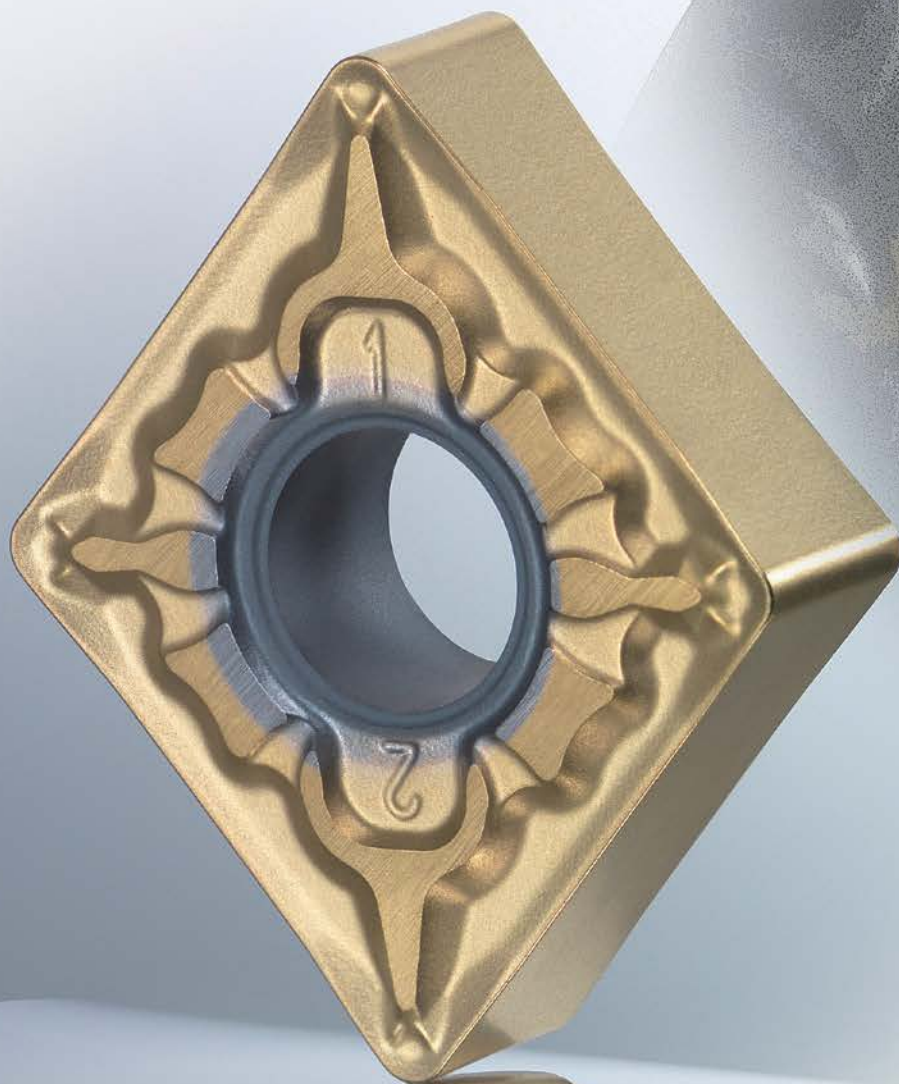


Grado Cermet con rivestimento PVD per acciaio

MIP3025

Produce eccellenti finiture superficiali.



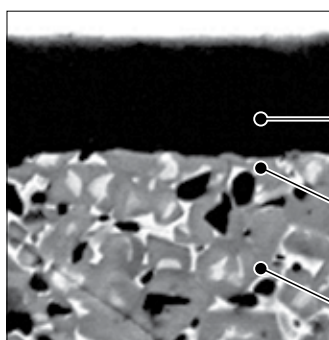
Grado Cermet con rivestimento PVD per acciaio

Grado Cermet con rivestimento PVD per acciaio

MP3025

MP3025 ha un'eccellente resistenza all'usura e alla frattura.

Grazie alla migliorata resistenza all'adesione, MP3025 garantisce finiture superficiali eccellenti, ideale per produzione in serie di piccole parti.



Il rivestimento PVD con componenti Ti fornisce eccellente resistenza all'usura e alla saldatura.

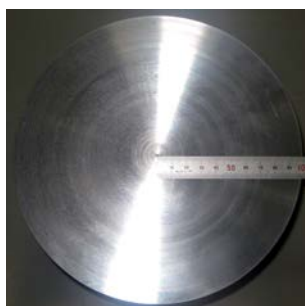
Il substrato fornisce un'eccellente capacità di adesione per lo strato di rivestimento.

Substrato con alta resistenza alla frattura e allo shock termico.

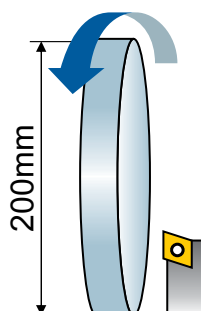
Finiture di alta qualità a bassa velocità.

MP3025 produce migliori finiture superficiali a basse velocità di taglio rispetto ai gradi Cermet PVD della concorrenza.

MP3025



Tradizionale



<Condizioni di taglio>

Pezzo da lavorare : S25C

Giri : n=398 min.⁻¹


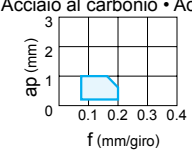

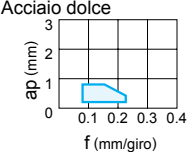

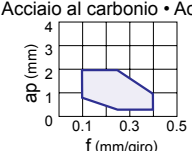

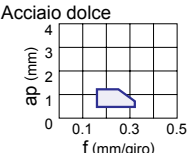

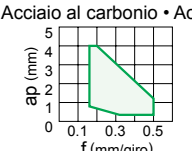
(Esterno: vc=250 m/min.)

Profondità di taglio: ap=1,5 mm


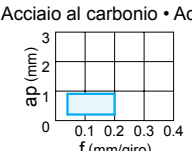

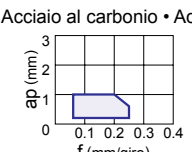

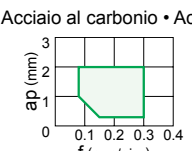
Avanzamento : f=0,15 mm/giro.

Taglio a umido

Rompitrucoli per il taglio dell'acciaio (inserti negativi)

Applicazione	Tolleranza	Rompitrucoli	Caratteristiche	Geometria
Finitura	M	FH 	Prima scelta per la finitura dell'acciaio inox, acciaio legato e acciaio inossidabile Rompitrucoli bilaterale. Controllo truciolo stabile anche a piccole profondità di taglio.	Acciaio al carbonio • Acciaio legato  Punta 12° Fianco 12°
	M	FY 	Prima scelta per la finitura dell'acciaio da costruzione. Rompitrucoli bilaterale. Controllo efficace dei trucioli che tendono ad incollare. Adatto alla finitura dell'acciaio da costruzione.	Acciaio dolce  Punta 15° Fianco 15°
Taglio leggero	M	LP 	Prima scelta per la lavorazione leggera dell'acciaio al carbonio e dell'acciaio legato Controllo dei trucioli stabile nella leggera asportazione. Il tagliente curvo consente una scorrevole evacuazione dei trucioli.	Acciaio al carbonio • Acciaio legato  Punta 15° 0.1 Fianco 11° 0.2
	M	SY 	Prima scelta per la lavorazione leggera dell'acciaio dolce Rompitrucoli bilaterale. Controllo efficace dei trucioli che tendono ad incollare. Adatto alla lavorazione leggera.	Acciaio dolce  Punta 10° Fianco 10°
Taglio medio	M	MP 	Prima scelta per la lavorazione media dell'acciaio al carbonio e dell'acciaio legato Adatto alla lavorazione da media a leggera. Geometria del rompitrucoli adatta per la copiatura e la retro-tornitura. Equilibrio ottimale tra taglienza e resistenza alla rottura.	Acciaio al carbonio • Acciaio legato  Punta 15° 0.15 Fianco 11° 0.2


