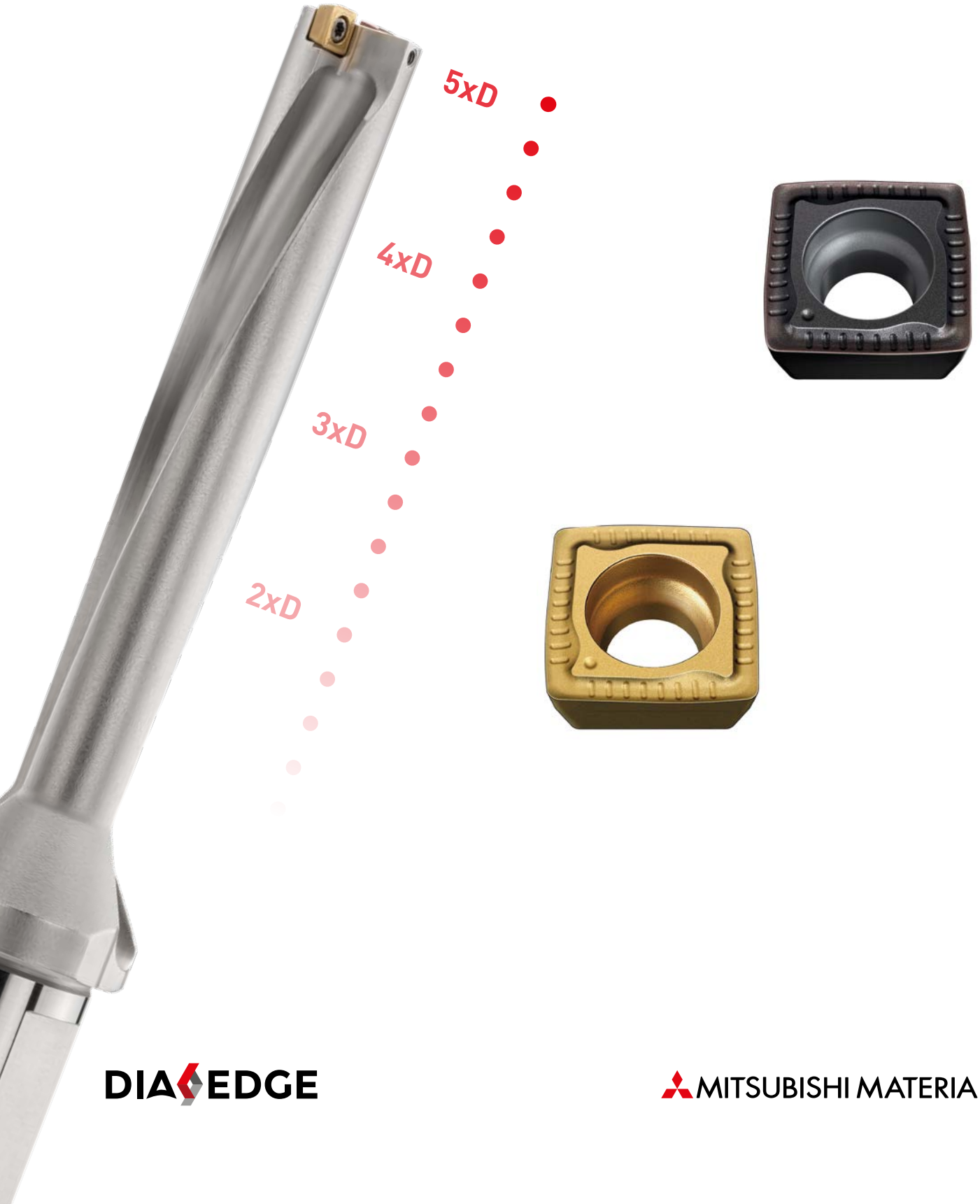
MVX + MINI MVX

BROCA CON PLACA INTERCAMBIABLE
ÚLTIMA TECNOLOGÍA QUE PROPORCIONA UNA ELEVADA RIGIDEZ DEL CUERPO



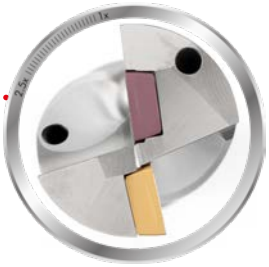
DIA EDGE

MITSUBISHI MATERIALS

MVX + MINI MVX

BROCA CON PLACAS INTERCAMBIABLES

4 FILOS DE CORTE



Placa económica de 4 filos de corte.

TIPOS DE PLACAS

Diferentes tipos de placas para una amplia gama de materiales de trabajo y aplicaciones.

EXCELENTES ACABADOS DE LAS SUPERFICIES

Wiper

La geometría de tipo wiper del filo de corte periférico ofrece una excelente precisión.

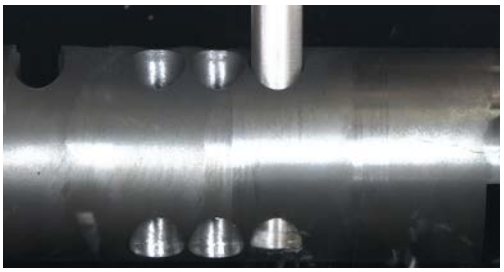
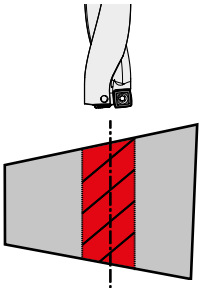
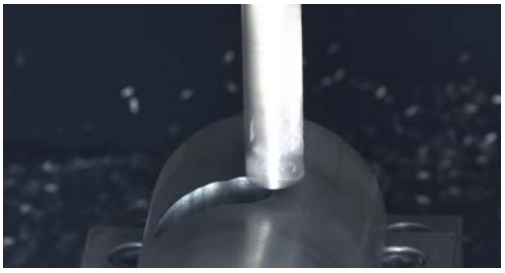
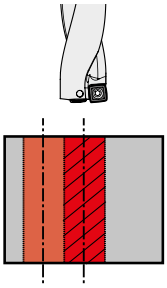
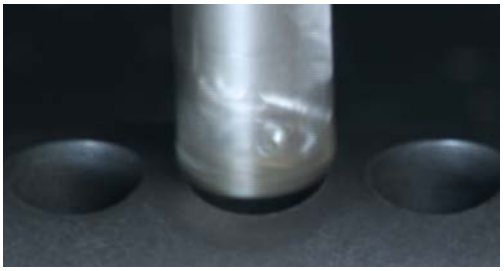
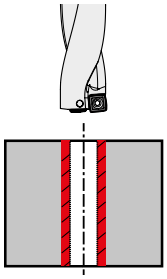
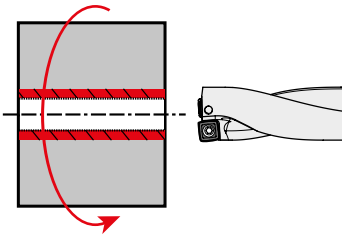
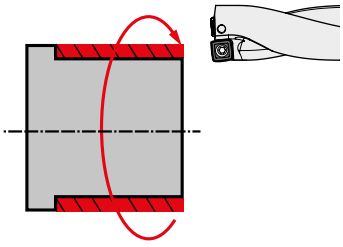
COMBINACIÓN IDEAL DE PLACAS DE CVD Y PVD

Mientras que para el filo periférico se utiliza una placa con recubrimiento de CVD muy resistente al desgaste, para la posición interior se emplea una placa con recubrimiento de PVD que le confiere una estabilidad adicional.

