

S-TAW

Fixation de plaquettes innovatrice pour un perçage stable et fiable de petits trous.

■ Plage de diamètres $\varnothing 10,0$ - $\varnothing 18,4$ mm, L/D 1,5, 3, 5, & 8



Type court
(1,5xD)

Type long
(8xD)

Foret à plaquette carbure indexable

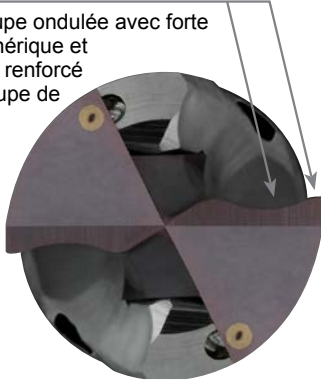
WSTAR Plaquette pour foret

S-TAW

Conçu pour une acuité, une précision et une rigidité extrême

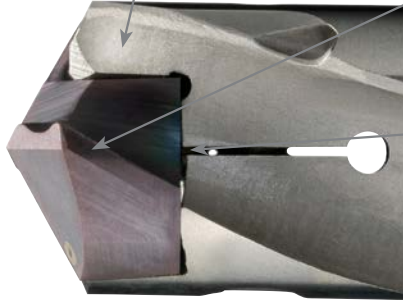
Arête de coupe ondulée

Arête de coupe ondulée avec forte acuité périphérique et point central renforcé pour une coupe de base.



Grande hélice

Sa conception de poche à faible effort améliore la fragmentation des copeaux pour un dégagement plus efficace.



Corps acier

Le corps acier à l'arrière accroît la rigidité.

Localisation du centrage

Ce système unique de Mitsubishi assure une fixation des plus précises.

Profondeur de trou jusqu'à 8D (L/D 1,5, 3,5 et 8 type long)

■ Type en acier rapide (1,5D)

Il est possible de percer des trous peu profonds efficacement et avec une grande précision. Convient pour percer de petits trous à l'aide d'un tour.

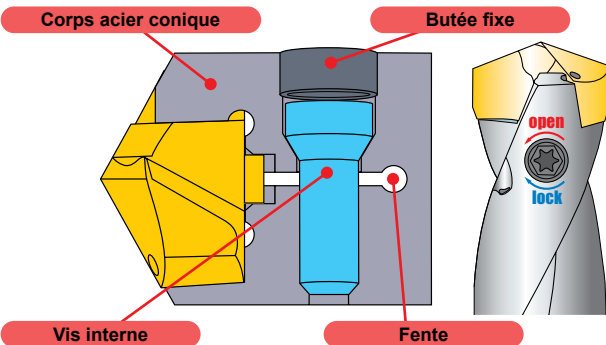


■ Type long (8D)

Le corps est optimisé pour le perçage de trous profonds. Excellente évacuation des copeaux et rigidité du corps, grâce à l'amélioration de l'épaisseur de l'âme et de la largeur d'hélice.



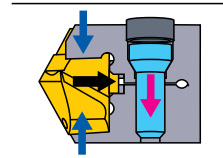
Système unique de fixation ultra rigide Mitsubishi (brevet en cours d'homologation)



<Insertion et retrait des plaquettes>

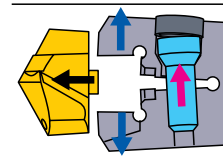
<Serrage>

Serrez la vis interne pour fixer en toute sécurité la plaquette sur le corps conique en acier.



<Desserrage>

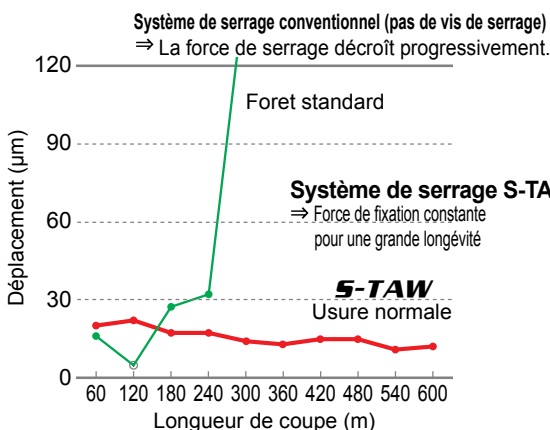
Desserrez la vis interne pour pousser le bloqueur et ouvrir la partie arrière en acier.



Plaquette & corps résistants

Le système de serrage offre une durée de vie exceptionnelle.

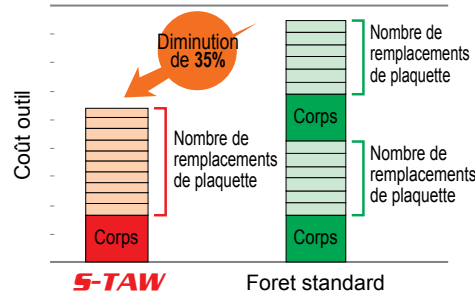
■ Faux-ronflement radial de la plaquette



Des corps et plaquettes résistants réduisent le coût.

■ Effet de la réduction du coût

Comparaison du coût outil pour 600 m de longueur usinée



<Conditions de coupe>
 Pièce : DIN Ck50 (150-180HB)
 Diamètre du foret : $\phi 10$ (L/D=5)
 Vitesse de coupe : 100 m/min
 Avance : 0,25 mm/tour
 Liquide de coupe : huile soluble
 Pression du liquide de coupe : 0,5 MPa (arrosage interne)
 Machine : Centre d'usinage

Nuance de plaquette

VP15TF Nuance de plaquette pour le perçage général **DP5010** Nuance de plaquette pour la fonte

Convient parfaitement à l'usinage d'une large gamme de matériaux, des aciers doux et carbone à l'acier inoxydable et aux fontes.