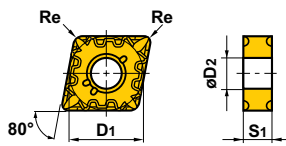

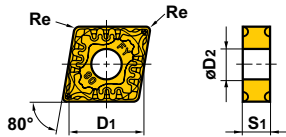

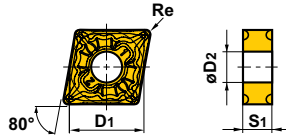

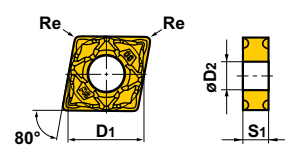

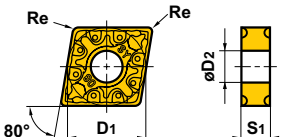

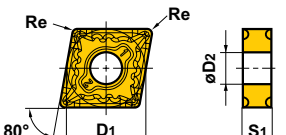

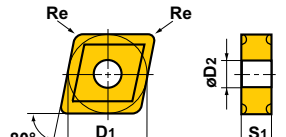

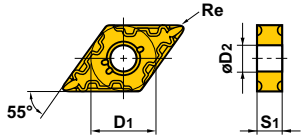
Rompitrucoli per il taglio dell'acciaio (inserti positivi)


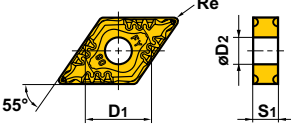

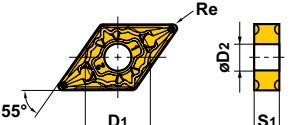

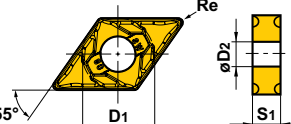

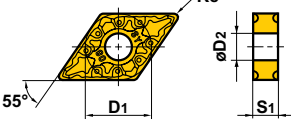

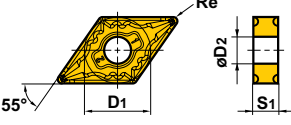

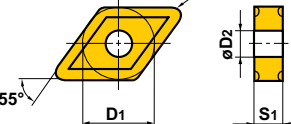

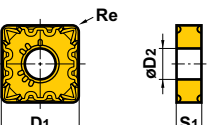

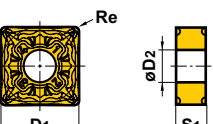
Applicazione	Tolleranza	Rompitrucoli	Caratteristiche	Geometria
Finitura	M	NEW FP 	Prima scelta per la finitura di acciaio al carbonio e acciaio legato La protuberanza sulla punta del rompitrucoli controlla i trucioli anche su piccole profondità di taglio. 5° 7° Inserto positivo	Acciaio al carbonio • Acciaio legato  Punta 6° Fianco 6°
Taglio leggero	M	NEW LP 	Prima scelta per il taglio leggero di acciaio al carbonio e acciaio legato Eccellente affilatura del tagliente grazie al grande angolo di spoglia. Evita la saldatura dei trucioli dell'inserto per garantire buone finiture superficiali. Rompitrucolo ottimizzato per un'ampia gamma di controllo dei trucioli. 5° 7° Inserto positivo	Acciaio al carbonio • Acciaio legato  Punta 18° Fianco 8°
Taglio medio	M	NEW MP 	Prima scelta per il taglio medio di acciaio al carbonio e acciaio legato Il pianetto di rinforzo produce un'eccellente resistenza all'usura e alla rottura. L'ampia tasca riduce le vibrazioni e l'ostruzione dei trucioli e evita anche l'aumento nella resistenza da taglio anche a profondità di taglio elevate. 5° 7° Inserto positivo	Acciaio al carbonio • Acciaio legato  Punta 18° 0.1 Fianco 18° 0.1

MP3025

INSERTI

● Inserti negativi (con foro)


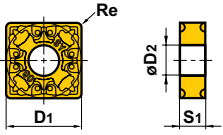

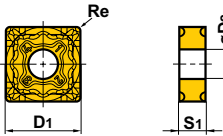

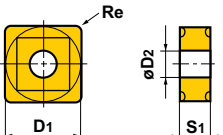

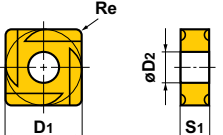

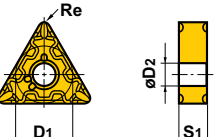

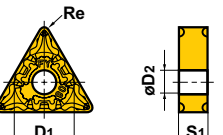

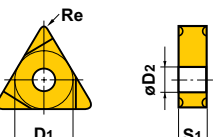

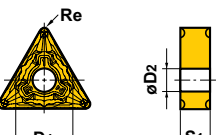
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio di finitura	CNMG120402-FH	M	●	12.7	4.76	0.2	5.16	
	120404-FH	M	●	12.7	4.76	0.4	5.16	
	120408-FH	M	●	12.7	4.76	0.8	5.16	
 Taglio di finitura	CNMG120404-FY	M	●	12.7	4.76	0.4	5.16	
	120408-FY	M	●	12.7	4.76	0.8	5.16	
 Taglio leggero	CNMG120404-LP	M	●	12.7	4.76	0.4	5.16	
	120408-LP	M	●	12.7	4.76	0.8	5.16	
 Taglio leggero (Wiper)	CNMG120404-SW	M	●	12.7	4.76	0.4	5.16	
	120408-SW	M	●	12.7	4.76	0.8	5.16	
	120412-SW	M	●	12.7	4.76	1.2	5.16	
 Taglio leggero	CNMG120404-SY	M	●	12.7	4.76	0.4	5.16	
	120408-SY	M	●	12.7	4.76	0.8	5.16	
 Taglio medio	CNMG120404-MP	M	●	12.7	4.76	0.4	5.16	
	120408-MP	M	●	12.7	4.76	0.8	5.16	
	120412-MP	M	●	12.7	4.76	1.2	5.16	
 Taglio medio	CNMG120404	M	●	12.7	4.76	0.4	5.16	
	120408	M	●	12.7	4.76	0.8	5.16	
 Taglio di finitura	DNMG150402-FH	M	●	12.7	4.76	0.2	5.16	
	150404-FH	M	●	12.7	4.76	0.4	5.16	
	150408-FH	M	●	12.7	4.76	0.8	5.16	
	150602-FH	M	●	12.7	6.35	0.2	5.16	
	150604-FH	M	●	12.7	6.35	0.4	5.16	
	150608-FH	M	●	12.7	6.35	0.8	5.16	

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
	DNMG150404-FY	M	●	12.7	4.76	0.4	5.16	
	150408-FY	M	●	12.7	4.76	0.8	5.16	
	150604-FY	M	●	12.7	6.35	0.4	5.16	
	150608-FY	M	●	12.7	6.35	0.8	5.16	
Taglio di finitura								
	NEW DNMG110404-LP	M	●	9.525	4.76	0.4	3.81	
	NEW 110408-LP	M	●	9.525	4.76	0.8	3.81	
	150404-LP	M	●	12.7	4.76	0.4	5.16	
	150408-LP	M	●	12.7	4.76	0.8	5.16	
	NEW 150412-LP	M	●	12.7	4.76	1.2	5.16	
	150604-LP	M	●	12.7	6.35	0.4	5.16	
Taglio leggero	150608-LP	M	●	12.7	6.35	0.8	5.16	
	DNMX150404-SW	M	●	12.7	4.76	0.4	5.16	
	150408-SW	M	●	12.7	4.76	0.8	5.16	
	150604-SW	M	●	12.7	6.35	0.4	5.16	
	150608-SW	M	●	12.7	6.35	0.8	5.16	
Taglio leggero (Wiper)								
	DNMG150404-SY	M	●	12.7	4.76	0.4	5.16	
	150408-SY	M	●	12.7	4.76	0.8	5.16	
	150604-SY	M	●	12.7	6.35	0.4	5.16	
	150608-SY	M	●	12.7	6.35	0.8	5.16	
Taglio leggero								
	DNMG150404-MP	M	●	12.7	4.76	0.4	5.16	
	150408-MP	M	●	12.7	4.76	0.8	5.16	
	150412-MP	M	●	12.7	4.76	1.2	5.16	
	150604-MP	M	●	12.7	6.35	0.4	5.16	
	150608-MP	M	●	12.7	6.35	0.8	5.16	
	150612-MP	M	●	12.7	6.35	1.2	5.16	
Taglio medio								
	DNMG150404	M	●	12.7	4.76	0.4	5.16	
	150408	M	●	12.7	4.76	0.8	5.16	
	150604	M	●	12.7	6.35	0.4	5.16	
	150608	M	●	12.7	6.35	0.8	5.16	
Taglio medio								
	SNMG120404-FH	M	●	12.7	4.76	0.4	5.16	
	120408-FH	M	●	12.7	4.76	0.8	5.16	
Taglio di finitura								
	SNMG120404-LP	M	●	12.7	4.76	0.4	5.16	
	120408-LP	M	●	12.7	4.76	0.8	5.16	
Taglio leggero								