MINI MVX: PROFUNDIDAD DE TALADRADO ~ 5 LD

Cuerpo de elevada rigidez y posicón de la placa optimizada que controla la deformación y la vibración del portaherramientas.

EJEMPLOS DE APLICACIONES ESPECIALES

Ejemplos de aplicación	Tipo de corte
TALADRADO EN PENDIENTE	
	
AGUJEROS SOLAPADOS	
	
MANDRINADO	
	
TORNEADO INTERIOR	
	
TORNEADO EXTERIOR	
	

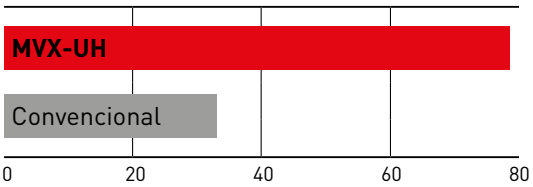
1. Para aplicaciones especiales, utilice únicamente un cuerpo de herramienta con una longitud de hasta DC×4.

ROMPEVIRUTAS

ROMPEVIRUTAS UH PARA ACERO ENDURECIDO

Filo de corte reforzado para el taladrado de acero endurecido de hasta 45 HRC.

Comparación del número de agujeros taladrados



RESULTADOS DE CORTE

Broca	MVX1700X3F20
Placa	MC1020-UM exterior
	DP8020-UH interior
Material de trabajo	DIN X40CrMoV51 (45 HRC)
Vc (m/min)	50
f (mm/rev)	0.08
ap (mm)	30 (agujero pasante)

ROMPEVIRUTAS UN PARA ALEACIONES DE ALUMINIO

El rompevirutas UN se ha diseñado con un afilado filo rectificado que ofrece una excelente evacuación de las virutas.
El fundido del aluminio también se evita gracias a las superficies de incidencia lisas.

Comparación de la calidad de acabado de las superficies

ROMPEVIRUTAS UN (TF15)

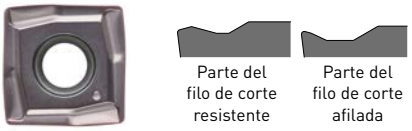
Convencional

RESULTADOS DE CORTE

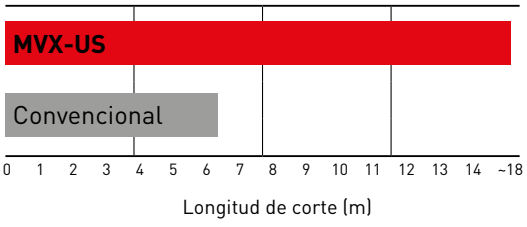
Broca	MVX1700X5F20
Placa	TF15-UN exterior
	TF15-UN interior
Material de trabajo	JIS ADC12
Vc (m/min)	400
f (mm/rev)	0.05
ap (mm)	40 (agujero ciego)

ROMPEVIRUTAS US PARA ACERO INOXIDABLE

Diseño específico para el filo interior.
Excelente resistencia a la rotura y al fundido.



Comparación de la ongitud de corte



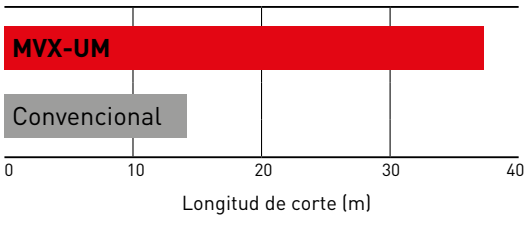
RESULTADOS DE CORTE

Broca	MVX3000X3F32
Placa	MC1020-UM exterior
	VP15TF-US interior
Material de trabajo	DIN X5CrNi18-10
Vc (m/min)	120
f (mm/rev)	0.12
ap (mm)	50 (agujero pasante)

ROMPEVIRUTAS UM PARA USO GENERAL EN VELOCIDADES DE AVANCE MEDIAS Y ALTAS

Rompevirutas de uso general para acero, acero inoxidable, fundición y acero endurecido.

Comparación de la ongitud de corte



RESULTADOS DE CORTE

Broca	MVX1900X3F25
Placa	MC1020-UM exterior
	VP15TF-UM interior
Material de trabajo	DIN C50
Vc (m/min)	220
f (mm/rev)	0.1
ap (mm)	50 (agujero pasante)

PLACAS

La velocidad de corte periférica es, naturalmente, más baja hacia el centro de la broca, lo que facilita la aparición del fundido de las virutas. A continuación se describen algunos puntos importantes que le ayudarán a elegir la placa correcta.

	1.ª recomendación		Rotura de la placa exterior	
	Exterior	**Interior**	**Exterior**	**Interior**
P	MC1020  UM	VP15TF  UM	VP15TF  UM	VP15TF  UM
M	MC1020  UM	VP15TF  US	VP15TF  UM	VP15TF  US
K	MC5020  UM	VP15TF  UM	VP15TF  UM	VP15TF  UM
N	TF15  UN	TF15  UN		
H	MC1020  UM	DP8020  UH	VP15TF  UM	DP8020  UH

CARACTERÍSTICAS DEL RECUBRIMIENTO

MC1020

MC1020 es un recubrimiento de CVD para unas velocidades de corte más elevadas. Sus principales propiedades son una mayor resistencia a la deformación plástica y al desgaste para mejorar la fiabilidad.

DP8020

Combinación de un duradero sustrato especial de metal duro y un recubrimiento de Ti-Al-Si de excepcional dureza.
DP8020 es una calidad de metal duro con recubrimiento de PVD apta para acero endurecido (45 HRC o inferior) y para evitar roturas durante el mecanizado de acero y la fundición.

MC5020

MC5020 es un recubrimiento de CVD apto para el taladrado de fundición. Cuenta con una excelente resistencia a la abrasión y ofrece una prolongada vida útil gracias al control de la virutas y el agrietamiento térmico que se produce durante el taladrado de funciones nodulares.