Nouvelle nuance revêtement PVD. Substrat de carbure métallique revêtu à l'aide d'une méthode propre de technologie cristalline.



Guide opérationnel

Installation de la plaquette

1. Avant d'insérer la plaquette dans le corps, vérifiez qu'il n'y a ni copeaux ni poussière dans la fente de celui-ci. Nettoyez au besoin à l'air comprimé.

2. Utilisez la clé fournie pour desserrer la vis interne et ouvrir l'extrémité du corps. Insérez ensuite la plaquette comme le montre l'illustration 1.

*En serrant la vis intérieure, veillez à ce que la clé ait un étroit contact avec la tête de la vis.

3. Après avoir inséré la plaquette dans le corps, serrez la vis interne en poussant légèrement la plaquette dans la poche, comme dans l'illustration 2, pour la placer et la fixer correctement.

*En serrant la vis intérieure, veillez à ce que la clé ait un étroit contact avec la tête de la vis.

4. Veillez à ne laisser aucun jeu entre la partie inférieure de la plaquette et la fente du corps.

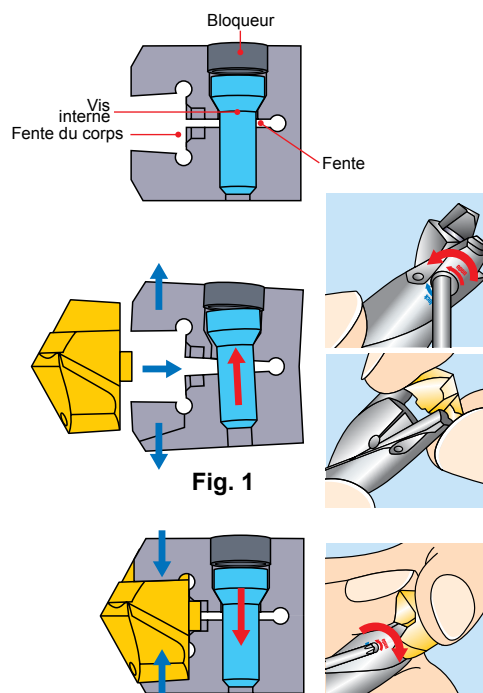
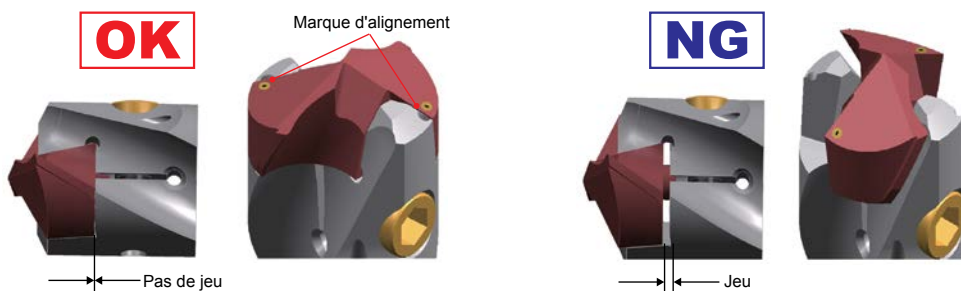


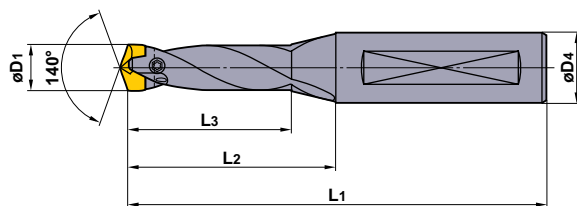
Fig. 2



(Remarque) Si la plaquette n'est pas fixée correctement, cela peut nuire aux performances de perçage et/ou causer des dégâts sur le foret. Pour éviter cela, vérifiez que les marques d'alignement du corps correspondent à celles de la plaquette lors du montage. Pendant l'usinage, utilisez un masque de protection et des dispositifs de sécurité.

S-TAW

| | | | | | |
|------------------------------|-----------------|---------------------|-------|---------------|------------------------|
| Acier carbone Acier allié | Traité Acier | Acier inoxydable | Fonte | Alliage léger | Alliage réfractaire |
| ◎ | | ○ | ◎ | ○ | |