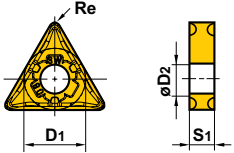

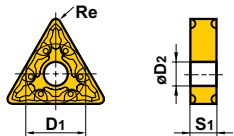

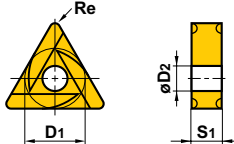

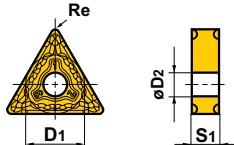

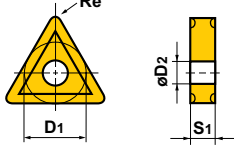

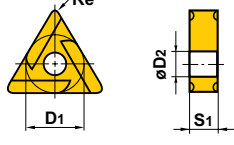

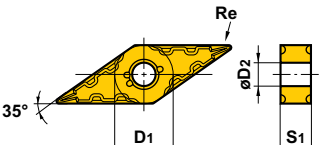

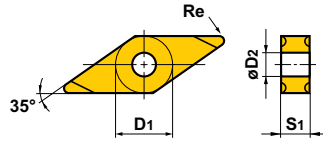
MP3025

INSERTI

● Inserti negativi (con foro)

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio leggero	SNMG120408-SY	M	●	12.7	4.76	0.8	5.16	
 Taglio medio	SNMG120404-MP	M	●	12.7	4.76	0.4	5.16	
	120408-MP	M	●	12.7	4.76	0.8	5.16	
	120412-MP	M	●	12.7	4.76	1.2	5.16	
 Taglio medio	SNMG090304	M	●	9.525	3.18	0.4	3.81	
	090308	M	●	9.525	3.18	0.8	3.81	
	120404	M	●	12.7	4.76	0.4	5.16	
	120408	M	●	12.7	4.76	0.8	5.16	
 Taglio medio	SNGG120404R	G	●	12.7	4.76	0.4	5.16	
	120408R	G	●	12.7	4.76	0.8	5.16	
	120404L	G	●	12.7	4.76	0.4	5.16	
	120408L	G	●	12.7	4.76	0.8	5.16	
 Taglio di finitura	TNMG160402-FH	M	●	9.525	4.76	0.2	3.81	
	160404-FH	M	●	9.525	4.76	0.4	3.81	
	160408-FH	M	●	9.525	4.76	0.8	3.81	
 Taglio di finitura	TNMG160404-FY	M	●	9.525	4.76	0.4	3.81	
	160408-FY	M	●	9.525	4.76	0.8	3.81	
 Taglio di finitura	TNGG160402R-F	G	●	9.525	4.76	0.2	3.81	
	160404R-F	G	●	9.525	4.76	0.4	3.81	
	160408R-F	G	●	9.525	4.76	0.8	3.81	
	160402L-F	G	●	9.525	4.76	0.2	3.81	
	160404L-F	G	●	9.525	4.76	0.4	3.81	
	160408L-F	G	●	9.525	4.76	0.8	3.81	
 Taglio leggero	TNMG160404-LP	M	●	9.525	4.76	0.4	3.81	
	160408-LP	M	●	9.525	4.76	0.8	3.81	
	160412-LP	M	●	9.525	4.76	1.2	3.81	
	220408-LP	M	●	12.7	4.76	0.8	5.16	


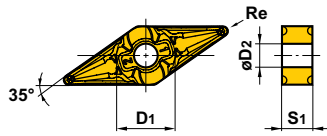

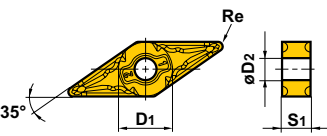

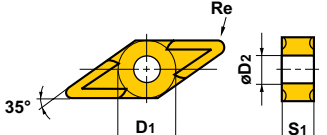

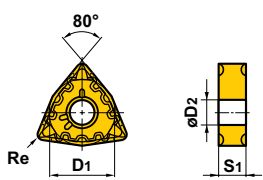

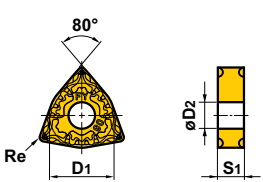

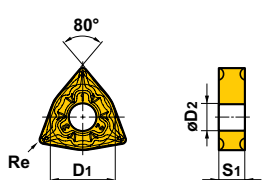

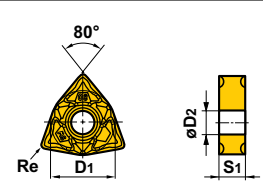

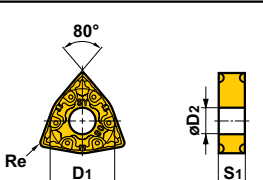
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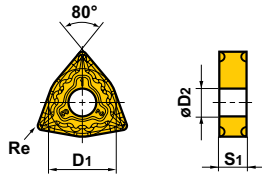

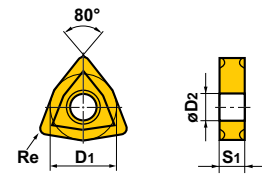
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio leggero (Wiper)	TNMX160404-SW	M	●	9.525	4.76	0.4	3.81	
	160408-SW	M	●	9.525	4.76	0.8	3.81	
 Taglio leggero	TNMG160404-SY	M	●	9.525	4.76	0.4	3.81	
	160408-SY	M	●	9.525	4.76	0.8	3.81	
 Taglio leggero	TNGG160402R-K	G	●	9.525	4.76	0.2	3.81	
	160404R-K	G	●	9.525	4.76	0.4	3.81	
	160408R-K	G	●	9.525	4.76	0.8	3.81	
	160402L-K	G	●	9.525	4.76	0.2	3.81	
	160404L-K	G	●	9.525	4.76	0.4	3.81	
	160408L-K	G	●	9.525	4.76	0.8	3.81	
 Taglio medio	TNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
	160412-MP	M	●	9.525	4.76	1.2	3.81	
 Taglio medio	TNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
 Taglio medio	TNGG160402R	G	●	9.525	4.76	0.2	3.81	
	160404R	G	●	9.525	4.76	0.4	3.81	
	160408R	G	●	9.525	4.76	0.8	3.81	
	160402L	G	●	9.525	4.76	0.2	3.81	
	160404L	G	●	9.525	4.76	0.4	3.81	
	160408L	G	●	9.525	4.76	0.8	3.81	
 Taglio di finitura	VNMG160402-FH	M	●	9.525	4.76	0.2	3.81	
	160404-FH	M	●	9.525	4.76	0.4	3.81	
	160408-FH	M	●	9.525	4.76	0.8	3.81	
 Taglio di finitura	VNGG160402R-F	G	●	9.525	4.76	0.2	3.81	
	160404R-F	G	●	9.525	4.76	0.4	3.81	
	160402L-F	G	●	9.525	4.76	0.2	3.81	
	160404L-F	G	●	9.525	4.76	0.4	3.81	

MP3025

INSERTI

● Inserti negativi (con foro)