VP15TF

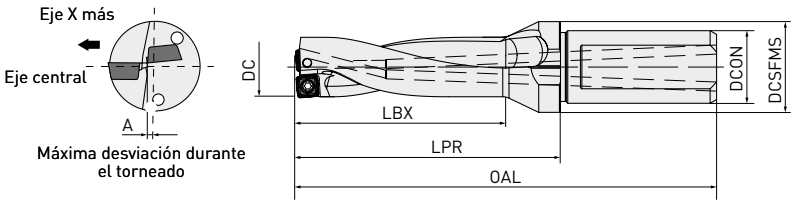
VP15TF es un recubrimiento de PVD ideal para una amplia gama de aplicaciones. El sustrato de micrograno y el recubrimiento Miracle ofrecen una excelente resistencia a la abrasión.

TF15

La calidad TF15 es un metal duro micrograno sin recubrimiento con un afilado filo de corte para el taladrado de aleaciones de aluminio.

MINI MVX

P M K

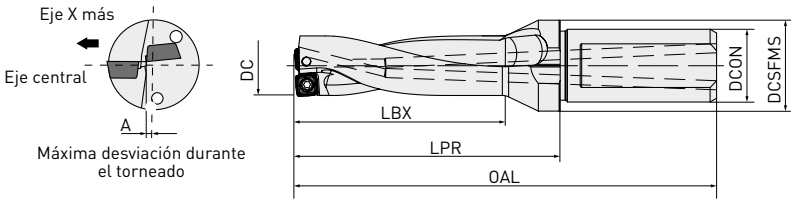


Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX1400X2F20	14.0	2	●	35	50	93	20	25	0.6	SO◌X05
MVX1400X3F20		3	●	49	64	107	20	25	0.6	
MVX1400X4F20		4	●	63	78	121	20	25	0.6	
MVX1400X5F20		5	●	77	92	135	20	25	0.6	
MVX1450X2F20	14.5	2	●	36	51	94	20	25	0.5	SO◌X05
MVX1450X3F20		3	●	50.5	65.5	108.5	20	25	0.5	
MVX1450X4F20		4	●	65	80	123	20	25	0.5	
MVX1450X5F20		5	●	79.5	94.5	137.5	20	25	0.5	
MVX1500X2F20	15.0	2	●	37	52	95	20	25	0.35	SO◌X05
MVX1500X3F20		3	●	52	67	110	20	25	0.35	
MVX1500X4F20		4	●	67	82	125	20	25	0.35	
MVX1500X5F20		5	●	82	97	140	20	25	0.35	
MVX1550X2F20	15.5	2	●	38	53	96	20	25	0.3	SO◌X05
MVX1550X3F20		3	●	53.5	68.5	111.5	20	25	0.3	
MVX1550X4F20		4	●	69	84	127	20	25	0.3	
MVX1550X5F20		5	●	84.5	99.5	142.5	20	25	0.3	
MVX1600X2F20	16.0	2	●	39	54	97	20	25	0.25	SO◌X05
MVX1600X3F20		3	●	55	70	113	20	25	0.25	
MVX1600X4F20		4	●	71	86	129	20	25	0.25	
MVX1600X5F20		5	●	87	102	145	20	25	0.25	
MVX1650X2F20	16.5	2	●	40	55	98	20	25	0.25	SO◌X05
MVX1650X3F20		3	●	56.5	71.5	114.5	20	25	0.25	
MVX1650X4F20		4	●	73	88	131	20	25	0.25	
MVX1650X5F20		5	●	89.5	104.5	147.5	20	25	0.25	

● : Stock Europa. ★ : Stock Japón.

MVX

P M K N H



Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX1700X2F20	17.0	2	●	41	56	99	20	25	0.5	SO◌X06
MVX1700X3F20		3	●	58	73	116	20	25	0.5	
MVX1700X4F20		4	●	75	90	133	20	25	0.5	
MVX1700X5F20		5	●	92	107	150	20	25	0.5	
MVX1700X6F20		6	●	109	124	167	20	25	0.5	
MVX1750X2F25	17.5	2	●	42	62	112	25	32	0.45	SO◌X06
MVX1750X3F25		3	●	59.5	79.5	129.5	25	32	0.45	
MVX1750X4F25		4	●	77	97	147	25	32	0.45	
MVX1750X5F25		5	●	94.5	114.5	164.5	25	32	0.45	
MVX1750X6F25		6	●	112	132	182	25	32	0.45	
MVX1800X2F25	18.0	2	●	43	63	113	25	32	0.4	SO◌X06
MVX1800X3F25		3	●	61	81	131	25	32	0.4	
MVX1800X4F25		4	●	79	99	149	25	32	0.4	
MVX1800X5F25		5	●	97	117	167	25	32	0.4	
MVX1800X6F25		6	●	115	135	185	25	32	0.4	
MVX1850X2F25	18.5	2	●	44	64	114	25	32	0.35	SO◌X06
MVX1850X3F25		3	●	62.5	82.5	132.5	25	32	0.35	
MVX1850X4F25		4	●	81	101	151	25	32	0.35	
MVX1850X5F25		5	●	99.5	119.5	169.5	25	32	0.35	
MVX1850X6F25		6	●	118	138	188	25	32	0.35	
MVX1900X2F25	19.0	2	●	45	65	115	25	32	0.3	SO◌X06
MVX1900X3F25		3	●	64	84	134	25	32	0.3	
MVX1900X4F25		4	●	83	103	153	25	32	0.3	
MVX1900X5F25		5	●	102	122	172	25	32	0.3	
MVX1900X6F25		6	●	121	141	191	25	32	0.3	
MVX1950X2F25	19.5	2	●	46	66	116	25	32	0.25	SO◌X06
MVX1950X3F25		3	●	65.5	85.5	135.5	25	32	0.25	
MVX1950X4F25		4	●	85	105	155	25	32	0.25	
MVX1950X5F25		5	●	104.5	124.5	174.5	25	32	0.25	
MVX1950X6F25		6	●	124	144	194	25	32	0.25	
MVX2000X2F25	20.0	2	●	47	67	117	25	32	0.6	SO◌X07
MVX2000X3F25		3	●	67	87	137	25	32	0.6	
MVX2000X4F25		4	●	87	107	157	25	32	0.6	
MVX2000X5F25		5	●	107	127	177	25	32	0.6	
MVX2000X6F25		6	●	127	147	197	25	32	0.6	
MVX2050X2F25	20.5	2	●	48	68	118	25	32	0.55	SO◌X07
MVX2050X3F25		3	●	68.5	88.5	138.5	25	32	0.55	

● : Stock Europa. ★ : Stock Japón.

