

**RRD**



**Versatilità e lunga durata  
dell'utensile**

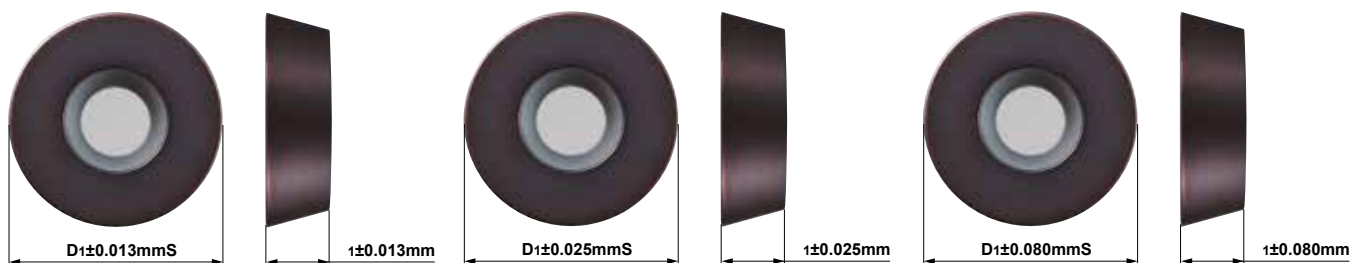


# Frese con inserti di tipo rotondo

# RRD

## Caratteristiche

Gli inserti sono disponibili in tre diverse classi di tolleranza per adattarsi ad ogni tipo di lavorazione.



## RDHX

## RDZX

## RDMX

- Sinterizzato (Tolleranza H)
- Alta precisione
- Per semi-finitura e finitura

- Sinterizzato (Tolleranza E)
- Uso universale
- Inserto economico con lunga vita utensile

- Sinterizzato (Tolleranza M)
- Uso universale
- Per sgrossatura e semi-finitura


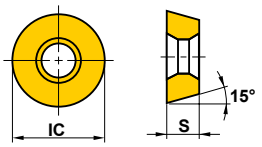

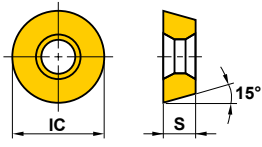

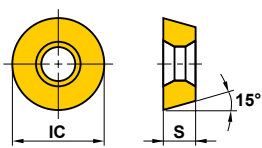
## Gradi degli inserti intercambiabili per RRD

ISO	Carburo rivestito	Cermet / Cermet rivestito	Carburo cementato	
P Acciaio	P01			↑ Resistenza all'usura
	P10	VP05HT, VP10H	VP25N	
	P20	VP15TF, VP20M	NX4545	
	P30	E7030		
	P40			
M Acciaio inossidabile	M01			↑ Resistenza all'usura
	M10	VP15TF, VP20M	VP25N	
	M20	E7030	NX4545	
	M30			
	M40			
K Chiusa	K01			↓ Tenacità
	K10		VP25N	
	K20	VP15TF		
	K30			
H Materiali temprati	H01			↓ Tenacità
	H10	VP05HT, VP10H		
	H20	VP15TF		
	H30			

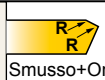
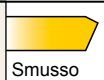
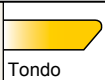
## Adatto a frese RRD