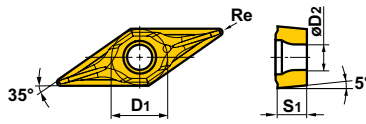

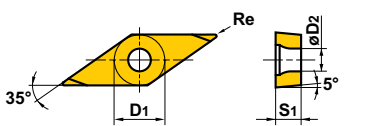

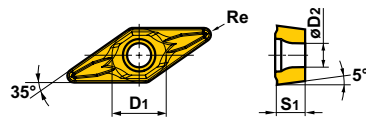

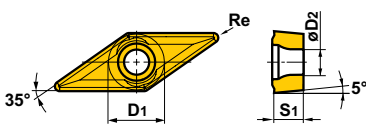

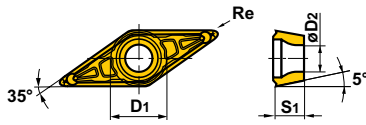

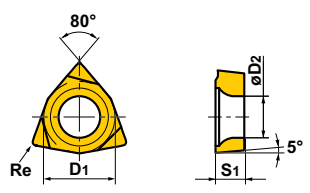

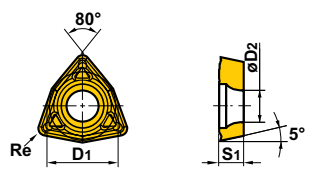
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio leggero	VNMG160404-LP	M	●	9.525	4.76	0.4	3.81	
	160408-LP	M	●	9.525	4.76	0.8	3.81	
 Taglio medio	VNMG160404-MP	M	●	9.525	4.76	0.4	3.81	
	160408-MP	M	●	9.525	4.76	0.8	3.81	
 Taglio medio	VNMG160404	M	●	9.525	4.76	0.4	3.81	
	160408	M	●	9.525	4.76	0.8	3.81	
 Taglio di finitura	WNMG080404-FH	M	●	12.7	4.76	0.4	5.16	
	080408-FH	M	●	12.7	4.76	0.8	5.16	
 Taglio di finitura	WNMG080404-FY	M	●	12.7	4.76	0.4	5.16	
	080408-FY	M	●	12.7	4.76	0.8	5.16	
 Taglio leggero	NEW WNMG06T304-LP	M	●	9.525	3.97	0.4	3.81	
	NEW 06T308-LP	M	●	9.525	3.97	0.8	3.81	
	080404-LP	M	●	12.7	4.76	0.4	5.16	
	080408-LP	M	●	12.7	4.76	0.8	5.16	
 Taglio leggero (Wiper)	WNMG060404-SW	M	●	9.525	4.76	0.4	3.81	
	060408-SW	M	●	9.525	4.76	0.8	3.81	
	080404-SW	M	●	12.7	4.76	0.4	5.16	
	080408-SW	M	●	12.7	4.76	0.8	5.16	
	080412-SW	M	●	12.7	4.76	1.2	5.16	
 Taglio leggero	WNMG080404-SY	M	●	12.7	4.76	0.4	5.16	
	080408-SY	M	●	12.7	4.76	0.8	5.16	

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			<i>MP3025</i>	D1	S1	Re	D2	
MP  Taglio medio	WNMG080404-MP	M	●	12.7	4.76	0.4	5.16	
	080408-MP	M	●	12.7	4.76	0.8	5.16	
	080412-MP	M	●	12.7	4.76	1.2	5.16	
Standard  Taglio medio	WNMG080404	M	●	12.7	4.76	0.4	5.16	
	080408	M	●	12.7	4.76	0.8	5.16	


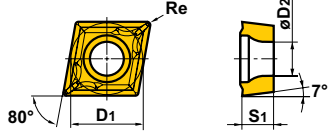

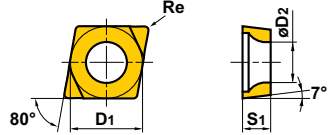

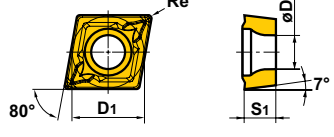

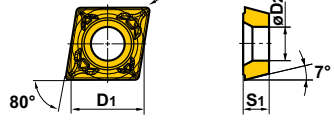

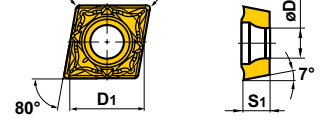

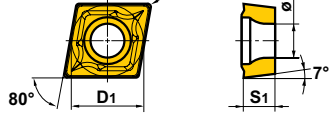

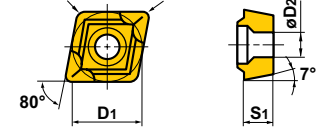
MP3025

INSERTI

● Inserti positivi 5° (con foro)

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio di finitura	NEW VBMT110302-FP	M	●	6.35	3.18	0.2	2.9	
	110304-FP	M	●	6.35	3.18	0.4	2.9	
	110308-FP	M	●	6.35	3.18	0.8	2.9	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
 Taglio di finitura	VBGT110302R-F	G	●	6.35	3.18	0.2	2.85	
	110302L-F	G	●	6.35	3.18	0.2	2.85	
 Taglio leggero	NEW VBMT110304-LP	M	●	6.35	3.18	0.4	2.9	
	110308-LP	M	●	6.35	3.18	0.8	2.9	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	
 Taglio medio	NEW VBMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
 Taglio medio	VBMT110304-MV	M	●	6.35	3.18	0.4	2.85	
	110308-MV	M	●	6.35	3.18	0.8	2.85	
	160404-MV	M	●	9.525	4.76	0.4	4.43	
	160408-MV	M	●	9.525	4.76	0.8	4.43	
 Taglio di finitura	WBGT020102L-F	G	●	3.97	1.59	0.2	2.3	
	020104L-F	G	●	3.97	1.59	0.4	2.3	
	L30202L-F	G	●	4.76	2.38	0.2	2.3	
	L30204L-F	G	●	4.76	2.38	0.4	2.3	
 Taglio medio	WBMTL30202L-MV	M	●	4.76	2.38	0.2	2.3	
	L30202R-MV	M	●	4.76	2.38	0.2	2.3	
	L30204L-MV	M	●	4.76	2.38	0.4	2.3	
	L30204R-MV	M	●	4.76	2.38	0.4	2.3	


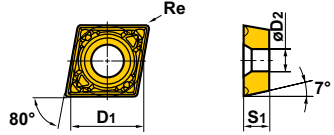

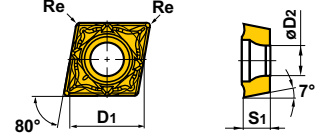

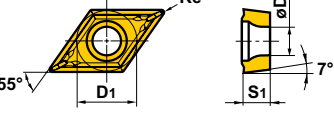

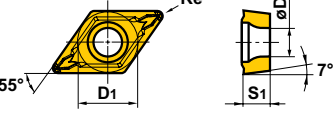

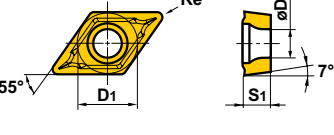

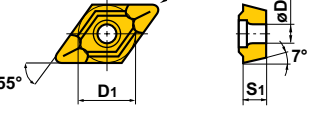


● Insetti positivi 7° (con foro)