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX2100X2F25		2	●	49	69	119	25	32	0.5	
MVX2100X3F25		3	●	70	90	140	25	32	0.5	
MVX2100X4F25	21.0	4	●	91	111	161	25	32	0.5	SO◌X07
MVX2100X5F25		5	●	112	132	182	25	32	0.5	
MVX2100X6F25		6	●	133	153	203	25	32	0.5	
MVX2150X2F25	21.5	2	●	50	70	120	25	32	0.45	SO◌X07
MVX2150X3F25		3	●	71.5	91.5	141.5	25	32	0.45	
MVX2200X2F25		2	●	51	71	121	25	32	0.4	
MVX2200X3F25		3	●	73	93	143	25	32	0.4	
MVX2200X4F25	22.0	4	●	95	115	165	25	32	0.4	SO◌X07
MVX2200X5F25		5	●	117	137	187	25	32	0.4	
MVX2200X6F25		6	●	139	159	209	25	32	0.4	
MVX2250X2F25	22.5	2	●	52	72	122	25	32	0.35	SO◌X07
MVX2250X3F25		3	●	74.5	94.5	144.5	25	32	0.35	
MVX2300X2F25		2	●	53	73	123	25	32	0.8	
MVX2300X3F25		3	●	76	96	146	25	32	0.8	
MVX2300X4F25	23.0	4	●	99	119	169	25	32	0.8	SO◌X08
MVX2300X5F25		5	●	122	142	192	25	32	0.8	
MVX2300X6F25		6	●	145	165	215	25	32	0.8	
MVX2350X2F25	23.5	2	●	54	74	124	25	32	0.75	SO◌X08
MVX2350X3F25		3	●	77.5	97.5	147.5	25	32	0.75	
MVX2400X2F25		2	●	55	75	125	25	32	0.7	
MVX2400X3F25		3	●	79	99	149	25	32	0.7	
MVX2400X4F25	24.0	4	●	103	123	173	25	32	0.7	
MVX2400X5F25		5	●	127	147	197	25	32	0.7	SO◌X08
MVX2400X6F25		6	●	151	171	221	25	32	0.7	
MVX2450X2F25	24.5	2	●	56	76	126	25	32	0.65	
MVX2450X3F25		3	●	80.5	100.5	150.5	25	32	0.65	
MVX2500X2F25		2	●	57	77	127	25	32	0.6	
MVX2500X3F25		3	●	82	102	152	25	32	0.6	
MVX2500X4F25	25.0	4	●	107	127	177	25	32	0.6	SO◌X08
MVX2500X5F25		5	●	132	152	202	25	32	0.6	
MVX2500X6F25		6	●	157	177	227	25	32	0.6	
MVX2550X2F25	25.5	2	●	58	78	128	25	32	0.6	SO◌X08
MVX2550X3F25		3	●	83.5	103.5	153.5	25	32	0.6	
MVX2600X2F32		2	●	59	79	134	32	42	0.5	
MVX2600X3F32		3	●	85	105	160	32	42	0.5	
MVX2600X4F32	26.0	4	●	111	131	186	32	42	0.5	SO◌X08
MVX2600X5F32		5	●	137	157	212	32	42	0.5	
MVX2600X6F32		6	●	163	183	238	32	42	0.5	
MVX2650X2F32	26.5	2	●	60	80	135	32	42	0.5	SO◌X08
MVX2650X3F32		3	●	86.5	106.5	161.5	32	42	0.5	
MVX2700X2F32		2	●	61	81	136	32	42	0.45	
MVX2700X3F32		3	●	88	108	163	32	42	0.45	
MVX2700X4F32	27.0	4	●	115	135	190	32	42	0.45	SO◌X08
MVX2700X5F32		5	●	142	162	217	32	42	0.45	
MVX2700X6F32		6	●	169	189	244	32	42	0.45	
MVX2750X2F32	27.5	2	●	62	82	137	32	42	0.4	SO◌X08
MVX2750X3F32		3	●	89.5	109.5	164.5	32	42	0.4	

● : Stock Europa. ★ : Stock Japón.

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX2800X2F32		2	●	63	83	138	32	42	0.85	
MVX2800X3F32		3	●	91	111	166	32	42	0.85	
MVX2800X4F32	28.0	4	●	119	139	194	32	42	0.85	SO◌X09
MVX2800X5F32		5	●	147	167	222	32	42	0.85	
MVX2800X6F32		6	●	175	195	250	32	42	0.85	
MVX2850X2F32	28.5	2	●	64	84	139	32	42	0.8	SO◌X09
MVX2850X3F32		3	●	92.5	112.5	167.5	32	42	0.8	
MVX2900X2F32		2	●	65	85	140	32	42	0.75	
MVX2900X3F32		3	●	94	114	169	32	42	0.75	
MVX2900X4F32	29.0	4	●	123	143	198	32	42	0.75	SO◌X09
MVX2900X5F32		5	●	152	172	227	32	42	0.75	
MVX2900X6F32		6	●	181	201	256	32	42	0.75	
MVX2950X2F32	29.5	2	●	66	86	141	32	42	0.7	SO◌X09
MVX2950X3F32		3	●	95.5	115.5	170.5	32	42	0.7	
MVX3000X2F32		2	●	67	87	142	32	42	0.65	
MVX3000X3F32		3	●	97	117	172	32	42	0.65	
MVX3000X4F32	30.0	4	●	127	147	202	32	42	0.65	SO◌X09
MVX3000X5F32		5	●	157	177	232	32	42	0.65	
MVX3000X6F32		6	●	187	207	262	32	42	0.65	
MVX3050X3F32	30.5	3	●	98.5	118.5	173.5	32	42	0.6	SO◌X09
MVX3100X2F40		2	●	69	89	154	40	50	0.55	
MVX3100X3F40		3	●	100	120	185	40	50	0.55	
MVX3100X4F40	31.0	4	●	131	151	216	40	50	0.55	SO◌X09
MVX3100X5F40		5	●	162	182	247	40	50	0.55	
MVX3100X6F40		6	●	193	213	278	40	50	0.55	
MVX3150X3F40	31.5	3	●	101.5	121.5	186.5	40	50	0.55	SO◌X09
MVX3200X2F40		2	●	71	91	156	40	50	0.45	
MVX3200X3F40		3	●	103	123	188	40	50	0.45	
MVX3200X4F40	32.0	4	●	135	155	220	40	50	0.45	SO◌X09
MVX3200X5F40		5	●	167	187	252	40	50	0.45	
MVX3200X6F40		6	●	199	219	284	40	50	0.45	
MVX3250X3F40	32.5	3	●	104.5	124.5	189.5	40	50	0.45	SO◌X09
MVX3300X2F40		2	●	73	93	158	40	50	0.4	
MVX3300X3F40		3	●	106	126	191	40	50	0.4	
MVX3300X4F40	33.0	4	●	139	159	224	40	50	0.4	SO◌X09
MVX3300X5F40		5	●	172	192	257	40	50	0.4	
MVX3300X6F40		6	●	205	225	290	40	50	0.4	
MVX3350X3F40	33.5	3	●	107.5	127.5	192.5	40	50	1.2	SO◌X11
MVX3400X2F40		2	●	75	105	170	40	50	1.1	
MVX3400X3F40		3	●	109	139	204	40	50	1.1	
MVX3400X4F40	34.0	4	●	143	173	238	40	50	1.1	SO◌X11
MVX3400X5F40		5	●	177	207	272	40	50	1.1	
MVX3400X6F40		6	●	211	241	306	40	50	1.1	
MVX3450X3F40	34.5	3	●	110.5	140.5	205.5	40	50	1.1	SO◌X11
MVX3500X2F40		2	●	77	107	172	40	50	1.0	
MVX3500X3F40		3	●	112	142	207	40	50	1.0	
MVX3500X4F40	35.0	4	●	147	177	242	40	50	1.0	SO◌X11
MVX3500X5F40		5	●	182	212	277	40	50	1.0	
MVX3500X6F40		6	●	217	247	312	40	50	1.0	
MVX3550X3F40	35.5	3	●	113.5	143.5	208.5	40	50	1.0	SO◌X11