CORPS

| Dia. Foret Plage D1 (mm) | Profondeur du trou (l/d) | Corps | | Dimensions (mm) | | | | ① ② Clé |
|---------------------------------|--------------------------|---------------|-------|-----------------------------------|----------------------|-----------------------|------------------|------------|
| | | Référence | Stock | Longueur effective d'hélice L3 | Longueur utile L2 | Longueur totale L1 | Dia. corps D4 | |
| NEW 10.0 10.4 | 1.5 | STAWSS1000S16 | ● | 22 | 32 | 80 | 16 | ①TIP06F |
| | 3 | STAWSN1000S16 | ● | 37 | 47 | 95 | 16 | |
| | 5 | STAWMN1000S16 | ● | 57 | 67 | 115 | 16 | |
| | 8 | STAWLN1000S16 | ● | 87 | 97 | 145 | 16 | |
| NEW 10.5 10.9 | 1.5 | STAWSS1050S16 | ● | 22 | 32 | 80 | 16 | ①TIP06F |
| | 3 | STAWSN1050S16 | ● | 37 | 47 | 95 | 16 | |
| | 5 | STAWMN1050S16 | ● | 57 | 67 | 115 | 16 | |
| | 8 | STAWLN1050S16 | ● | 87 | 97 | 145 | 16 | |
| NEW 11.0 11.4 | 1.5 | STAWSS1100S16 | ● | 25 | 36 | 84 | 16 | ①TIP06F |
| | 3 | STAWSN1100S16 | ● | 41 | 52 | 100 | 16 | |
| | 5 | STAWMN1100S16 | ● | 66 | 77 | 125 | 16 | |
| | 8 | STAWLN1100S16 | ● | 96 | 107 | 155 | 16 | |
| NEW 11.5 11.9 | 1.5 | STAWSS1150S16 | ● | 25 | 36 | 84 | 16 | ①TIP06F |
| | 3 | STAWSN1150S16 | ● | 41 | 52 | 100 | 16 | |
| | 5 | STAWMN1150S16 | ● | 66 | 77 | 125 | 16 | |
| | 8 | STAWLN1150S16 | ● | 96 | 107 | 155 | 16 | |
| NEW 12.0 12.4 | 1.5 | STAWSS1200S16 | ● | 27 | 39 | 87 | 16 | ①TIP06F |
| | 3 | STAWSN1200S16 | ● | 45 | 57 | 105 | 16 | |
| | 5 | STAWMN1200S16 | ● | 70 | 82 | 130 | 16 | |
| | 8 | STAWLN1200S16 | ● | 105 | 117 | 165 | 16 | |
| NEW 12.5 12.9 | 1.5 | STAWSS1250S16 | ● | 27 | 39 | 87 | 16 | ①TIP06F |
| | 3 | STAWSN1250S16 | ● | 45 | 57 | 105 | 16 | |
| | 5 | STAWMN1250S16 | ● | 70 | 82 | 130 | 16 | |
| | 8 | STAWLN1250S16 | ● | 105 | 117 | 165 | 16 | |
| NEW 13.0 13.4 | 1.5 | STAWSS1300S16 | ● | 30 | 43 | 91 | 16 | ②TIP08W |
| | 3 | STAWSN1300S16 | ● | 49 | 62 | 110 | 16 | |
| | 5 | STAWMN1300S16 | ● | 74 | 87 | 135 | 16 | |
| | 8 | STAWLN1300S16 | ● | 114 | 127 | 175 | 16 | |
| NEW 13.5 13.9 | 1.5 | STAWSS1350S16 | ● | 30 | 43 | 91 | 16 | ②TIP08W |
| | 3 | STAWSN1350S16 | ● | 49 | 62 | 110 | 16 | |
| | 5 | STAWMN1350S16 | ● | 74 | 87 | 135 | 16 | |
| | 8 | STAWLN1350S16 | ● | 114 | 127 | 175 | 16 | |

(Remarque) Veuillez nous contacter pour toute géométrie ne figurant pas dans ce catalogue (autre diamètre ou autre longueur, par exemple).

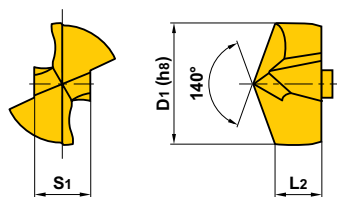
● : Article stocké. □ : Pas en stock, produit sur commande uniquement.

| Dia. Foret Plage D1 (mm) | Profondeur du trou (l/d) | Corps | | Dimensions (mm) | | | |  |
|---------------------------------|--------------------------|----------------------|-------|-----------------------------|----------------|-----------------|------------|---|
| | | Référence | Stock | Longueur effective d'hélice | Longueur utile | Longueur totale | Dia. corps | |
| | | | | L3 | L2 | L1 | D4 | Clé |
| NEW 14.0 14.4 | 1.5 | STAWSS1400S16 | ● | 31 | 45 | 93 | 16 | TIP08W |
| | 3 | STAWSN1400S16 | ● | 53 | 67 | 115 | 16 | |
| | 5 | STAWMN1400S16 | ● | 83 | 97 | 145 | 16 | |
| | NEW 8 | STAWLN1400S16 | ● | 122 | 137 | 185 | 16 | |
| NEW 14.5 14.9 | 1.5 | STAWSS1450S16 | ● | 31 | 45 | 93 | 16 | TIP08W |
| | 3 | STAWSN1450S16 | ● | 53 | 67 | 115 | 16 | |
| | 5 | STAWMN1450S16 | ● | 83 | 97 | 145 | 16 | |
| | NEW 8 | STAWLN1450S16 | ● | 122 | 137 | 185 | 16 | |
| NEW 15.0 15.4 | 1.5 | STAWSS1500S20 | ● | 33 | 48 | 98 | 20 | TIP08W |
| | 3 | STAWSN1500S20 | ● | 60 | 75 | 125 | 20 | |
| | 5 | STAWMN1500S20 | ● | 90 | 105 | 155 | 20 | |
| | NEW 8 | STAWLN1500S20 | ● | 130 | 148 | 198 | 20 | |
| NEW 15.5 16.4 | 1.5 | STAWSS1600S20 | ● | 34 | 50 | 100 | 20 | TIP10W |
| | 3 | STAWSN1600S20 | ● | 60 | 80 | 130 | 20 | |
| | 5 | STAWMN1600S20 | ● | 90 | 115 | 165 | 20 | |
| | 8 | STAWLN1600S20 | ● | 138 | 158 | 208 | 20 | |
| NEW 16.5 17.4 | 1.5 | STAWSS1700S20 | ● | 36 | 53 | 103 | 20 | TIP10W |
| | 3 | STAWSN1700S20 | ● | 61 | 85 | 135 | 20 | |
| | 5 | STAWMN1700S20 | ● | 95 | 120 | 170 | 20 | |
| | 8 | STAWLN1700S20 | ● | 146 | 166 | 216 | 20 | |
| NEW 17.5 18.4 | 1.5 | STAWSS1800S20 | ● | 37 | 55 | 105 | 20 | TIP10W |
| | 3 | STAWSN1800S20 | ● | 64 | 90 | 140 | 20 | |
| | 5 | STAWMN1800S20 | ● | 100 | 125 | 175 | 20 | |
| | 8 | STAWLN1800S20 | ● | 154 | 174 | 224 | 20 | |

(Remarque) Veuillez nous contacter pour toute géométrie ne figurant pas dans ce catalogue (autre diamètre ou autre longueur, par exemple).

