





KIT		Tools	Description		Cermet	
					pz	RIV.
TAGLIANTE AFFILATO SUPER FINITURA	KIT INS WTBP 	H·BOR H·NBJ16	0601003L-F	060102L-F	2	TN60
			TBGT	060102L	2	TN60
			TPGH	090202L	2	TN60
				110304L	2	TN60
TAGLIANTE AFFILATO SUPER FINITURA	KIT INS CCGT 	H·BOR-P H·NBJ16-P	CCGT	030102L-F	2	TN60
				040102L-F	2	TN60
				060202EL-U	2	TN60
				09T302EL-U	2	TN60
TAGLIANTE AFFILATO SUPER FINITURA	KIT INS NBH2084 	NBH2084	TBGT	060102L	2	TN60
			TPGH	090202L	2	TN60
				110304L	2	TN60
TAGLIANTE AFFILATO SUPER FINITURA	KIT INS AB1143 	ABC1143 ABR1143 ABJ1143	CCGT	030102L-F	2	TN60
				040102L-F	2	TN60
				060202EL-U	2	TN60

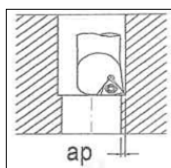
PARAMETRI DI TAGLIO INDICATIVI

$$Vc = D \cdot 3.14 \cdot n / 100$$

$$n = Vc \cdot 100 / 3.14 \cdot D$$









$$Vf = n \cdot f$$

Vc = cutting speed (mm/m)
D = diameter of workpiece
n = revolution (rpm)
Vf = feed rate (mm/min)
f = feed (mm/rev.)



Boring Range		Insert	ap	feed mm/rev	cutting speed m/min
MIN	MAX				
6	9	WBGT060102L	0,05 - 0,20	0,05 - 0,10	Carbon Steel 100-200
8	13	TBGT060102L	0,05 - 0,20	0,05 - 0,10	Stainless Steel 70-140
		TBGT060104L	0,10 - 0,25	0,07 - 0,15	
12	70	TPGH090202L	0,05 - 0,20	0,05 - 0,10	Cast Iron 70-140
		TPGH090204L	0,10 - 0,25	0,07 - 0,15	
20	150	TPGH110302L	0,05 - 0,20	0,05 - 0,10	Aluminio 150-300
		TPGH110304L	0,10 - 0,25	0,07 - 0,15	

SINERGYA INSERTI PER PROGRAMMA DI ALESATURA

Insert	Description	Cermet		Megacoat Cermet				PVD Coated Carbide		Megacoat Carbide Inox Superleghe	Carbide
		TN620	TN60	PV720	PV7010	PV7025	PV7005	PR930	PR1005	PR1535	KV10
TAGLIANTE AFFILATO SUPERFINITURA 	0601003L-F		*					*			
	0601011L-F		*					*			*
	060102L-F		*		*	*		*			*
	060104L-F		*		*	*		*			*
GHSA 	WBGW 060102L										*
TAGLIANTE AFFILATO SUPERFINITURA 	060101L		*								*
	060102L		*	*	*	*		*			*
	060104L		*	*	*	*		*			*
	060101ML								*		
	060102ML								*		
GHSA 	TBGW 060102 060104		*								*
TAGLIANTE AFFILATO SUPERFINITURA 	090201L		*					*		*	*
	090202L	*	*	*	*	*	*	*		*	*
	090204L	*	*	*	*	*	*	*		*	*
	090201R							*		*	*
	090202R	*	*	*	*	*	*	*		*	*
	090204R	*	*	*	*	*	*	*		*	*
	110302L	*	*	*	*	*	*	*		*	*
	110304L	*	*	*	*	*	*	*		*	*
	110302R	*	*	*	*	*	*	*		*	*
	110304R	*	*	*	*	*	*	*		*	*
TAGLIANTE AFFILATO SUPERFINITURA 	0301003L-F		*					*			*
	030101L-F		*					*			*
	030102L-F		*		*	*		*			*
	030104L-F		*		*	*		*			*
	0301003R-F							*			*
	030101R-F		*			*		*			*
	030102R-F		*		*	*		*			*
	030104R-F		*		*	*		*			*
	0401003L-F							*			*
	040101L-F		*			*		*			*
	040102L-F		*		*	*		*			*
	040104L-F		*		*	*		*			*
	0401003R-F							*			*
	040101R-F		*			*		*			*
040102R-F		*			*		*			*	
040104R-F		*			*		*			*	
TAGLIANTE CON ONATURA 	060201EL-U		*			*		*			
	060202EL-U	*	*	*		*		*			
	060204EL-U	*	*			*		*			
	060201ER-U					*		*			
	060202ER-U	*	*	*		*		*			
	060204ER-U	*	*	*		*		*			
	09T301EL-U		*			*		*			
	09T302EL-U		*			*		*			
	09T304EL-U		*			*		*			
	09T301ER-U		*			*		*			
SEMIFINITURA 	060202GK	*		*	*	*		*			
	060204GK	*		*	*	*		*			
	09T302GK	*		*	*	*		*			
	09T304GK	*		*	*	*		*			
	120404GK	*		*	*	*		*			
	120408GK	*		*	*	*		*			
120412GK							*				