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX3600X2F40		2	●	79	109	174	40	50	1.0	
MVX3600X3F40		3	●	115	145	210	40	50	1.0	
MVX3600X4F40	36.0	4	●	151	181	246	40	50	1.0	SO○X11
MVX3600X5F40		5	●	187	217	282	40	50	1.0	
MVX3600X6F40		6	●	223	253	318	40	50	0.9	
MVX3700X2F40		2	●	81	111	176	40	50	0.9	
MVX3700X3F40		3	●	118	148	213	40	50	0.9	
MVX3700X4F40	37.0	4	●	155	185	250	40	50	0.9	SO○X11
MVX3700X5F40		5	●	192	222	287	40	50	0.9	
MVX3700X6F40		6	●	229	259	324	40	50	0.9	
MVX3800X2F40		2	●	83	113	178	40	50	0.8	
MVX3800X3F40		3	●	121	151	216	40	50	0.8	
MVX3800X4F40	38.0	4	●	159	189	254	40	50	0.8	SO○X11
MVX3800X5F40		5	●	197	227	292	40	50	0.8	
MVX3800X6F40		6	●	235	265	330	40	50	0.8	
MVX3900X2F40		2	●	85	115	180	40	50	0.7	
MVX3900X3F40		3	●	124	154	219	40	50	0.7	
MVX3900X4F40	39.0	4	●	163	193	258	40	50	0.7	SO○X11
MVX3900X5F40		5	●	202	232	297	40	50	0.7	
MVX3900X6F40		6	●	241	271	336	40	50	0.7	
MVX4000X2F40		2	●	87	117	182	40	50	1.5	
MVX4000X3F40		3	●	127	157	222	40	50	1.5	
MVX4000X4F40	40.0	4	●	167	197	262	40	50	1.5	SO○X13
MVX4000X5F40		5	●	207	237	302	40	50	1.5	
MVX4000X6F40		6	●	247	277	342	40	50	1.4	
MVX4100X2F40		2	●	89	119	184	40	50	1.4	
MVX4100X3F40		3	●	130	160	225	40	50	1.4	
MVX4100X4F40	41.0	4	●	171	201	266	40	50	1.4	SO○X13
MVX4100X5F40		5	●	212	242	307	40	50	1.4	
MVX4100X6F40		6	●	253	283	348	40	50	1.4	
MVX4200X2F40		2	●	91	121	186	40	50	1.3	
MVX4200X3F40		3	●	133	163	228	40	50	1.3	
MVX4200X4F40		4	●	175	205	270	40	63	1.3	
MVX4200X4F50	42.0	4	★	175	205	280	50	63	1.3	SO○X13
MVX4200X5F40		5	●	217	247	312	40	63	1.3	
MVX4200X5F50		5	★	217	247	322	50	63	1.3	
MVX4200X6F40		6	●	259	289	354	40	63	1.3	
MVX4200X6F50		6	★	259	289	364	50	63	1.3	
MVX4300X2F40		2	●	93	123	188	40	50	1.2	
MVX4300X3F40		3	●	136	166	231	40	50	1.2	
MVX4300X4F40		4	●	179	209	274	40	63	1.2	
MVX4300X4F50	43.0	4	★	179	209	284	50	63	1.2	SO○X13
MVX4300X5F40		5	●	222	252	317	40	63	1.2	
MVX4300X5F50		5	★	222	252	327	50	63	1.2	
MVX4300X6F40		6	●	265	295	360	40	63	1.2	
MVX4300X6F50		6	★	265	295	370	50	63	1.2	

● : Stock Europa. ★ : Stock Japón.

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX4400X2F40	44.0	2	●	95	125	190	40	50	1.1	SO○X13
MVX4400X3F40		3	●	139	169	234	40	50	1.1	
MVX4400X4F40		4	●	183	213	278	40	63	1.1	
MVX4400X4F50		4	★	183	213	288	50	63	1.1	
MVX4400X5F40		5	●	227	257	322	40	63	1.1	
MVX4400X5F50		5	★	227	257	332	50	63	1.1	
MVX4500X2F40	45.0	2	●	97	127	192	40	50	1.0	SO○X13
MVX4500X3F40		3	●	142	172	237	40	50	1.0	
MVX4500X4F40		4	●	187	217	282	40	63	1.0	
MVX4500X4F50		4	★	187	217	292	50	63	1.0	
MVX4500X5F40		5	●	232	262	327	40	63	1.0	
MVX4500X5F50		5	★	232	262	337	50	63	1.0	
MVX4600X2F40	46.0	2	●	99	129	194	40	50	0.9	SO○X13
MVX4600X3F40		3	●	145	175	240	40	50	0.9	
MVX4600X4F40		4	●	191	221	286	40	63	0.9	
MVX4600X4F50		4	★	191	221	296	50	63	0.9	
MVX4600X5F40		5	●	237	267	332	40	63	0.9	
MVX4600X5F50		5	★	237	267	342	50	63	0.9	
MVX4700X2F40	47.0	2	●	101	141	206	40	63	1.9	SO○X16
MVX4700X3F40		3	●	148	188	253	40	63	1.9	
MVX4700X4F40		4	●	195	235	300	40	63	1.9	
MVX4700X4F50		4	★	195	235	310	50	63	1.9	
MVX4700X5F40		5	●	242	282	347	40	63	1.9	
MVX4700X5F50		5	★	242	282	357	50	63	1.9	
MVX4800X2F40	48.0	2	●	103	143	208	40	63	1.8	SO○X16
MVX4800X3F40		3	●	151	191	256	40	63	1.8	
MVX4800X4F40		4	●	199	239	304	40	63	1.8	
MVX4800X4F50		4	★	199	239	314	50	63	1.8	
MVX4800X5F40		5	●	247	287	352	40	63	1.8	
MVX4800X5F50		5	★	247	287	362	50	63	1.8	
MVX4900X2F40	49.0	2	●	105	145	210	40	63	1.7	SO○X16
MVX4900X3F40		3	●	154	194	259	40	63	1.7	
MVX4900X4F40		4	●	203	243	308	40	63	1.7	
MVX4900X4F50		4	★	203	243	318	50	63	1.7	
MVX4900X5F40		5	●	252	292	357	40	63	1.7	
MVX4900X5F50		5	★	252	292	367	50	63	1.7	
MVX5000X2F40	50.0	2	●	107	147	212	40	63	1.6	SO○X16
MVX5000X3F40		3	●	157	197	262	40	63	1.6	
MVX5000X4F40		4	●	207	247	312	40	63	1.6	
MVX5000X4F50		4	★	207	247	322	50	63	1.6	
MVX5000X5F40		5	●	257	297	362	40	63	1.6	
MVX5000X5F50		5	★	257	297	372	50	63	1.6	
MVX5100X2F40	51.0	2	●	109	149	214	40	63	1.5	SO○X16
MVX5100X3F40		3	●	160	200	265	40	63	1.5	
MVX5100X4F40		4	●	211	251	316	40	63	1.5	
MVX5100X4F50		4	★	211	251	326	50	63	1.5	
MVX5100X5F40		5	●	262	302	367	40	63	1.5	
MVX5100X5F50		5	★	262	302	377	50	63	1.5	