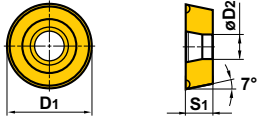

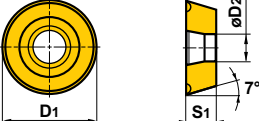

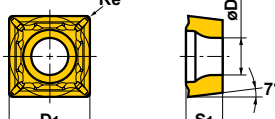

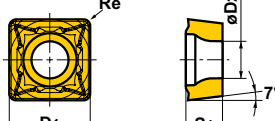

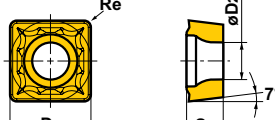

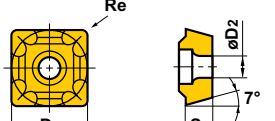

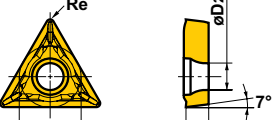
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio di finitura	NEW FP							
	CCMT060202-FP	M	●	6.35	2.38	0.2	2.8	
	060204-FP	M	●	6.35	2.38	0.4	2.8	
	09T302-FP	M	●	9.525	3.97	0.2	4.4	
	09T304-FP	M	●	9.525	3.97	0.4	4.4	
	09T308-FP	M	●	9.525	3.97	0.8	4.4	
 Taglio di finitura	L-F							
	CCGT03S102L-F	G	●	3.97	1.39	0.2	2.0	
	03S104L-F	G	●	3.97	1.39	0.4	2.0	
	04T002L-F	G	●	4.76	1.79	0.2	2.4	
	04T004L-F	G	●	4.76	1.79	0.4	2.4	
 Taglio leggero	NEW LP							
	CCMT060204-LP	M	●	6.35	2.38	0.4	2.8	
	060208-LP	M	●	6.35	2.38	0.8	2.8	
	09T304-LP	M	●	9.525	3.97	0.4	4.4	
	09T308-LP	M	●	9.525	3.97	0.8	4.4	
 Taglio leggero	SV							
	CCMH060202-SV	M	●	6.35	2.38	0.2	2.8	
	060204-SV	M	●	6.35	2.38	0.4	2.8	
 Taglio leggero (Wiper)	SW							
	CCMT060202-SW	M	●	6.35	2.38	0.2	2.8	
	060204-SW	M	●	6.35	2.38	0.4	2.8	
	09T302-SW	M	●	9.525	3.97	0.2	4.4	
	09T304-SW	M	●	9.525	3.97	0.4	4.4	
 Taglio medio	NEW MP							
	CCMT060204-MP	M	●	6.35	2.38	0.4	2.8	
	060208-MP	M	●	6.35	2.38	0.8	2.8	
	09T304-MP	M	●	9.525	3.97	0.4	4.4	
	09T308-MP	M	●	9.525	3.97	0.8	4.4	
	120404-MP	M	●	12.7	4.76	0.4	5.5	
	120408-MP	M	●	12.7	4.76	0.8	5.5	
	120412-MP		●	12.7	4.76	1.2	5.5	
 Taglio medio	Standard							
	CCMT060202	M	●	6.35	2.38	0.2	2.8	
	060204	M	●	6.35	2.38	0.4	2.8	
	080304	M	●	7.94	3.18	0.4	3.4	
	09T302	M	●	9.525	3.97	0.2	4.4	
	09T304	M	●	9.525	3.97	0.4	4.4	
	09T308	M	●	9.525	3.97	0.8	4.4	
	120404	M	●	12.7	4.76	0.4	5.5	
	120408	M	●	12.7	4.76	0.8	5.5	

MP3025

INSERTI

● Inserti positivi 7° (con foro)


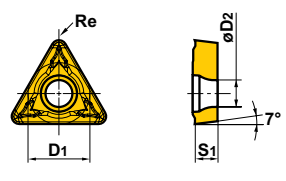

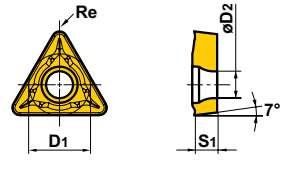

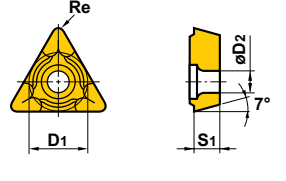

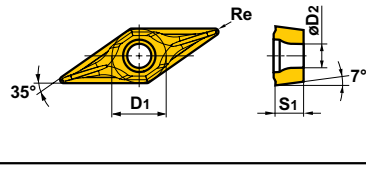

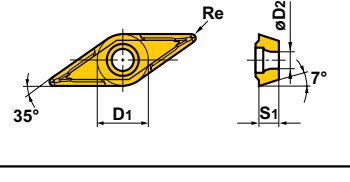

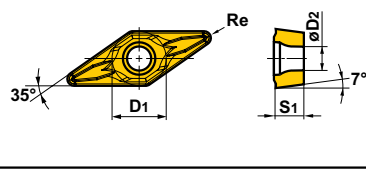
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio medio	CCMH060202-MV	M	●	6.35	2.38	0.2	2.8	
	060204-MV	M	●	6.35	2.38	0.4	2.8	
 Taglio medio (Wiper)	CCMT060204-MW	M	●	6.35	2.38	0.4	2.8	
	060208-MW	M	●	6.35	2.38	0.8	2.8	
	09T304-MW	M	●	9.525	3.97	0.4	4.4	
	09T308-MW	M	●	9.525	3.97	0.8	4.4	
 Taglio di finitura	DCMT070202-FP	M	●	6.35	2.38	0.2	2.8	
	070204-FP	M	●	6.35	2.38	0.4	2.8	
	11T302-FP	M	●	9.525	3.97	0.2	4.4	
	11T304-FP	M	●	9.525	3.97	0.4	4.4	
	11T308-FP	M	●	9.525	3.97	0.8	4.4	
 Taglio leggero	DCMT070204-LP	M	●	6.35	2.38	0.4	2.8	
	070208-LP	M	●	6.35	2.38	0.8	2.8	
	11T304-LP	M	●	9.525	3.97	0.4	4.4	
	11T308-LP	M	●	9.525	3.97	0.8	4.4	
 Taglio medio	DCMT070204-MP	M	●	6.35	2.38	0.4	2.8	
	070208-MP	M	●	6.35	2.38	0.8	2.8	
	11T304-MP	M	●	9.525	3.97	0.4	4.4	
	11T308-MP	M	●	9.525	3.97	0.8	4.4	
	150404-MP	M	●	12.7	4.76	0.4	5.5	
	150408-MP	M	●	12.7	4.76	0.8	5.5	
 Taglio medio	DCMT070202	M	●	6.35	2.38	0.2	2.8	
	070204	M	●	6.35	2.38	0.4	2.8	
	070208	M	●	6.35	2.38	0.8	2.8	
	11T302	M	●	9.525	3.97	0.2	4.4	
	11T304	M	●	9.525	3.97	0.4	4.4	
	11T308	M	●	9.525	3.97	0.8	4.4	
	150404	M	●	12.7	4.76	0.4	5.5	
	150408	M	●	12.7	4.76	0.8	5.5	
 Taglio medio	DCMT070202-MV	M	●	6.35	2.38	0.2	2.8	
	070204-MV	M	●	6.35	2.38	0.4	2.8	
	070208-MV	M	●	6.35	2.38	0.8	2.8	
	11T302-MV	M	●	9.525	3.97	0.2	4.4	
	11T304-MV	M	●	9.525	3.97	0.4	4.4	
	11T308-MV	M	●	9.525	3.97	0.8	4.4	


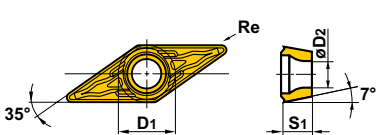

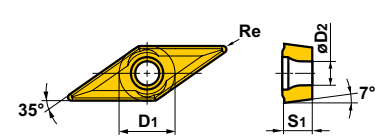

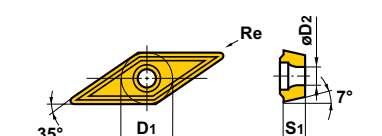

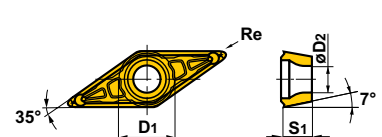


Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio medio	RCMT0602M0	M	●	6	2.38	-	2.8	
	0803M0	M	●	8	3.18	-	3.4	
 Taglio medio	RCMX1003M0	M	●	10	3.18	-	3.6	
	1204M0	M	●	12	4.76	-	4.2	
 Taglio di finitura	SCMT09T304-FP	M	●	9.525	3.97	0.4	4.4	
	09T308-FP	M	●	9.525	3.97	0.8	4.4	
 Taglio leggero	SCMT09T304-LP	M	●	9.525	3.97	0.4	4.4	
	09T308-LP	M	●	9.525	3.97	0.8	4.4	
 Taglio medio	SCMT09T304-MP	M	●	9.525	3.97	0.4	4.4	
	09T308-MP	M	●	9.525	3.97	0.8	4.4	
	120404-MP	M	●	12.7	4.76	0.4	5.5	
	120408-MP	M	●	12.7	4.76	0.8	5.5	
 Taglio medio	SCMT09T304	M	●	9.525	3.97	0.4	4.4	
	09T308	M	●	9.525	3.97	0.8	4.4	
	120404	M	●	12.7	4.76	0.4	5.5	
	120408	M	●	12.7	4.76	0.8	5.5	
 Taglio di finitura	TCMT090202-FP	M	●	5.56	2.38	0.2	2.5	
	090204-FP	M	●	5.56	2.38	0.4	2.5	
	110202-FP	M	●	6.35	2.38	0.2	2.8	
	110204-FP	M	●	6.35	2.38	0.4	2.8	
	16T304-FP	M	●	9.525	3.97	0.4	4.4	