# INSERTI

Materiale da lavorare	P	Acciaio	● ● ● ● ●					● ● ● ● ●		<b>Parametri di taglio (Guida) :</b> ● : Taglio stabile ● : Taglio generico ✚ : Taglio instabile <b>Onatura :</b> E : Tondo S : Smusso + onatura T : Smusso			
	M	Acciaio inossidabile	● ● ● ● ●					● ● ● ● ●					
Forma	K	Ghisa	✚ ✚ ✚ ✚ ✚					✚ ✚ ✚ ✚ ✚		Dimensioni (mm) IC S Geometria			
	S	Lega resistente al calore, Lega di titanio	● ● ● ● ●					● ● ● ● ●					
		H	Materiali temprati	● ● ● ● ●					● ● ● ● ●				
Forma	Codice di ordinazione	Classe	Onatura	Rivestito					Metallo duro	Dimensioni (mm)		Geometria	
				F7030	VP15TF	VP20M	VP10H	VP05HT	UTT20T	IC	S		
	RDHX0501M0E	H	E	●	●	●	●	●			5	1.5	
	RDHX0501M0S	H	S	●	●	●	●	●	●	●	5	1.5	
	RDHX07T1M0E	H	E	●	●	●	●	●			7	1.98	
	RDHX07T1M0S	H	S	●	●	●	●	●	□	□	7	1.98	
	RDHX0702M0E	H	E	●	●	●	●	●			7	2.38	
	RDHX0702M0S	H	S	●	●	●	●	●	□	□	7	2.38	
	RDHX1003M0E	H	E	●	●	●	●	●			10	3.18	
	RDHX1003M0S	H	S	●	●	●	●	●	□	□	10	3.18	
	RDHX12T3M0E	H	E	●	●	●	●	●			12	3.97	
	RDHX12T3M0S	H	S	●	●	●	●	●	□	□	12	3.97	
	RDHX1604M0E	H	E	●	●	●	●	●			16	4.76	
	RDHX1604M0S	H	S	●	●	●	●	●	□	□	16	4.76	
IC: ±0.013 mm S: ±0.013 mm													
	RDMX07T1M0E	M	E					●			7	1.98	
	RDMX07T1M0T	M	T	●	●	●	●	●	□	□	7	1.98	
	RDMX0702M0E	M	E					●			7	2.38	
	RDMX0702M0T	M	T	●	●	●	●	●	□	□	7	2.38	
	RDMX1003M0E	M	E					●			10	3.18	
	RDMX1003M0S	M	S	●	●	●	●	●			10	3.18	
	RDMX1003M0T	M	T	●	●	●	●	●	●	●	10	3.18	
	RDMX12T3M0E	M	E					●			12	3.97	
	RDMX12T3M0S	M	S	●	●	●	●	●			12	3.97	
	RDMX12T3M0T	M	T	●	●	●	●	●	●	●	12	3.97	
	RDMX1604M0E	M	E					●			16	4.76	
	RDMX1604M0S	M	S	●	●	●	●	●			16	4.76	
RDMX1604M0T	M	T	●	●	●	●	●	●	●	16	4.76		
IC: ±0.080 mm S: ±0.080 mm													
	RDZX0501M0E	Z	E	●							5	1.50	
	RDZX0501M0S	Z	S	●	●	●	●	●			5	1.50	
	RDZX07T1M0E	Z	E	●							7	1.98	
	RDZX07T1M0S	Z	S	●	●	●	●	●			7	1.98	
	RDZX0702M0E	Z	E	●							7	2.38	
	RDZX0702M0S	Z	S	●	●	●	●	●			7	2.38	
	RDZX1003M0E	Z	E	●							10	3.18	
	RDZX1003M0S	Z	S	●	●	●	●	●			10	3.18	
	RDZX12T3M0E	Z	E	●							12	3.97	
	RDZX12T3M0S	Z	S	●	●	●	●	●			12	3.97	
	RDZX1604M0E	Z	E	●							16	4.76	
	RDZX1604M0S	Z	S	●	●	●	●	●			16	4.76	
IC: ±0.025 mm S: ±0.025 mm													

## Parametri del tagliente

<b>S</b>		<b>T</b>		<b>E</b>	
Smusso+Onatura		Smusso		Tondo	
Sgrossatura		Sgrossatura e finitura		Finitura	

● : Inventario mantenuto. □ : Non a magazzino, prodotto solo su ordinazione

# FRESATURA MULTIFUNZIONALE

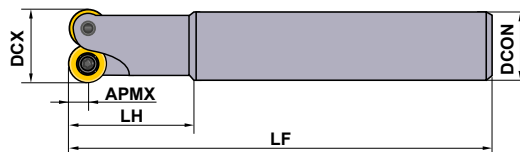
# RRD



Sgrossatura



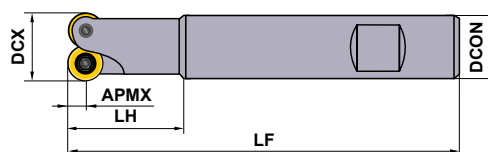
P M K N S H



## TIPO A STELO RETTILINEO

Solo portautensile destro.

R (mm)	Codice di ordinazione	Disponibilità		Dimensioni (mm)					Vite di fissaggio	Chiave	Inserto
		R	Numero di denti	DCX	DCON	LF	LH	APMX			
2.5	RRD025R102S10Z-B20	●	2	10	10	75	23	2.5	B-TS20	TKY06F	RDH/Z 0501M0
	RRD025R123S12Z-B20	●	3	12	12	75	23	2.5	B-TS20	TKY06F	
	RRD025R154S16Z-B20	●	4	15	16	80	23	2.5	B-TS20	TKY06F	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S12Z	●	2	12	12	75	23	3.5	B-TS253	TKY07F	
	RRD035R122S16Z	●	2	12	16	88	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16Z	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16ZM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20Z	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20ZM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25Z	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S12Z	●	3	15	12	75	17	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	RRD035R153S16Z	●	3	15	16	78	30	3.5	TS253	TKY08F	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20ZM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25Z	●	2	20	25	136	72	5.0	B-TS35	TKY15F	
	RRD050R202S25ZL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25ZM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	



## TIPO A STELO CON PIANETTO WELDON

Solo portautensile destro.