S-TAW

PLAQUETTES



| Référence | Stock | | Dimensions (mm) | | | Corps correspondant |
|--------------------|--------|-------|-----------------|-----|-----|--|
| | VP15TF | VP10H | D1 | L2 | S1 | |
| STAWN1000TH | ● | □ | 10.0 | 3.8 | 4.6 | STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16 |
| 1010TH | ● | □ | 10.1 | 3.8 | 4.6 | |
| 1020TH | ● | □ | 10.2 | 3.8 | 4.6 | |
| 1030TH | ● | □ | 10.3 | 3.8 | 4.6 | |
| 1040TH | ● | □ | 10.4 | 3.8 | 4.6 | |
| 1050TH | ● | □ | 10.5 | 4.0 | 4.8 | STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16 |
| 1060TH | ● | □ | 10.6 | 4.0 | 4.8 | |
| 1070TH | ● | □ | 10.7 | 4.0 | 4.8 | |
| 1080TH | ● | □ | 10.8 | 4.0 | 4.8 | |
| 1090TH | ● | □ | 10.9 | 4.0 | 4.8 | |
| 1100TH | ● | □ | 11.0 | 4.2 | 5.1 | STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16 |
| 1110TH | ● | □ | 11.1 | 4.2 | 5.1 | |
| 1120TH | ● | □ | 11.2 | 4.2 | 5.1 | |
| 1130TH | ● | □ | 11.3 | 4.2 | 5.1 | |
| 1140TH | ● | □ | 11.4 | 4.2 | 5.1 | |
| 1150TH | ● | □ | 11.5 | 4.4 | 5.3 | STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16 |
| 1160TH | ● | □ | 11.6 | 4.4 | 5.3 | |
| 1170TH | ● | □ | 11.7 | 4.4 | 5.3 | |
| 1180TH | ● | □ | 11.8 | 4.4 | 5.3 | |
| 1190TH | ● | □ | 11.9 | 4.4 | 5.3 | |
| 1200TH | ● | □ | 12.0 | 4.6 | 5.5 | STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16 |
| 1210TH | ● | □ | 12.1 | 4.6 | 5.5 | |
| 1220TH | ● | □ | 12.2 | 4.6 | 5.5 | |
| 1230TH | ● | □ | 12.3 | 4.6 | 5.5 | |
| 1240TH | ● | □ | 12.4 | 4.6 | 5.5 | |
| 1250TH | ● | □ | 12.5 | 4.8 | 5.8 | STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16 |
| 1260TH | ● | □ | 12.6 | 4.8 | 5.8 | |
| 1270TH | ● | □ | 12.7 | 4.8 | 5.8 | |
| 1280TH | ● | □ | 12.8 | 4.8 | 5.8 | |
| 1290TH | ● | □ | 12.9 | 4.8 | 5.8 | |
| 1300TH | ● | □ | 13.0 | 4.9 | 6.0 | STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16 |
| 1310TH | ● | □ | 13.1 | 4.9 | 6.0 | |
| 1320TH | ● | □ | 13.2 | 4.9 | 6.0 | |
| 1330TH | ● | □ | 13.3 | 4.9 | 6.0 | |
| 1340TH | ● | □ | 13.4 | 4.9 | 6.0 | |
| 1350TH | ● | □ | 13.5 | 5.1 | 6.2 | STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16 |
| 1360TH | ● | □ | 13.6 | 5.1 | 6.2 | |
| 1370TH | ● | □ | 13.7 | 5.1 | 6.2 | |
| 1380TH | ● | □ | 13.8 | 5.1 | 6.2 | |
| 1390TH | ● | □ | 13.9 | 5.1 | 6.2 | |

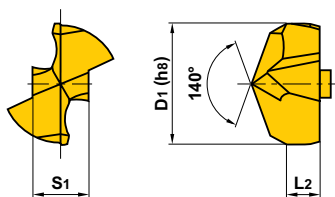
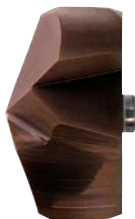
● : Article stocké. □ : Pas en stock, produit sur commande uniquement.
 (1 plaquette réversible par boîte)