MP3025

INSERTI

● Inserti positivi 7° (con foro)


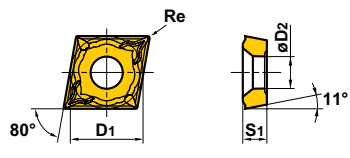

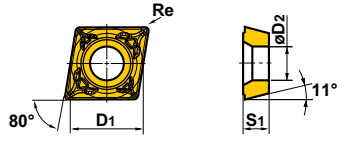

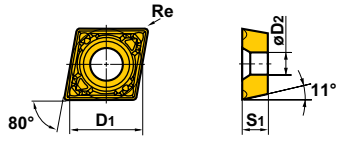

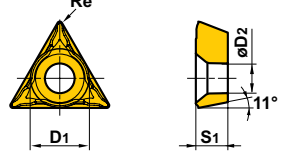

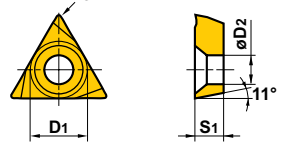

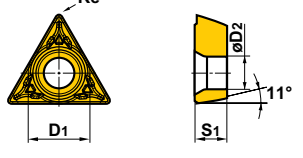
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio leggero	TCMT090204-LP	M	●	5.56	2.38	0.4	2.5	
	090208-LP	M	●	5.56	2.38	0.8	2.5	
	110204-LP	M	●	6.35	2.38	0.4	2.8	
	110208-LP	M	●	6.35	2.38	0.8	2.8	
	16T304-LP	M	●	9.525	3.97	0.4	4.4	
	16T308-LP	M	●	9.525	3.97	0.8	4.4	
 Taglio medio	TCMT090204-MP	M	●	5.56	2.38	0.4	2.5	
	090208-MP	M	●	5.56	2.38	0.8	2.5	
	110204-MP	M	●	6.35	2.38	0.4	2.8	
	110208-MP	M	●	6.35	2.38	0.8	2.8	
	130304-MP	M	●	7.94	3.18	0.4	3.4	
	16T304-MP	M	●	9.525	3.97	0.4	4.4	
	16T308-MP	M	●	9.525	3.97	0.8	4.4	
16T312-MP	M	●	9.525	3.97	1.2	4.4		
 Taglio medio	TCMT080204	M	●	4.76	2.38	0.4	2.3	
	090204	M	●	5.56	2.38	0.4	2.5	
	110202	M	●	6.35	2.38	0.2	2.8	
	110204	M	●	6.35	2.38	0.4	2.8	
	110208	M	●	6.35	2.38	0.8	2.8	
	130302	M	●	7.94	3.18	0.2	3.4	
	130304	M	●	7.94	3.18	0.4	3.4	
	16T304	M	●	9.525	3.97	0.4	4.4	
16T308	M	●	9.525	3.97	0.8	4.4		
 Taglio di finitura	VCMT110302-FP	M	●	6.35	3.18	0.2	2.8	
	110304-FP	M	●	6.35	3.18	0.4	2.8	
	160404-FP	M	●	9.525	4.76	0.4	4.4	
	160408-FP	M	●	9.525	4.76	0.8	4.4	
 Taglio di finitura	VCMT080202-FV	M	●	4.76	2.38	0.2	2.42	
	080204-FV	M	●	4.76	2.38	0.4	2.42	
 Taglio leggero	VCMT110304-LP	M	●	6.35	3.18	0.4	2.8	
	110308-LP	M	●	6.35	3.18	0.8	2.8	
	160404-LP	M	●	9.525	4.76	0.4	4.4	
	160408-LP	M	●	9.525	4.76	0.8	4.4	


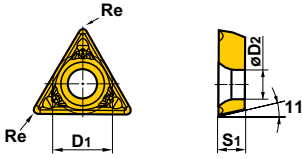
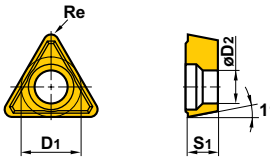
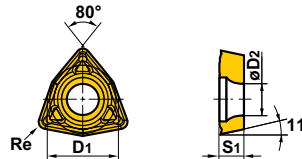
Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
 Taglio leggero	VCMT080202-SV	M	●	4.76	2.38	0.2	2.42	
	080204-SV	M	●	4.76	2.38	0.4	2.42	
 Taglio medio	VCMT160404-MP	M	●	9.525	4.76	0.4	4.4	
	160408-MP	M	●	9.525	4.76	0.8	4.4	
	160412-MP	M	●	9.525	4.76	1.2	4.4	
 Taglio medio	VCMT110304	M	●	6.35	3.18	0.4	2.8	
	160404	M	●	9.525	4.76	0.4	4.4	
	160408	M	●	9.525	4.76	0.8	4.4	
 Taglio medio	VCMT080202-MV	M	●	4.76	2.38	0.2	2.42	
	080204-MV	M	●	4.76	2.38	0.4	2.42	
 Taglio medio	WCMT020102	M	●	3.97	1.59	0.2	2.3	
	020104	M	●	3.97	1.59	0.4	2.3	
	L30202	M	●	4.76	2.38	0.2	2.3	
	L30204	M	●	4.76	2.38	0.4	2.3	
	040202	M	●	6.35	2.38	0.2	2.8	
	040204	M	●	6.35	2.38	0.4	2.8	
	06T304	M	●	9.525	3.97	0.4	4.4	
06T308	M	●	9.525	3.97	0.8	4.4		

MP3025


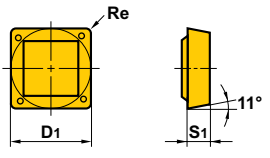
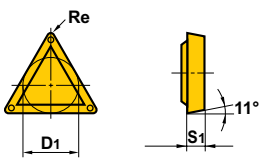
INSERTI

● Inserti positivi 11° (con foro)