R (mm)	Codice di ordinazione	Disponibilità		Dimensioni (mm)					Vite di fissaggio	Chiave	Inserto
		R	Numero di denti	DCX	DCON	LF	LH	APMX			
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S16WL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16WM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16W	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16WM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20W	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20WM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25W	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S16W	●	3	15	16	78	30	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
5	RRD050R202S20W	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20WM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25W	●	2	20	25	135	72	5.0	B-TS35	TKY15F	
	RRD050R202S25WL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25WM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	

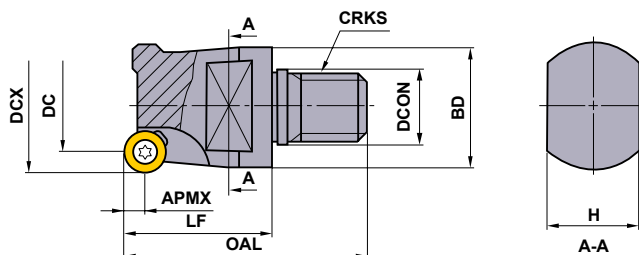
● : Inventario mantenuto.

# FRESATURA MULTIFUNZIONALE

# RRD



Sgrossatura



## TIPO AVVITABILE

Solo portautensile destro.

R (mm)	Codice di ordinazione	Disponibilità	Numero di denti	Dimensioni (mm)								Vite di fissaggio	Vite di fissaggio	Chiave	Inserto	
				DCX	DC	OAL	LF	DCON	BD	CRKS	APMX					H
2.5	RRD025R102M5-B20	●	2	10	5	35	20	5.5	9.9	M5	2.5	6	B-TS20	—	TKY06F	RDH/Z 0501M0
	RRD025R123M8-B20	●	3	12	7	38	20	8.5	13.5	M8	2.5	9	B-TS20	—	TKY06F	
	RRD025R154M8-B20	●	4	15	10	38	20	8.5	13.5	M8	2.5	10	B-TS20	—	TKY06F	
	RRD025R205M10-B20	●	5	20	15	44	25	10.5	18	M10	2.5	15	B-TS20	—	TKY06F	
3.5	RRD035R122M8	●	2	12	5	46	28	8.5	13.5	M8	3.5	9	B-TS253	—	TKY07F	RDH/M/Z 07T1M0
	RRD035R153M8	●	3	15	8	46	28	8.5	13.5	M8	3.5	10	TS253	—	TKY08F	
	RRD035R204M10	●	4	20	13	47	28	10.5	18	M10	3.5	15	TS253	—	TKY08F	
	RRD035R255M12	●	5	25	18	50	28	12.5	21	M12	3.5	17	TS253	—	TKY08F	
	RRD035R306M16	●	6	30	23	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
	RRD035R357M16	●	7	35	28	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
3.5	RRD035R152M8	●	2	15	8	46	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	RDH/M/Z 0702M0
	RRD035R153M8X	●	3	15	8	43	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	
5	RRD050R202M10	●	2	20	10	47	28	10.5	18	M10	5.0	15	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050R252M12	●	2	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R253M12	●	3	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M12	●	4	30	20	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M16	●	4	30	20	55	32	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R355M16	●	5	35	25	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R426M16	●	6	42	32	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
6	RRD060R242M12	●	2	24	12	54	32	12.5	21	M12	6.0	17	B-TS35	—	TKY15F	RDH/M/Z 12T3M0
	RRD060R353M16	●	3	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R354M16	●	4	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R424M16	●	4	42	30	55	32	17	29	M16	6.0	24	B-TS35	TS1001	TKY15F	
	RRD060R425M16	●	5	42	30	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
8	RRD080R322M16	●	2	32	16	65	42	17	29	M16	8.0	22	214	—	TKY20F	RDH/M/Z 1604M0

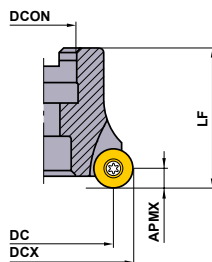
(Nota) Per prolunghe del tipo ad avvitamento, fare riferimento alla pagina K144—K145.

