Recopt	
	4320		16 220		Recopt	
					Recopt	
F.1516	5115	12KHN2	14 220		Recopt	
		18HG			Recopt	
	5120	20KH	14 221		Recopt	
	5120 H	20KH			Recopt	
	A182-F11, A182-F12	12KHM	15 121		Recopt	
	A387 Grade 12 Cl. 2				Recopt	
F.155	A182-F22	12KH8	15 313		Recopt	
F.1130	1035	35	12 040		Recopt	
F.5110	1045	45	12 050		Recopt	
	1040	40	12 041		Recopt	
F.1150	1055	55			Recopt	
	1060	60	12 061		Recopt	
	1039	40G			Recopt	
	1330	30G2			Recopt	
F.1135	1035	35			Recopt	
F.1140	1045	45	12 050		Recopt	
F.1150	1064	60			Recopt	
	1060	60			Recopt	
F.144	9255	55S2			Recopt	
F.1250	4135	35KHM			Recopt	
F.5241	S1	5KHV2S			Recopt	
	L6	5KHNV			Recopt	
	5045				Recopt	
	3135				Călit şi temperat	
	3435				Recopt	
	9840				Călit şi temperat	
F.1280	4340	38H2N2MA	16 343		Recopt	
	5132	35KH			Călit şi temperat	
	5140	40H	14 140		Călit şi temperat	
F.1251	4130	20KHM	15 130		Călit şi temperat	
F.1252	4142, 4140	38HM	15 142		Recopt	
F.1252	4142, 4140	38HM	15 142		Călit şi temperat	
					Călit şi temperat	
F.143	6150	50KHFA	15 260		Călit şi temperat	
F.1740	A355 Cl. A				Recopt	
F.5103	1070	70			Recopt	
F.5117	1095				Recopt	
F.5118	W1	U10A			Recopt	
		U10			Recopt	
	W1	U13			Recopt	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
F.520L	L2	11KHF			Recopt	
F.5220	O1	9KHVG			Recopt	
	O2	9G2F			Recopt	
F.5230	52100	SHKH15	14 109		Recopt	
F.5212	D3	KH12			Recopt	
	H11	4KH5MFS			Recopt	
F.5318	H13	4KH5MF1S			Recopt	
F.5227	A2	9KH5VF			Recopt	
	H10	3KH3M3F			Recopt	
F.5213		KH12			Recopt	
		KH12MF			Recopt	
F.520.S	L6	5KHNM			Recopt	
F.5613	M35	R6M5K5			Recopt	
	M42	R2AM9K5			Recopt	
	T4	R18K5F2			Recopt	
F.5603	M2	R6M5			Recopt	
	M7				Recopt	
	T1	R18			Recopt	
	403	08KH13			Recopt	Ferritic
F.3401	410, CA-15	12KH13, 08KH13			Recopt	Martensitic
F.3113	430	12KH17			Recopt	Feritic
F.5261	420	20KH13	17 022		Recopt	Martensitic
F.3404	420	40KH13			Recopt	Martensitic
	440 A				Recopt	Martensitic
	440 B	95KH18			Recopt	Martensitic
	440 C	95KH18			Recopt	Martensitic
	A182 F6NM			F6NM	Recopt	Martensitic
	446	15KH28			Recopt	Feritic
	XM-13			PH 13-8 Mo	Normalizat în soluţie	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Normalizat în soluţie	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Normalizat în soluţie	Martensitic
	631	09KH17N7YU1		17-7 PH	Normalizat în soluţie	Austenitic/Feritic
	AMS 6515			Marage 350	Normalizat în soluţie	Martensitic
	AMS 6521			Marage 300	Normalizat în soluţie	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Normalizat în soluţie	Martensitic
	AMS 6512			Marage 250	Normalizat în soluţie	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Normalizat în soluţie	Martensitic
F.3508	303	12KH19N9			Recopt	Austenitic
F.3504	304 L	03KH18N11			Recopt	Austenitic
F.3504	304	08KH18N10	17 240		Recopt	Austenitic
F.3534	316	08KH17H13M2T	17 346		Recopt	Austenitic
F.3524	347	08KH18N12B			Recopt	Austenitic
F.3517	301	07KH16N6			Recopt	Austenitic
	302	12KH18N9			Recopt	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Recopt	Austenitic
	316 LN	03KH16N15M3			Recopt	Austenitic
F.3541	304 LN	03KH18N11			Recopt	Austenitic
	317	08KH17H15M3T			Recopt	Austenitic
				253 MA	Recopt	Austenitic
	310 S	12KH25N20			Recopt	Austenitic
	329 LN			SAF 2205	Recopt	Duplex
				3RE60	Recopt	Duplex
	904L				Recopt	Super austenitic
	329				Recopt	Duplex
	660			A286	Normalizat în soluţie	Austenitic
				254 SMO	Recopt	Super austenitic
				654 SMO	Recopt	Super austenitic
				Alloy 800	Recopt	Austenitic