| Référence | Stock | | Dimensions (mm) | | | Corps correspondant |
|--------------------|--------|-------|-----------------|-----|-----|--|
| | VP15TF | VP10H | D1 | L2 | S1 | |
| STAWN1400TH | ● | | 14.0 | 5.3 | 6.4 | STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16 |
| 1410TH | ● | | 14.1 | 5.3 | 6.4 | |
| 1420TH | ● | | 14.2 | 5.3 | 6.4 | |
| 1430TH | ● | | 14.3 | 5.3 | 6.4 | |
| 1440TH | ● | | 14.4 | 5.3 | 6.4 | |
| 1450TH | ● | | 14.5 | 5.5 | 6.7 | STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16 |
| 1460TH | ● | | 14.6 | 5.5 | 6.7 | |
| 1470TH | ● | | 14.7 | 5.5 | 6.7 | |
| 1480TH | ● | | 14.8 | 5.5 | 6.7 | |
| 1490TH | ● | | 14.9 | 5.5 | 6.7 | |
| 1500TH | ● | | 15.0 | 5.7 | 6.9 | STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20 |
| 1510TH | ● | | 15.1 | 5.7 | 6.9 | |
| 1520TH | ● | | 15.2 | 5.7 | 6.9 | |
| 1530TH | ● | | 15.3 | 5.7 | 6.9 | |
| 1540TH | ● | | 15.4 | 5.7 | 6.9 | |
| NEW 1550T | ● | | 15.5 | 5.9 | 7.1 | STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20 |
| NEW 1560T | ● | | 15.6 | 5.9 | 7.1 | |
| NEW 1570T | ● | | 15.7 | 5.9 | 7.1 | |
| NEW 1580T | ● | | 15.8 | 5.9 | 7.1 | |
| NEW 1590T | ● | | 15.9 | 5.9 | 7.1 | |
| NEW 1600T | ● | | 16.0 | 5.9 | 7.1 | |
| NEW 1610T | ● | | 16.1 | 5.9 | 7.1 | |
| NEW 1620T | ● | | 16.2 | 5.9 | 7.1 | |
| NEW 1630T | ● | | 16.3 | 5.9 | 7.1 | |
| NEW 1640T | ● | | 16.4 | 5.9 | 7.1 | |
| NEW 1650T | ● | | 16.5 | 6.3 | 7.6 | STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20 |
| NEW 1660T | ● | | 16.6 | 6.3 | 7.6 | |
| NEW 1670T | ● | | 16.7 | 6.3 | 7.6 | |
| NEW 1680T | ● | | 16.8 | 6.3 | 7.6 | |
| NEW 1690T | ● | | 16.9 | 6.3 | 7.6 | |
| NEW 1700T | ● | | 17.0 | 6.3 | 7.6 | |
| NEW 1710T | ● | | 17.1 | 6.3 | 7.6 | |
| NEW 1720T | ● | | 17.2 | 6.3 | 7.6 | |
| NEW 1730T | ● | | 17.3 | 6.3 | 7.6 | |
| NEW 1740T | ● | | 17.4 | 6.3 | 7.6 | |
| NEW 1750T | ● | | 17.5 | 6.7 | 8.1 | STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20 |
| NEW 1760T | ● | | 17.6 | 6.7 | 8.1 | |
| NEW 1770T | ● | | 17.7 | 6.7 | 8.1 | |
| NEW 1780T | ● | | 17.8 | 6.7 | 8.1 | |
| NEW 1790T | ● | | 17.9 | 6.7 | 8.1 | |
| NEW 1800T | ● | | 18.0 | 6.7 | 8.1 | |
| NEW 1810T | ● | | 18.1 | 6.7 | 8.1 | |
| NEW 1820T | ● | | 18.2 | 6.7 | 8.1 | |
| NEW 1830T | ● | | 18.3 | 6.7 | 8.1 | |
| NEW 1840T | ● | | 18.4 | 6.7 | 8.1 | |

S-TAW

PLAQUETTES

(Pour fontes)



| Référence | Stock | | Dimensions (mm) | | | Corps correspondant |
|------------------------|--------|--|-----------------|-----|-----|--|
| | DP5010 | | D1 | L2 | S1 | |
| NEW STAWK1000TG | ● | | 10.0 | 3.3 | 4.6 | STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16 |
| NEW 1010TG | ● | | 10.1 | 3.3 | 4.6 | |
| NEW 1020TG | ● | | 10.2 | 3.3 | 4.6 | |
| NEW 1030TG | ● | | 10.3 | 3.3 | 4.6 | |
| NEW 1040TG | ● | | 10.4 | 3.3 | 4.6 | |
| NEW 1050TG | ● | | 10.5 | 3.5 | 4.8 | STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16 |
| NEW 1060TG | ● | | 10.6 | 3.5 | 4.8 | |
| NEW 1070TG | ● | | 10.7 | 3.5 | 4.8 | |
| NEW 1080TG | ● | | 10.8 | 3.5 | 4.8 | |
| NEW 1090TG | ● | | 10.9 | 3.5 | 4.8 | |
| NEW 1100TG | ● | | 11.0 | 3.7 | 5.1 | STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16 |
| NEW 1110TG | ● | | 11.1 | 3.7 | 5.1 | |
| NEW 1120TG | ● | | 11.2 | 3.7 | 5.1 | |
| NEW 1130TG | ● | | 11.3 | 3.7 | 5.1 | |
| NEW 1140TG | ● | | 11.4 | 3.7 | 5.1 | |
| NEW 1150TG | ● | | 11.5 | 3.9 | 5.3 | STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16 |
| NEW 1160TG | ● | | 11.6 | 3.9 | 5.3 | |
| NEW 1170TG | ● | | 11.7 | 3.9 | 5.3 | |
| NEW 1180TG | ● | | 11.8 | 3.9 | 5.3 | |
| NEW 1190TG | ● | | 11.9 | 3.9 | 5.3 | |
| NEW 1200TG | ● | | 12.0 | 4.1 | 5.5 | STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16 |
| NEW 1210TG | ● | | 12.1 | 4.1 | 5.5 | |
| NEW 1220TG | ● | | 12.2 | 4.1 | 5.5 | |
| NEW 1230TG | ● | | 12.3 | 4.1 | 5.5 | |
| NEW 1240TG | ● | | 12.4 | 4.1 | 5.5 | |
| NEW 1250TG | ● | | 12.5 | 4.2 | 5.8 | STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16 |
| NEW 1260TG | ● | | 12.6 | 4.2 | 5.8 | |
| NEW 1270TG | ● | | 12.7 | 4.2 | 5.8 | |
| NEW 1280TG | ● | | 12.8 | 4.2 | 5.8 | |
| NEW 1290TG | ● | | 12.9 | 4.2 | 5.8 | |
| NEW 1300TG | ● | | 13.0 | 4.4 | 6.0 | STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16 |
| NEW 1310TG | ● | | 13.1 | 4.4 | 6.0 | |
| NEW 1320TG | ● | | 13.2 | 4.4 | 6.0 | |
| NEW 1330TG | ● | | 13.3 | 4.4 | 6.0 | |
| NEW 1340TG | ● | | 13.4 | 4.4 | 6.0 | |
| NEW 1350TG | ● | | 13.5 | 4.6 | 6.2 | STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16 |
| NEW 1360TG | ● | | 13.6 | 4.6 | 6.2 | |
| NEW 1370TG | ● | | 13.7 | 4.6 | 6.2 | |
| NEW 1380TG | ● | | 13.8 | 4.6 | 6.2 | |
| NEW 1390TG | ● | | 13.9 | 4.6 | 6.2 | |