# FRESATURA MULTIFUNZIONALE

## RRD N



Sgrossatura



### TIPO AD ALBERO (neutro)

Solo portautensile destro.

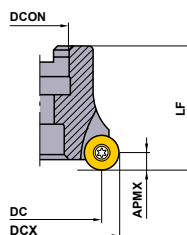
R (mm)	Codice di ordinazione	Disponibilità		Dimensioni (mm)					* WT (kg)	Accessori					
		R	Numero di denti	DCX	DC	LF	DCON	APMX		Spessore	Vite per spessore	Vite di fissaggio	Vite di fissaggio	Chiave	Inserto
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	—	—	B-TS35	—	TKY15F	RDH/M/Z
	RRD050N-052A07R	●	7	52	42	50	22	5	0.4	—	—	B-TS35	—	TKY15F	1003M0
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0
	RRD060N-050A05R	●	5	50	38	50	22	6	0.38	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-052A05R	●	5	52	40	50	22	6	0.4	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-063A06R	●	6	63	51	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	
8	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080N-052A04R	●	4	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-052A05R	●	5	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-063A05R	●	5	63	47	50	22	8	0.58	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-066A05R	●	5	66	50	50	27	8	0.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-080A06R	●	6	80	64	52	27	8	1	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-125B08R	●	8	125	109	52	40	8	2.5	KS-12	B-TS45	214	—	TKY20F	
RRD080N-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F		

\* WT : Peso utensile

## RRD P



Sgrossatura



### TIPO AD ALBERO (positivo)

Solo portautensile destro.

R (mm)	Codice di ordinazione	Disponibilità		Dimensioni (mm)					* WT (kg)	Accessori					
		R	Numero di denti	DCX	DC	LF	DCON	APMX		Spessore	Vite per spessore	Vite di fissaggio	Vite di fissaggio	Chiave	Inserto
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0E
	RRD060P-052A05R	●	5	52	40	50	22	6	0.35	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-063A06R	●	6	63	51	50	22	6	0.58	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-066A06R	●	6	66	54	52	27	6	0.6	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-080A07R	●	7	80	68	50	27	6	1.0	—	—	B-TS35	TS1001	TKY15F	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080P-063A05R	●	5	63	47	50	22	8	0.53	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-066A05R	●	5	66	50	50	27	8	0.55	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-080A06R	●	6	80	64	52	27	8	1.0	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-125B08R	●	8	125	109	52	40	8	2.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F	

\* WT : Peso utensile

● : Inventario mantenuto.

## PARAMETRI DI TAGLIO CONSIGLIATI

### PARAMETRI DI TAGLIO PER LA SGROSSATURA (ae=50% di Ø)

Materiale da lavorare	Durezza	Grado	Velocità di taglio (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acciaio dolce	≤180HB	NX4545 F7030 VP15TF	(250-320)	-0.2	0.25	-0.5	0.45	-1.0	0.35	-1.0	0.40	-1.0	0.50	-1.5	0.60
			(240-300)	0.2-0.3	0.20	0.5-1.0	0.25	1.0-2.0	0.30	1.5-2.0	0.32	1.0-1.5	0.40	1.5-2.5	0.45
			(200-280)	0.3-0.5	0.12	1.0-1.5	0.15	2.0-2.5	0.20	2.0-3.0	0.25	1.5-3.0	0.35	2.5-5.0	0.35
Acciaio al carbonio Acciaio legato	180-350HB	NX4545 F7030 VP15TF	(220-300)	-0.2	0.20	-0.5	0.40	-1.0	0.30	-1.0	0.40	-1.0	0.50	-1.5	0.55
			(200-290)	0.2-0.3	0.15	0.5-1.0	0.20	1.0-1.5	0.25	1.5-2.0	0.30	1.0-1.5	0.38	1.5-2.5	0.40
			(160-250)	0.3-0.5	0.10	1.0-1.5	0.10	1.5-2.0	0.22	2.0-3.0	0.22	1.5-3.0	0.30	2.5-4.5	0.32
M Acciaio inossidabile	≤270HB	F7030 VP20M	(180-240)	-0.1	0.15	-0.5	0.20	-1.0	0.20	-1.0	0.25	-1.0	0.25	-1.5	0.30
			(160-200)	0.1-0.2	0.15	0.5-1.0	0.15	1.0-2.0	0.18	1.5-2.0	0.20	1.0-1.5	0.22	1.5-2.5	0.25
			(140-180)	0.2-0.25	0.10	1.0-1.5	0.12	2.0-2.5	0.14	2.0-3.0	0.15	1.5-3.0	0.18	2.5-5.0	0.20
K Ghisa	Resistenza alla trazione ≤450MPa	VP15TF VP20M VP10H	(200-250)	-0.1	0.15	-0.5	0.18	-1.0	0.20	-1.0	0.25	-1.0	0.30	-1.5	0.35
			(180-230)	0.1-0.2	0.10	0.5-1.0	0.10	1.0-1.5	0.15	1.5-2.0	0.18	1.0-1.5	0.25	1.5-2.5	0.22
			(160-200)	0.2-0.25	0.10	1.0-1.5	0.10	1.5-2.0	0.12	2.0-3.0	0.15	1.5-3.0	0.18	2.5-4.5	0.20
H Acciaio temprato	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(140-200)	-0.1	0.12	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(110-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-170)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