	F 53			SAF 2507	Recopt	Super duplex

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
	A48 25 B	Sc 15	422 415			Fonte cenuşii (GCI)
	A48 30 B	Sc 20	422 420			Fonte cenuşii (GCI)
	A48 35 B	Sc 25	422 425			Fonte cenuşii (GCI)
	A48 50 B	Sc 35				Fonte cenuşii (GCI)
	G 3500					Fonte cenuşii (GCI)
	Grade 350					Fontă cu grafit vermicular (CGI)
	Grade 400					Fontă cu grafit vermicular (CGI)
	Grade 400-15					Fontă cu grafit vermicular (CGI)
	Grade 450					Fontă cu grafit vermicular (CGI)
	Grade 500					Fontă cu grafit vermicular (CGI)
	A220 60004				Temperat	Fontă maleabilă (MCI)
						Fontă cu grafit nodular (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Fontă cu grafit nodular (SGI)
	60-40-18	Vc 42-12				Fontă cu grafit nodular (SGI)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Fontă cu grafit nodular (SGI)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Fontă cu grafit nodular (SGI)
FGE 70-2	A536, 100-70-03	Vc 70-2				Fontă cu grafit nodular (SGI)
	1600/1300/-					Fontă ductilă (ADI)
	1050/700/7					Fontă ductilă (ADI)
	1200/850/4					Fontă ductilă (ADI)
	1400/1100/1					Fontă ductilă (ADI)
	850/550/10					Fontă ductilă (ADI)
	A436 Type 2			Ni-Resist 2		Fontă austenitică cu grafit lamelar
	A436 Type 3			Ni-Resist 3		Fontă austenitică cu grafit lamelar
	A436 Type 1			Ni-Resist 1		Fontă austenitică cu grafit lamelar
				Nodumag		Fontă austenitică cu grafit lamelar
	A436 Type D-2			Ni-Resist D-2		Fontă austenitică cu grafit lamelar
	A439 Type D-2M			Ni-Resist D-2M		Fontă austenitică cu grafit lamelar
	A436 Type D-3			Ni-Resist D-3		Fontă austenitică cu grafit lamelar
	A439 Type D-5			Ni-Resist D-5		Fontă austenitică cu grafit lamelar
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
				Discalloy	Îmbătrânit	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Normalizat în soluţie	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Pur comercial	Ti (α)
	AMS 4919			Ti 6-2-4-2	Recopt	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Recopt	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Recopt	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Recopt	Ti (β)
F.1516	5115	12KHN2	14 220		Cementat	
F.5103	1070	70			Călit şi temperat	
F.5107	1078, 1080	75			Călit şi temperat	
F.5117	1095				Călit şi temperat	
F.5118	W1	U10A			Călit şi temperat	
	S1	5KHV2SF			Călit şi temperat	
	5155				Călit şi temperat	
F.1252	4142, 4140	38HM	15 142		Călit şi temperat	
F.520L	L2	11KHF			Călit şi temperat	
F.5220	O1	9KHVG			Călit şi temperat	
	O2	9G2F			Călit şi temperat	
F.5230	52100	SHKH15	14 109		Călit şi temperat	
F.5318	H13	4KH5MF1S			Călit şi temperat	
F.5227	A2	9KH5VF			Călit şi temperat	
F.5211	D2	KH12MF			Călit şi temperat	
F.5213		KH12			Călit şi temperat	
		KH12MF			Călit şi temperat	
F.520.S	L6	5KHNM			Călit şi temperat	
F.5613	M35	R6M5K5			Călit şi temperat	
	M42	R2AM9K5			Călit şi temperat	
	T1	R18			Călit şi temperat	
F.5261	420	20KH13	17 022		Călit şi temperat	Martensitic
	440 A				Călit şi temperat	Martensitic
	440 B	95KH18			Călit şi temperat	Martensitic
	440 C	95KH18			Călit şi temperat	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Îmbătrânit	Austenitic
	AMS 6512			Marage 250	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6515			Marage 350	Îmbătrânit	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		Fontă albă
	A532 IA (NiCr-HC)			Ni-Hard 1		Fontă albă
	A532 ID (Ni-HiCr)			Ni-Hard 4		Fontă albă

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