● : Article stocké. (1 plaquette réversible par boîte)

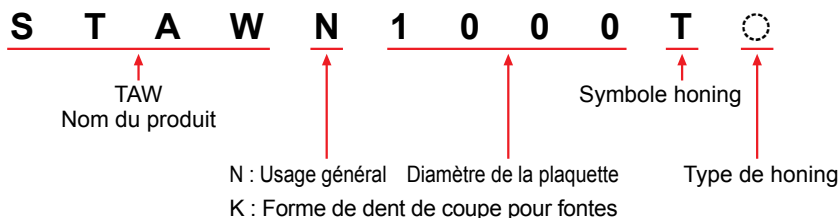
| Référence | Stock | | Dimensions (mm) | | | Corps correspondant |
|------------------------|--------|--|-----------------|-----|-----|--|
| | DP5010 | | D1 | L2 | S1 | |
| NEW STAWK1400TG | ● | | 14.0 | 4.8 | 6.4 | STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16 |
| NEW 1410TG | ● | | 14.1 | 4.8 | 6.4 | |
| NEW 1420TG | ● | | 14.2 | 4.8 | 6.4 | |
| NEW 1430TG | ● | | 14.3 | 4.8 | 6.4 | |
| NEW 1440TG | ● | | 14.4 | 4.8 | 6.4 | |
| NEW 1450TG | ● | | 14.5 | 5.0 | 6.7 | STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16 |
| NEW 1460TG | ● | | 14.6 | 5.0 | 6.7 | |
| NEW 1470TG | ● | | 14.7 | 5.0 | 6.7 | |
| NEW 1480TG | ● | | 14.8 | 5.0 | 6.7 | |
| NEW 1490TG | ● | | 14.9 | 5.0 | 6.7 | |
| NEW 1500TG | ● | | 15.0 | 5.2 | 6.9 | STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20 |
| NEW 1510TG | ● | | 15.1 | 5.2 | 6.9 | |
| NEW 1520TG | ● | | 15.2 | 5.2 | 6.9 | |
| NEW 1530TG | ● | | 15.3 | 5.2 | 6.9 | |
| NEW 1540TG | ● | | 15.4 | 5.2 | 6.9 | |
| NEW 1550TG | ● | | 15.5 | 5.3 | 7.1 | STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20 |
| NEW 1560TG | ● | | 15.6 | 5.3 | 7.1 | |
| NEW 1570TG | ● | | 15.7 | 5.3 | 7.1 | |
| NEW 1580TG | ● | | 15.8 | 5.3 | 7.1 | |
| NEW 1590TG | ● | | 15.9 | 5.3 | 7.1 | |
| NEW 1600TG | ● | | 16.0 | 5.3 | 7.1 | |
| NEW 1610TG | ● | | 16.1 | 5.3 | 7.1 | |
| NEW 1620TG | ● | | 16.2 | 5.3 | 7.1 | |
| NEW 1630TG | ● | | 16.3 | 5.3 | 7.1 | |
| NEW 1640TG | ● | | 16.4 | 5.3 | 7.1 | |
| NEW 1650TG | ● | | 16.5 | 5.7 | 7.6 | STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20 |
| NEW 1660TG | ● | | 16.6 | 5.7 | 7.6 | |
| NEW 1670TG | ● | | 16.7 | 5.7 | 7.6 | |
| NEW 1680TG | ● | | 16.8 | 5.7 | 7.6 | |
| NEW 1690TG | ● | | 16.9 | 5.7 | 7.6 | |
| NEW 1700TG | ● | | 17.0 | 5.7 | 7.6 | |
| NEW 1710TG | ● | | 17.1 | 5.7 | 7.6 | |
| NEW 1720TG | ● | | 17.2 | 5.7 | 7.6 | |
| NEW 1730TG | ● | | 17.3 | 5.7 | 7.6 | |
| NEW 1740TG | ● | | 17.4 | 5.7 | 7.6 | |
| NEW 1750TG | ● | | 17.5 | 6.0 | 8.1 | STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20 |
| NEW 1760TG | ● | | 17.6 | 6.0 | 8.1 | |
| NEW 1770TG | ● | | 17.7 | 6.0 | 8.1 | |
| NEW 1780TG | ● | | 17.8 | 6.0 | 8.1 | |
| NEW 1790TG | ● | | 17.9 | 6.0 | 8.1 | |
| NEW 1800TG | ● | | 18.0 | 6.0 | 8.1 | |
| NEW 1810TG | ● | | 18.1 | 6.0 | 8.1 | |
| NEW 1820TG | ● | | 18.2 | 6.0 | 8.1 | |
| NEW 1830TG | ● | | 18.3 | 6.0 | 8.1 | |
| NEW 1840TG | ● | | 18.4 | 6.0 | 8.1 | |

S-TAW

LARGEUR LISTEL

Si une plaquette avec une préparation autre est requise, veuillez commander en utilisant les symboles ci-dessous.