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
	CPMH080202-FV	M	●	7.94	2.38	0.2	3.5	
	080204-FV	M	●	7.94	2.38	0.4	3.5	
	090302-FV	M	●	9.525	3.18	0.2	4.5	
	090304-FV	M	●	9.525	3.18	0.4	4.5	
	090308-FV	M	●	9.525	3.18	0.8	4.5	
Taglio di finitura								
	CPMH080202-SV	M	●	7.94	2.38	0.2	3.5	
	080204-SV	M	●	7.94	2.38	0.4	3.5	
	090302-SV	M	●	9.525	3.18	0.2	4.5	
	090304-SV	M	●	9.525	3.18	0.4	4.5	
	090308-SV	M	●	9.525	3.18	0.8	4.5	
Taglio leggero								
	CPMH080204-MV	M	●	7.94	2.38	0.4	3.5	
	080208-MV	M	●	7.94	2.38	0.8	3.5	
	090304-MV	M	●	9.525	3.18	0.4	4.5	
	090308-MV	M	●	9.525	3.18	0.8	4.5	
Taglio medio								
	TPMH080202-FV	M	●	4.76	2.38	0.2	2.4	
	080204-FV	M	●	4.76	2.38	0.4	2.4	
	090202-FV	M	●	5.56	2.38	0.2	2.9	
	090204-FV	M	●	5.56	2.38	0.4	2.9	
	110302-FV	M	●	6.35	3.18	0.2	3.4	
	110304-FV	M	●	6.35	3.18	0.4	3.4	
	110308-FV	M	●	6.35	3.18	0.8	3.4	
	160302-FV	M	●	9.525	3.18	0.2	4.4	
	160304-FV	M	●	9.525	3.18	0.4	4.4	
	160308-FV	M	●	9.525	3.18	0.8	4.4	
Taglio di finitura								
	TPGH080202L-FS	G	●	4.76	2.38	0.2	2.4	
	080204L-FS	G	●	4.76	2.38	0.4	2.4	
	090202L-FS	G	●	5.56	2.38	0.2	2.9	
	090204L-FS	G	●	5.56	2.38	0.4	2.9	
	110302L-FS	G	●	6.35	3.18	0.2	3.4	
	110304L-FS	G	●	6.35	3.18	0.4	3.4	
	160304L-FS	G	●	9.525	3.18	0.4	4.4	
	160308L-FS	G	●	9.525	3.18	0.8	4.4	
Taglio di finitura								
	TPMH080202-SV	M	●	4.76	2.38	0.2	2.4	
	080204-SV	M	●	4.76	2.38	0.4	2.4	
	090202-SV	M	●	5.56	2.38	0.2	2.9	
	090204-SV	M	●	5.56	2.38	0.4	2.9	
	110302-SV	M	●	6.35	3.18	0.2	3.4	
	110304-SV	M	●	6.35	3.18	0.4	3.4	
	110308-SV	M	●	6.35	3.18	0.8	3.4	
	160302-SV	M	●	9.525	3.18	0.2	4.4	
	160304-SV	M	●	9.525	3.18	0.4	4.4	
	160308-SV	M	●	9.525	3.18	0.8	4.4	
Taglio leggero								

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
	TPMH080202-MV	M	●	4.76	2.38	0.2	2.4	
	080204-MV	M	●	4.76	2.38	0.4	2.4	
	090202-MV	M	●	5.56	2.38	0.2	2.9	
	090204-MV	M	●	5.56	2.38	0.4	2.9	
	090208-MV	M	●	5.56	2.38	0.8	2.9	
	110302-MV	M	●	6.35	3.18	0.2	3.4	
	110304-MV	M	●	6.35	3.18	0.4	3.4	
	110308-MV	M	●	6.35	3.18	0.8	3.4	
	160304-MV	M	●	9.525	3.18	0.4	4.4	
	160308-MV	M	●	9.525	3.18	0.8	4.4	
Taglio medio								
Standard	TPMX110304	M	●	6.35	3.18	0.4	3.5	
	110308	M	●	6.35	3.18	0.8	3.5	
Taglio medio								
MV	WPMT040202-MV	M	●	6.35	2.38	0.2	2.8	
	040204-MV	M	●	6.35	2.38	0.4	2.8	
	060304-MV	M	●	9.525	3.18	0.4	4.4	
	060308-MV	M	●	9.525	3.18	0.8	4.4	
Taglio medio								

● Insetti positivi 11° (senza foro)

Forma	Codice ordinazione	Classe	Disponibilità	Dimensioni (mm)				Geometria
			MP3025	D1	S1	Re	D2	
	SPMR090304	M	●	9.525	3.18	0.4	-	
	090308	M	●	9.525	3.18	0.8	-	
	120304	M	●	12.7	3.18	0.4	-	
	120308	M	●	12.7	3.18	0.8	-	
Taglio da leggero a medio								
Standard	TPMR090202	M	●	5.56	2.38	0.2	-	
	090204	M	●	5.56	2.38	0.4	-	
	090208	M	●	5.56	2.38	0.8	-	
	110302	M	●	6.35	3.18	0.2	-	
	110304	M	●	6.35	3.18	0.4	-	
	110308	M	●	6.35	3.18	0.8	-	
	160304	M	●	9.525	3.18	0.4	-	
	160308	M	●	9.525	3.18	0.8	-	
	160312	M	●	9.525	3.18	1.2	-	
Taglio da leggero Taglio medio								

CONDIZIONI DI TAGLIO RACCOMANDATE

Inseri negativi (utensili per tornitura esterna)

Materiale da lavorare	Durezza	Modalità di taglio		Rompitruciolo	Velocità di taglio (m/min)	Avanzamento (mm/giro)	Profondità di taglio (mm)
P Acciaio dolce (SS400, S10C etc.)	<180HB	Taglio generico	Taglio di finitura	FY	275–420	0.09–0.23	0.20–0.80
			Taglio leggero	SY	250–385	0.16–0.33	0.50–1.20
Acciaio al carbonio, acciaio legato (S45C, SCM440 etc.)	180–280HB	Taglio stabile	Taglio di finitura	R/L-F	210–325	0.05–0.15	0.10–0.50
			Taglio leggero	LP	195–295	0.10–0.40	0.30–2.00
			Taglio leggero	SW	195–295	0.10–0.50	0.30–2.50
			Taglio leggero	R/L-K	195–295	0.08–0.20	0.30–1.20
			Taglio medio	MP	175–270	0.16–0.50	0.30–4.00
			Taglio medio	Standard	175–270	0.25–0.60	1.50–5.00
			Taglio medio	D/S	175–270	0.15–0.32	0.40–2.00
		Taglio generico	FH	210–325	0.08–0.20	0.20–1.00	
		Taglio generico	Taglio medio	LP	195–295	0.10–0.40	0.30–2.00

Inseri positivi 7° (Portautensili SP, utensili per tornitura esterna)

Materiale da lavorare	Durezza	Modalità di taglio		Rompitruciolo	Velocità di taglio (m/min)	Avanzamento (mm/giro)	Profondità di taglio (mm)
P Acciaio dolce (SS400, S10C etc.)	≤180HB	Taglio stabile	Taglio di finitura	R/L-F	230–350	0.05–0.12	0.10–1.50
			Taglio leggero	MV, Standard	190–295	0.08–0.30	0.30–2.00
		Taglio generico	Taglio di finitura	FP, FV	230–350	0.04–0.20	0.20–0.90
			Taglio leggero	LP	230–350	0.06–0.25	0.20–1.00
			Taglio medio	MP	190–295	0.08–0.30	0.30–2.00
Acciaio al carbonio, acciaio legato (S45C, SCM440 etc.)	180–280HB	Taglio stabile	Taglio di finitura	R/L-F	170–260	0.05–0.12	0.10–0.50
			Taglio leggero	SV	170–260	0.06–0.25	0.20–1.00
			Taglio medio	MV, Standard	140–215	0.08–0.30	0.30–2.00
			Taglio medio	MW	140–215	0.10–0.35	0.80–2.50
		Taglio generico	Taglio di finitura	FP, FV	170–260	0.04–0.20	0.20–0.90
			Taglio leggero	LP	170–260	0.06–0.25	0.20–1.00
			Taglio leggero	SW	170–260	0.06–0.24	0.20–1.50
			Taglio medio	MP	140–215	0.08–0.30	0.30–2.00
Acciaio al carbonio, acciaio legato (SNCM439 etc.)	280–350HB	Taglio generico	Taglio medio	MP	100–155	0.08–0.30	0.30–2.00

Inseri positivi 11° (Portautensili MC, utensili per tornitura esterna)