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX5200X2F40	52.0	2	●	111	151	216	40	63	1.4	SO○X16
MVX5200X3F40		3	●	163	203	268	40	63	1.4	
MVX5200X4F40		4	●	215	255	320	40	63	1.4	
MVX5200X4F50		4	★	215	255	330	50	63	1.4	
MVX5200X5F40		5	●	267	307	372	40	63	1.4	
MVX5200X5F50		5	★	267	307	382	50	63	1.4	
MVX5300X2F40	53.0	2	●	113	153	218	40	63	1.3	SO○X16
MVX5300X3F40		3	●	166	206	271	40	63	1.3	
MVX5300X4F40		4	●	219	259	324	40	63	1.3	
MVX5300X4F50		4	★	219	259	334	50	63	1.3	
MVX5300X5F40		5	●	272	312	377	40	63	1.3	
MVX5300X5F50		5	★	272	312	387	50	63	1.3	
MVX5400X2F40	54.0	2	●	115	155	220	40	63	1.2	SO○X16
MVX5400X3F40		3	●	169	209	274	40	63	1.2	
MVX5400X4F40		4	●	223	263	328	40	63	1.2	
MVX5400X4F50		4	★	223	263	338	50	63	1.2	
MVX5400X5F40		5	●	277	317	382	40	63	1.2	
MVX5400X5F50		5	★	277	317	392	50	63	1.2	
MVX5500X2F40	55.0	2	●	117	157	222	40	63	1.1	SO○X16
MVX5500X3F40		3	●	172	212	277	40	63	1.1	
MVX5500X4F40		4	●	227	267	332	40	63	1.1	
MVX5500X4F50		4	★	227	267	342	50	63	1.1	
MVX5500X5F40		5	●	282	322	387	40	63	1.1	
MVX5500X5F50		5	★	282	322	397	50	63	1.1	
MVX5600X2F40	56.0	2	●	119	159	224	40	63	1.0	SO○X16
MVX5600X3F40		3	●	175	215	280	40	63	1.0	
MVX5600X4F40		4	●	231	271	336	40	63	1.0	
MVX5600X4F50		4	★	231	271	346	50	63	1.0	
MVX5600X5F40		5	●	287	327	392	40	63	1.0	
MVX5600X5F50		5	★	287	327	402	50	63	1.0	
MVX5700X2F40	57.0	2	●	121	161	226	40	68	1.5	SO○X18
MVX5700X3F40		3	●	178	218	283	40	68	1.5	
MVX5700X4F40		4	●	235	275	340	40	68	1.5	
MVX5700X4F50		4	★	235	275	350	50	68	1.5	
MVX5700X5F40		5	●	292	332	397	40	68	1.5	
MVX5700X5F50		5	★	292	332	407	50	68	1.5	
MVX5800X2F40	58.0	2	●	123	163	228	40	68	1.4	SO○X18
MVX5800X3F40		3	●	181	221	286	40	68	1.4	
MVX5800X4F40		4	●	239	279	344	40	68	1.4	
MVX5800X4F50		4	★	239	279	354	50	68	1.4	
MVX5800X5F40		5	●	297	337	402	40	68	1.4	
MVX5800X5F50		5	★	297	337	412	50	68	1.4	
MVX5900X2F40	59.0	2	●	125	165	230	40	68	1.3	SO○X18
MVX5900X3F40		3	●	184	224	289	40	68	1.3	
MVX5900X4F40		4	●	243	283	348	40	68	1.3	
MVX5900X4F50		4	★	243	283	358	50	68	1.3	
MVX5900X5F40		5	●	302	342	407	40	68	1.3	
MVX5900X5F50		5	★	302	342	417	50	68	1.3	

● : Stock Europa. ★ : Stock Japón.

MVX

Referencia	DC	L x DC	Stock	LBX	LPR	OAL	DCON	DCSFMS	A	Placa
MVX6000X2F40	60.0	2	●	127	167	232	40	68	1.2	SO◌X18
MVX6000X3F40		3	●	187	227	292	40	68	1.2	
MVX6000X4F40		4	●	247	287	352	40	68	1.2	
MVX6000X4F50		4	★	247	287	362	50	68	1.2	
MVX6000X5F40		5	●	307	347	412	40	68	1.2	
MVX6000X5F50		5	★	307	347	422	50	68	1.2	
MVX6100X2F40	61.0	2	●	129	169	234	40	68	1.1	SO◌X18
MVX6100X3F40		3	●	190	230	295	40	68	1.1	
MVX6100X4F40		4	●	251	291	356	40	68	1.1	
MVX6100X4F50		4	★	251	291	366	50	68	1.1	
MVX6100X5F40		5	●	312	352	417	40	68	1.1	
MVX6100X5F50		5	★	312	352	427	50	68	1.1	
MVX6200X2F40	62.0	2	●	131	171	236	40	68	1.0	SO◌X18
MVX6200X3F40		3	●	193	233	298	40	68	1.0	
MVX6200X4F40		4	●	255	295	360	40	68	1.0	
MVX6200X4F50		4	★	255	295	370	50	68	1.0	
MVX6200X5F40		5	●	317	357	422	40	68	1.0	
MVX6200X5F50		5	★	317	357	432	50	68	1.0	
MVX6300X2F40	63.0	2	●	133	173	238	40	68	0.8	SO◌X18
MVX6300X3F40		3	●	196	236	301	40	68	0.8	
MVX6300X4F40		4	●	259	299	364	40	68	0.8	
MVX6300X4F50		4	★	259	299	374	50	68	0.8	
MVX6300X5F40		5	●	322	362	427	40	68	0.8	
MVX6300X5F50		5	★	322	362	437	50	68	0.8	

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17 Vc

● : Stock Europa. ★ : Stock Japón.