(Référence plaquette)



(Honing standard)

| Type de honing | Largeur listel (mm) |
|----------------|---------------------|
| F | 0 |
| G | 0.02—0.05 |
| H(Standard) | 0.05—0.10 |
| - | 0.10—0.15 |
| K | 0.15—0.20 |
| S | 0.20—0.25 |
| M | 0.25—0.30 |

CONDITIONS DE COUPE RECOMMANDÉES

| Matière à usiner | Diamètre foret Conditions Dureté | φ10.0—φ12.9 | | φ13.0—φ13.9 | | φ14.0—φ15.4 | | φ15.5—φ18.4 | |
|---------------------------|--|-----------------------------|---------------------|-----------------------------|---------------------|-----------------------------|---------------------|-----------------------------|---------------------|
| | | Vitesse de coupe (m/min) | Avance (mm/tr) | Vitesse de coupe (m/min) | Avance (mm/tr) | Vitesse de coupe (m/min) | Avance (mm/tr) | Vitesse de coupe (m/min) | Avance (mm/tr) |
| P Acier doux | ≤180HB | 80 (60—100) | 0.20 (0.15—0.25) | 90 (70—110) | 0.25 (0.20—0.30) | 100 (80—120) | 0.30 (0.25—0.35) | 100 (80—120) | 0.35 (0.25—0.40) |
| | 180—280HB | 80 (60—100) | 0.20 (0.15—0.25) | 90 (70—110) | 0.25 (0.20—0.30) | 100 (80—120) | 0.30 (0.25—0.35) | 100 (80—120) | 0.35 (0.25—0.40) |
| | 280—350HB | 70 (60—90) | 0.20 (0.15—0.25) | 80 (60—100) | 0.25 (0.20—0.30) | 90 (70—110) | 0.25 (0.20—0.30) | 90 (70—110) | 0.30 (0.20—0.35) |
| M Acier inoxydable | ≤200HB | 40 (30—50) | 0.13 (0.10—0.16) | 50 (40—60) | 0.15 (0.12—0.18) | 60 (50—70) | 0.17 (0.14—0.20) | 60 (50—70) | 0.17 (0.14—0.20) |
| K Fonte grise | Résistance à la traction ≤350MPa | 80 (60—100) | 0.20 (0.15—0.25) | 90 (70—110) | 0.25 (0.20—0.30) | 100 (80—120) | 0.30 (0.25—0.35) | 120 (80—140) | 0.45 (0.35—0.55) |
| | Résistance à la traction ≤450MPa | 70 (60—90) | 0.20 (0.15—0.25) | 80 (60—100) | 0.25 (0.20—0.30) | 90 (70—110) | 0.30 (0.25—0.35) | 100 (80—120) | 0.35 (0.25—0.40) |



(Remarque 1) Si vous utilisez un foret pour percer un trou d'une profondeur de 1,5D, vous pouvez augmenter la vitesse d'avance de 20 % environ.

(Remarque 2) Si vous utilisez un foret pour percer un trou d'une profondeur de 8D, vous pouvez diminuer la vitesse de coupe de 20 % environ.

(Remarque 3) Si vous utilisez un foret pour percer un trou d'une profondeur de 8D, il est recommandé de percer un trou pilote de la même taille.

(Remarque 4) Pour l'acier inoxydable, veuillez utiliser un liquide de coupe interne. (L'usinage avec micro-pulvérisation et brouillard d'huile n'est pas recommandé).

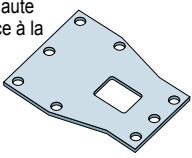
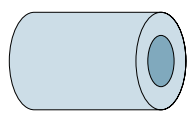
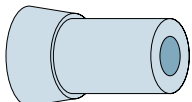
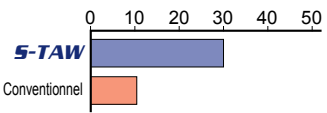
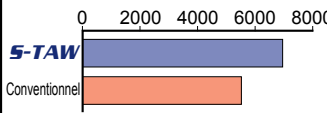
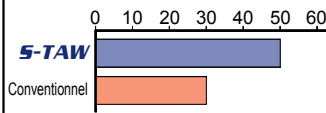
PIÈCES DÉTACHÉES