(Nota 1) Se si utilizza una larghezza di taglio massima, ridurre i parametri di taglio del 20%.

(Nota 2) Se si utilizza uno sbalzo lungo, ridurre la velocità di avanzamento del 20%.

### PARAMETRI DI TAGLIO PER LA FINITURA (ae=20% di Ø)

Materiale da lavorare	Durezza	Grado	Velocità di taglio (m/min)	Ø10-15mm		Ø20mm		Ø24-25mm		Ø30-42mm		Ø50-80mm		Ø100-160mm	
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)
P Acciaio dolce	≤180HB	NX4545 F7030 VP15TF	(260-360)	-0.1	0.15	-0.15	0.20	-0.15	0.25	-0.15	0.30	-0.15	0.32	-0.3	0.35
			(240-320)	0.1-0.2	0.15	0.1-0.2	0.15	0.1-0.2	0.18	0.1-0.3	0.20	0.1-0.3	0.22	0.2-0.3	0.25
			(220-280)	0.2-0.24	0.10	0.1-0.30	0.15	0.1-0.30	0.18	0.1-0.30	0.20	0.2-0.30	0.20	0.3-0.40	0.20
Acciaio al carbonio Acciaio legato	180-350HB	NX4545 F7030 VP15TF	(250-350)	-0.1	0.12	-0.1	0.15	-0.1	0.18	-0.1	0.25	-0.1	0.28	-0.15	0.30
			(230-310)	0.1-0.15	0.12	0.1-0.30	0.15	0.1-0.30	0.15	0.1-0.30	0.20	0.1-0.3	0.22	0.15-0.3	0.25
			(210-270)	0.15-0.2	0.10	0.15-0.30	0.12	0.15-0.30	0.15	0.15-0.30	0.15	0.2-0.3	0.18	0.2-0.3	0.18
M Acciaio inossidabile	≤270HB	F7030 VP20M	(180-240)	-0.1	0.12	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(160-200)	0.1-0.2	0.10	0.1-0.30	0.12	0.1-0.3	0.15	0.1-0.3	0.18	0.1-0.3	0.20	0.15-0.3	0.22
			(140-180)	0.2-0.25	0.10	0.2-0.30	0.10	0.2-0.3	0.12	0.2-0.3	0.12	0.2-0.3	0.15	0.2-0.3	0.18
K Ghisa	Resistenza alla trazione ≤450MPa	VP15TF VP20M VP10H	(200-300)	-0.1	0.15	-0.1	0.18	-0.1	0.20	-0.1	0.22	-0.1	0.25	-0.15	0.30
			(200-280)	0.1-0.2	0.10	0.1-0.30	0.10	0.1-0.3	0.15	0.1-0.3	0.15	0.1-0.3	0.20	0.15-0.3	0.22
			(180-240)	0.2-0.25	0.10	0.2-0.40	0.10	0.2-0.4	0.12	0.2-0.4	0.12	0.2-0.4	0.15	0.2-0.4	0.18
H Acciaio temprato	-52HRC -58HRC -60HRC	VP15TF VP10H VP05HT	(150-200)	-0.1	0.15	-0.1	0.14	-0.1	0.15	-0.1	0.18	-0.1	0.18	-0.1	0.20
			(120-180)	0.1-0.15	0.10	0.1-0.20	0.12	0.1-0.30	0.12	0.1-0.30	0.14	0.1-0.30	0.14	0.1-0.30	0.15
			(100-180)	0.1-0.15	0.10	0.1-0.20	0.10	0.1-0.30	0.10	0.1-0.30	0.12	0.1-0.30	0.12	0.1-0.30	0.12

(Nota 1) Se si utilizza una larghezza di taglio massima, ridurre i parametri di taglio del 20%.

(Nota 2) Se si utilizza uno sbalzo lungo, ridurre la velocità di avanzamento del 20%.



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