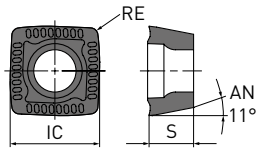
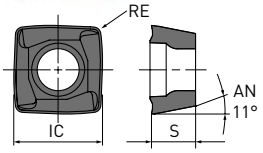
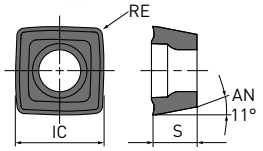
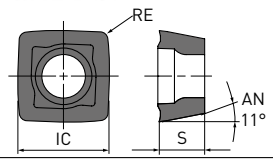
REPUESTOS

Diámetro de la broca (mm)	 Tornillo roscado	Par de sujeción (Nm)	Llave	
14 – 16.5	TPS20-1	0.6	TIP06F	
17 – 19.5	TPS25	1.0	TIP07F	
20 – 22.5	TPS3	2.0	TIP10W	
23 – 27.5	TPS351	2.5	TIP10W	
28 – 33	TPS4	3.5	TIP15W	
33.5 – 46	TPS43	3.5	TIP15W	
47 – 63	TPS54	7.5	TIP25D	

TOLERANCIA AL MECANIZADO

L x DC	Ø 14 – 33	Ø 17 – 33	Ø 33.5 – 47	Ø 48 – 63
2-3	+ 0.25 0	+ 0.25 0	+ 0.3 0	+ 0.3 0
4-5	+ 0.35 0	+ 0.35 0	+ 0.4 0	+ 0.45 0
6	+ 0.45 0	+ 0.45 0	+ 0.6 0	—

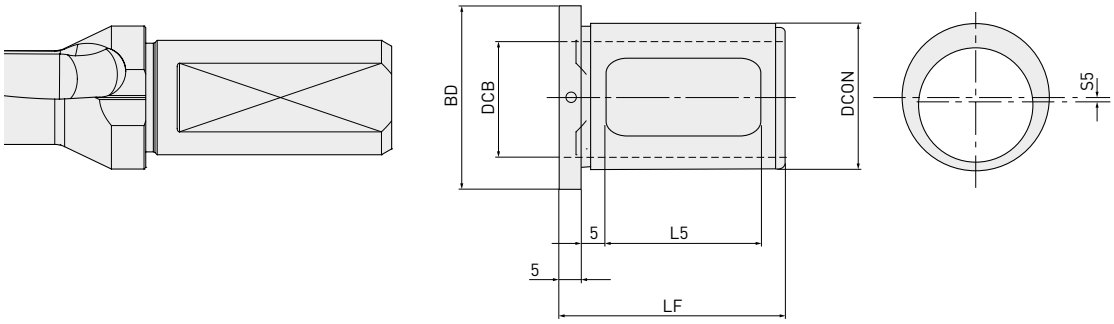
PLACAS

Referencia	MC5020 *	MC1020 *	VP15TF	DP8020	TF15	IC	S	RE	Diám. broca	Forma
UM										
SOMX052704-UM	●	●	●			5.0	2.7	0.4	Ø14 – 16.5	
SOMX063005-UM	●	●	●			6.0	3.0	0.5	Ø17 – 19.5	
SOMX073505-UM	●	●	●			7.0	3.5	0.5	Ø20 – 22.5	
SOMX084005-UM	●	●	●			8.3	4.0	0.5	Ø23 – 27.5	
SOMX094506-UM	●	●	●			9.7	4.5	0.6	Ø28 – 33	
SOMX115506-UM	●	●	●			11.6	5.5	0.6	Ø33.5 – 39	
SOMX136008-UM	●	●	●			13.8	6.0	0.8	Ø40 – 46	
SOMX166508-UM	●	●	●			16.5	6.5	0.8	Ø47 – 56	
SOMX187008-UM	●	●	●			18.2	7.0	0.8	Ø57 – 63	
US										
SOMX063005-US			●			6.0	3.0	0.5	Ø17 – 19.5	
SOMX073505-US			●			7.0	3.5	0.5	Ø20 – 22.5	
SOMX084005-US			●			8.3	4.0	0.5	Ø23 – 27.5	
SOMX094506-US			●			9.7	4.5	0.6	Ø28 – 33	
SOMX115506-US			●			11.6	5.5	0.6	Ø33.5 – 39	
SOMX136008-US			●			13.8	6.0	0.8	Ø40 – 46	
SOMX166508-US			●			16.5	6.5	0.8	Ø47 – 56	
SOMX187008-US			●			18.2	7.0	0.8	Ø57 – 63	
UH										
SOMX062905-UH				●		6.0	2.9	0.5	Ø17 – 19.5	
SOMX073405-UH				●		7.0	3.4	0.5	Ø20 – 22.5	
SOMX083905-UH				●		8.3	3.9	0.5	Ø23 – 27.5	
SOMX094406-UH				●		9.7	4.4	0.6	Ø28 – 33	
SOMX115406-UH				●		11.6	5.4	0.6	Ø33.5 – 39	
SOMX135908-UH				●		13.8	5.9	0.8	Ø40 – 46	
SOMX166408-UH				●		16.5	6.4	0.8	Ø47 – 56	
SOMX186908-UH				●		18.2	6.9	0.8	Ø57 – 63	
UN										
SOGX063005-UN					●	6.0	3.0	0.5	Ø17 – 19.5	
SOGX073505-UN					●	7.0	3.5	0.5	Ø20 – 22.5	
SOGX084005-UN					●	8.3	4.0	0.5	Ø23 – 27.5	
SOGX094506-UN					●	9.7	4.5	0.6	Ø28 – 33	
SOGX115506-UN					●	11.6	5.5	0.6	Ø33.5 – 39	
SOGX136008-UN					●	13.8	6.0	0.8	Ø40 – 46	
SOGX166508-UN					●	16.5	6.5	0.8	Ø47 – 56	
SOGX187008-UN					●	18.2	7.0	0.8	Ø57 – 63	

* Las calidades MC1020 y MC5020 se han diseñado exclusivamente para su uso como placa exterior.

Vc 17

JUST FIT SLEEVE [JFS]
AUMENTO DEL DIÁMETRO DE CORTE



Referencia	Referencia kit	Stock	DCB	DCON	BD	LF	L5	Aumento * (S5×2)	Tipo de mango MVX
JFS2520-10	JFS-1	●	20	25	33	43	30	0.1	F20
JFS2520-20		●	20	25	33	43	30	0.2	F20
JFS2520-30		●	20	25	33	43	30	0.3	F20
JFS2520-40		●	20	25	33	43	30	0.4	F20
JFS2520-50		●	20	25	33	43	30	0.5	F20
JFS3225-10	JFS-2	●	25	32	40	50	34	0.1	F25
JFS3225-20		●	25	32	40	50	34	0.2	F25
JFS3225-30		●	25	32	40	50	34	0.3	F25
JFS3225-40		●	25	32	40	50	34	0.4	F25
JFS3225-50		●	25	32	40	50	34	0.5	F25
JFS4032-10	JFS-3	●	32	40	48	55	40	0.1	F32
JFS4032-20		●	32	40	48	55	40	0.2	F32
JFS4032-30		●	32	40	48	55	40	0.3	F32
JFS4032-40		●	32	40	48	55	40	0.4	F32
JFS4032-50		●	32	40	48	55	40	0.5	F32
JFS5040-10	—	★	40	50	68	65	50	0.1	F40
JFS5040-20		★	40	50	68	65	50	0.2	F40
JFS5040-30		★	40	50	68	65	50	0.3	F40
JFS5040-40		★	40	50	68	65	50	0.4	F40
JFS5040-50		★	40	50	68	65	50	0.5	F40

* Aumento: tamaño del diámetro de corte aumentado.
1. No compatible con mangos de Ø 50 mm.