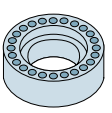
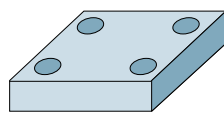
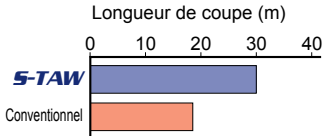
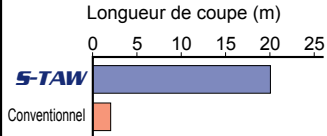
| Corps correspondant | Référence du pack (Vis interne & stoppeur) |  |  |
|-------------------------------|--|--|---|
| | | Bloqueur | Vis interne |
| STAWSS/SN/MN/LN100S16 | WS203107TPS-35LH | WS203107TPS | WS35LH |
| STAWSS/SN/MN/LN105S16 | WS203107TPS-35LH | WS203107TPS | WS35LH |
| STAWSS/SN/MN/LN1100S16 | WS203108TPS-35LH | WS203108TPS | WS35LH |
| STAWSS/SN/MN/LN1150S16 | WS203108TPS-35LH | WS203108TPS | WS35LH |
| STAWSS/SN/MN/LN1200S16 | WS203108TPS-35LH | WS203108TPS | WS35LH |
| STAWSS/SN/MN/LN1250S16 | WS203108TPS-35LH | WS203108TPS | WS35LH |
| STAWSS/SN/MN/LN1300S16 | WS253909TPS-45LH | WS253909TPS | WS45LH |
| STAWSS/SN/MN/LN1350S16 | WS253909TPS-45LH | WS253909TPS | WS45LH |
| STAWSS/SN/MN/LN1400S16 | WS253909TPS-45LH | WS253909TPS | WS45LH |
| STAWSS/SN/MN/LN1450S16 | WS253909TPS-45LH | WS253909TPS | WS45LH |
| STAWSS/SN/MN/LN1500S20 | WS253909TPS-45LH | WS253909TPS | WS45LH |
| STAWSS/SN/MN/LN1600S20 | WS304912TPS-55LH | WS304912TPS | WS55LH |
| STAWSS/SN/MN/LN1700S20 | WS304912TPS-55LH | WS304912TPS | WS55LH |
| STAWSS/SN/MN/LN1800S20 | WS304912TPS-55LH | WS304912TPS | WS55LH |

* Couple de serrage (N • m) : WS35LH=1,2, WS45LH=2,0, WS55LH=2,5

(Remarque) La vis interne, le bloqueur et le manuel d'utilisation sont inclus dans l'emballage. Veuillez remplacer les pièces détachées conformément au Manuel d'utilisation.

Exemples d'application

| Corps | | STAWMN1000S16 | STAWSS1150S16 | STAWMN1350S16 |
|---------------------|--------------------------|--|--|---|
| Plaquette (nuance) | | STAWN1000TH (VP15TF) | STAWN1150TH (VP15TF) | STAWN1350TH (VP15TF) |
| Pièce | | Acier à haute résistance à la traction  | Acier roulements (SUJ2)  | Acier carbone  |
| Composant | | Armature | Douille | Axe |
| Conditions de coupe | Vitesse de coupe (m/min) | 100 | 62 | 95 |
| | Avance (mm/tour) | 0.25 | 0.17 | 0.25 |
| | Rotation (mm/tour) | 3183 | 1716 | 2240 |
| | Avance linéaire (mm/min) | 796 | 292 | 560 |
| Liquide de coupe | | Huile soluble (arrosage interne) | Huile soluble (liquide de coupe interne) | Huile soluble (liquide de coupe interne) |
| Machine | | Centre d'usinage | Tour | Tour |
| Résultat | | Longueur de coupe (m) 0 10 20 30 40 50  | Nombre de trous 0 2000 4000 6000 8000  | Longueur de coupe (m) 0 10 20 30 40 50 60  |

| Corps | | STAWMN1100S16 | STAWSN1450S16 |
|---------------------|--------------------------|---|--|
| Plaquette (nuance) | | STAWN1100TH (VP15TF) | STAWK1450TG(DP5010) |
| Pièce | | Acier allié  | Fonte (FC250)  |
| Composant | | Pièces machine | Plaque machine |
| Conditions de coupe | Vitesse de coupe (m/min) | 70 | 180 |
| | Avance (mm/tour) | 0.25 | 0.4 |
| | Rotation (mm/tour) | 2025 | 3951 |
| | Avance linéaire (mm/min) | 506 | 1580 |
| Liquide de coupe | | Huile soluble (liquide de coupe interne) | Huile soluble (liquide de coupe interne) |
| Machine | | Centre d'usinage | Centre d'usinage |
| Résultat | | Longueur de coupe (m) 0 10 20 30 40  | Longueur de coupe (m) 0 5 10 15 20 25  |



www.mitsubishicarbide.com

MMC HARTMETALL GmbH
 Comeniusstr. 2, 40670 Meerbusch, Germany
 Tel. +49-2159-9189-0 Fax +49-2159-918966
 e-mail admin@mmchg.de

MITSUBISHI MATERIALS ESPAÑA, S.A.
 Calle Emperador 2, 46136 Museros/Valencia, Spain
 Tel. +34-96-144-1711 Fax +34-96-144-3786
 e-mail mme@mmevalencia.com

MMC HARDMETAL RUSSIA OOO LTD.
 UL. Bolschaja Semenovskaya, 11, bld 5, 107023 Moscow, Russia
 Tel. +7-495-72558-85 Fax +7-495-98139-73
 e-mail info@mmc-carbide.ru

MMC HARDMETAL U.K. LTD.
 Mitsubishi House, Galena Close, Tamworth, Staffs. B77 4AS, U.K.
 Tel. +44-1827-312312 Fax +44-1827-312314
 e-mail sales@mitsubishicarbide.co.uk

MMC ITALIA S.r.l.
 V.le Delle Industrie 2, 20020 Milano, Italy
 Tel. +39-02 93 77 03 1 Fax +39-02 93 58 90 93
 e-mail info@mmc-italia.it

MMC METAL FRANCE s.a.r.l.
 6, Rue Jacques Monod, 91400 Orsay, France
 Tel. +33-1-69 35 53 53 Fax +33-1-69 35 53 50
 e-mail mmfsales@mmc-metal-france.fr

MMC HARDMETAL POLAND SP. z o.o.
 Al. Armii Krajowej 61, 50-541 Wrocław, Poland
 Tel. +48-71335-16-20 Fax +48-71335-16-21
 e-mail sales@mitsubishicarbide.com.pl