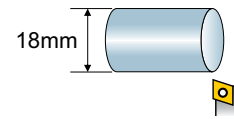
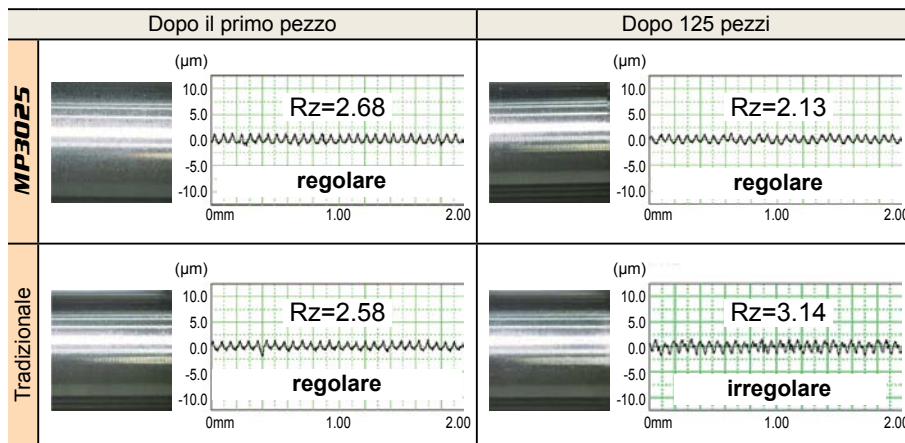
Materiale da lavorare	Durezza	Modalità di taglio		Rompitruciolo	Velocità di taglio (m/min)	Avanzamento (mm/giro)	Profondità di taglio (mm)
P Acciaio dolce (SS400, S10C etc.)	≤180HB	Taglio generico	Taglio leggero/medio	Standard	190–295	0.08–0.30	0.30–2.00
Acciaio al carbonio, acciaio legato (S45C, SCM440 etc.)	180–280HB	Taglio generico	Taglio leggero/medio	Standard	140–215	0.08–0.30	0.30–2.00

Inseri positivi 5°/7° (utensile per barenatura)

Materiale da lavorare	Durezza	Modalità di taglio		Rompitruciolo	Velocità di taglio (m/min)	Avanzamento (mm/giro)	Profondità di taglio (mm)
P Acciaio dolce (SS400, S10C etc.)	≤180HB	Taglio generico	Taglio di finitura	FP, FV	230–350	0.04–0.20	0.20–0.90
			Taglio leggero	LP	230–350	0.06–0.25	0.20–1.00
			Taglio medio	MP, MV, Standard	190–295	0.08–0.30	0.30–2.00
Acciaio al carbonio, acciaio legato (S45C, SCM440 etc.)	180–280HB	Taglio generico	Taglio di finitura	FP	170–260	0.04–0.20	0.20–0.90
			Taglio leggero	LP	170–260	0.06–0.25	0.20–1.00
			Taglio medio	MP	140–215	0.08–0.30	0.30–2.00
Acciaio al carbonio, acciaio legato (SNCM439 etc.)	280–350HB	Taglio generico	Taglio di finitura	FP	120–185	0.04–0.20	0.20–0.90
			Taglio leggero	LP	120–185	0.06–0.25	0.20–1.00
			Taglio medio	MP	100–155	0.08–0.30	0.30–2.00

*Condizioni di taglio raccomandate per inserto positivo 5° e 7° possono variare a seconda dello sbalzo. Fare riferimento alle condizioni di taglio raccomandate per barenatura per lavorazioni interne.

Comparazione rugosità superficiale

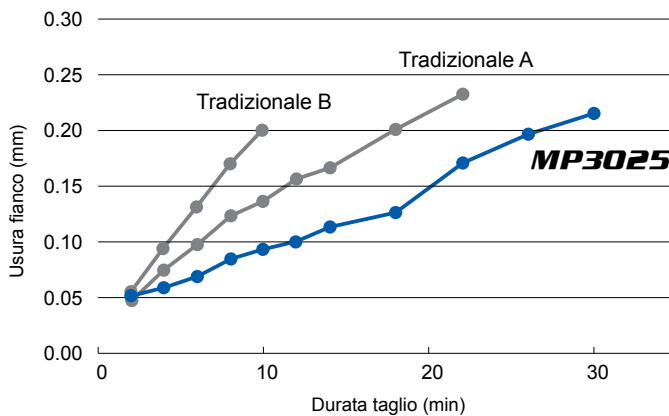


<Condizioni di taglio>


Pezzo da lavorare : JIS-S45C
 Inserti : DCMT11T304
 Velocità di taglio : $vc=150$ m/min
 Profondità di taglio : $ap=1,0$ mm
 Avanzamento : $f=0,07$ mm/giro
 Taglio a umido

MP3025 ha mantenuto una finitura superficiale di alta qualità dopo 125 componenti.

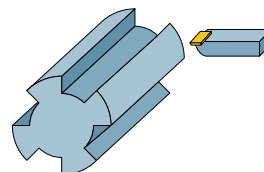
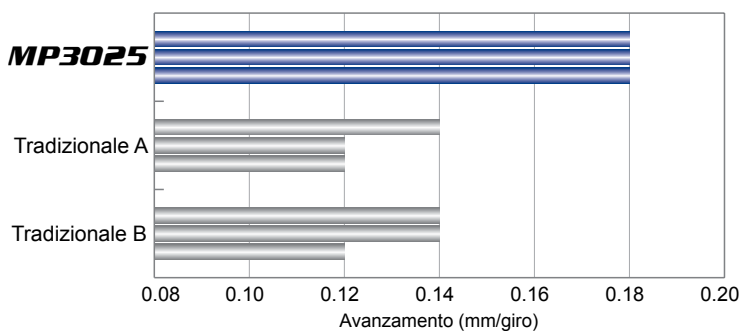
Comparazione resistenza all'usura




<Condizioni di taglio>

Pezzo da lavorare : S45C
 Inserti : CNMG120408-
 Velocità di taglio : $vc=250$ m/min
 Profondità di taglio : $ap=1,0$ mm
 Avanzamento : $f=0,15$ mm/giro
 Taglio a umido

Comparazione resistenza alla rottura

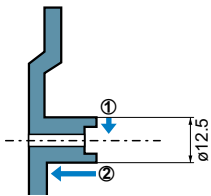
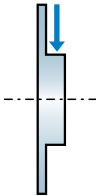
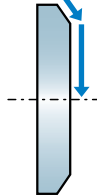
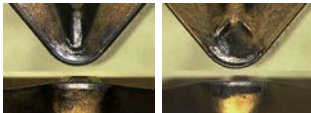
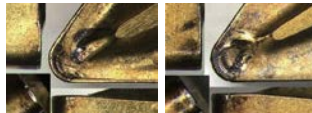
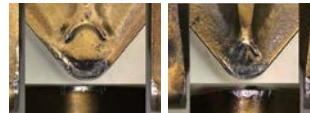


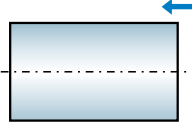
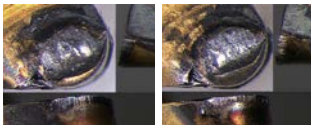
<Condizioni di taglio>

Pezzo da lavorare : SCM440
 Inserti : CNMG120408-
 Velocità di taglio : $vc=200$ m/min
 Profondità di taglio : $ap=1,0$ mm
 Taglio a secco

Grado Cermet con rivestimento PVD per acciaio

Esempi di applicazione

Inserto		WNMG080408-LP (MP3025)	DNMG150404-LP (MP3025)	WNMG080408-LP (MP3025)
Pezzo da lavorare		Pignone (JIS-SPHC) 	Ricambi motore (JIS-SCM420H) 	JIS-SS400 
Condizioni di taglio	Velocità di taglio (m/min)	98	200	200
	Avanzamento (mm/min)	0.2	0.12	0.2
	Profondità di taglio (mm)	0.35	0.3	0.5
Refrigerante		Taglio a umido		Taglio a secco
Risultati		Tradizionale MP3025  MP3025 ha una migliore resistenza all'usura rispetto al Cermet tradizionale diminuendo il consumo di inserti	Tradizionale MP3025  MP3025 ha raddoppiato la vita utensile e il rompitrucolo LP ha consentito la lavorazione senza vibrazioni.	Tradizionale MP3025  MP3025 ha raddoppiato la vita utensile rispetto agli inserti convenzionali durante la lavorazione a secco.

Inserto		TNGG160404L-F (MP3025)
Pezzo da lavorare		JIS S45C 
Condizioni di taglio	Velocità di taglio (m/min)	250
	Avanzamento (mm/min)	0.15
	Profondità di taglio (mm)	0.5
Refrigerante		Taglio a umido
Risultati		Tradizionale MP3025  Rispetto ai prodotti tradizionali, MP3025 ha visualizzato minor usura, pertanto maggiore vita utensile.

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