GUIA PARA ELEGIR JUST FIT SLEEVE

Diámt. Deseado = Broca Ø + Incremento de JFS + 0.1 mm

(Ej.) El diámetro deseado es 20.3 mm la tolerancia que tomamos es de 0.1 mm.

Ø20.3 = (MVX2000 X ○F25 + JFS3225-20) + 0.1

- MVX2000 X ○F25 → Broca de 20 mm
- JFS3225-20 → Utilizando JFS un incremento de 0.2 mm.
- 0.1 → Voladizo

<Herramienta seleccionada>
Broca: **MVX2000 X ○F25**
Just fit sleeve [JFS]:
JFS3225-20

1. La tolerancia puede variar debido a las condiciones de corte utilizadas, por favor siga la tabla de arriba

PEDIDOS DE JUST FIT SLEEVE

Método de compra 1

La tolerancia puede variar en función de las condiciones de corte utilizadas. Por lo tanto, se recomienda comprar como un lote. Cuando haga un pedido, utilice las referencias indicadas. (5 fundas/lote)

Método de compra 2

Es posible hacer pedidos individualmente. Cuando haga un pedido, utilice las referencias individuales.

● : Stock Europa. ★ : Stock Japón.

MVX + MINI MVX

CONDICIONES DE CORTE RECOMENDADAS

	Material de trabajo	Dureza	Vc	Rompevirutas interior	Ø14 – Ø16.5 f			Ø17 – Ø19.5 f			
					LxDC=2 – 3	LxDC=4	LxDC=5	LxDC=2 – 3	LxDC=4	LxDC=5	LxDC=6
P	Acero dulce (C15, Ck15)	≤180 HB	200 (180 – 235)	UM	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.04 (0.04 – 0.05)
				UH	–	–	–				
	Acero al carbono, acero aleado (Ck45, 41CrMo4)	180 – 280HB	140 (115 –180)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 – 0.14)	0.08 (0.06 – 0.09)	0.08 (0.06 – 0.09)	0.05 (0.04 – 0.06)
				UH	–	–	–				
	Acero al carbono, acero aleado (100Cr6)	280 – 350HB	100 (75 – 140)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 – 0.14)	0.08 (0.06 – 0.09)	0.08 (0.06 – 0.09)	0.05 (0.04 – 0.06)
				UH	–	–	–				
	Acero para herramientas de aleación (X210Cr12)	≤350 HB	135 (100 – 170)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.08 (0.06 – 0.14)	0.08 (0.06 – 0.09)	0.08 (0.06 – 0.09)	0.05 (0.04 – 0.06)
				UH	–	–	–				
M	Acero inoxidable austenítico (X5CrNi18-10, X5CrNiMo17-12-2)	≤200 HB	130 (80 – 180)	US	–	–	–	0.08 (0.06 – 0.12)	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.04 (0.04 – 0.05)
	Acero inoxidable austenítico (X2CrNiN18-9, X5CrNiMoN17-11-2)	>200HB	130 (80 – 180)	US	–	–	–	0.08 (0.06 – 0.12)	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.04 (0.04 – 0.05)
	Acero inoxidable ferrítico y martensítico (X12Cr13, X6Cr17)	≤200 HB	120 (80 – 165)	US	–	–	–	0.08 (0.06 – 0.12)	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.04 (0.04 – 0.05)
	Acero inoxidable ferrítico y martensítico (X17CrNi16-2, X30Cr13)	>200HB	120 (80 – 165)	US	–	–	–	0.08 (0.06 – 0.12)	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.06 (0.04 – 0.08)	0.05 (0.04 – 0.06)	0.05 (0.04 – 0.06)	0.04 (0.04 – 0.05)
K	Fundición gris (GG25, GG30)	Resistencia a la tracción ≤350 MPa	160 (130 – 195)	UM	0.10 (0.06 - 0.14)	0.08 (0.06 - 0.10)	0.08 (0.06 - 0.10)	0.11 (0.08 – 0.14)	0.09 (0.08 – 0.10)	0.09 (0.08 – 0.10)	0.05 (0.04 – 0.06)
	Fundición dúctil (GGG40)	Resistencia a la tracción ≤450 MPa	100 (80 – 135)	UM	0.10 (0.06 - 0.14)	0.08 (0.06 - 0.10)	0.08 (0.06 - 0.10)	0.11 (0.08 – 0.14)	0.09 (0.08 – 0.10)	0.09 (0.08 – 0.10)	0.05 (0.04 – 0.06)
	Fundición dúctil (GGG70)	Resistencia a la tracción ≤800 MPa	100 (70 – 125)	UM	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.11 (0.08 – 0.14)	0.09 (0.08 – 0.10)	0.09 (0.08 – 0.10)	0.05 (0.04 – 0.06)
N	Aleación de aluminio (A6061, A7075)	Si<5%	200 (100 – 350)	UN	–	–	–	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	Aleación de aluminio (AC4B)	5%≤Si≤10%	150 (100 – 200)	UN	–	–	–	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	Aleación de aluminio (ADC12, A390)	Si>10%	150 (100 – 200)	UN	–	–	–	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
H	Acero endurecido (X40CrMoV51, 55NiCrMoV6)	38 – 45HRC	50 (30 – 80)	UH	–	–	–	0.08 (0.04 – 0.12)	0.06 (0.04 – 0.09)	–	–

MVX + MINI MVX CONDICIONES DE CORTE RECOMENDADAS

	Vc	Rompevirutas interior	Ø20 – Ø23.5 f				Ø24 – Ø29.5 f				Ø30 – Ø63 f			
			LxDC=2–3	LxDC=4	LxDC=5	LxDC=6	LxDC=2–3	LxDC=4	LxDC=5	LxDC=6	LxDC=2–3	LxDC=4	LxDC=5	LxDC=6
P	200 (180 – 235)	UM	0.06 (0.04 – 0.08)	0.06 (0.04 – 0.07)	0.06 (0.04 – 0.07)	0.04 (0.04 – 0.05)	0.07 (0.04 – 0.08)	0.06 (0.04 – 0.07)	0.06 (0.04 – 0.07)	0.05 (0.04 – 0.06)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)
		UH												
	140 (115 –180)	UM	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.11 (0.10 – 0.12)
		UH												
	100 (75 – 140)	UM	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.11 (0.10 – 0.12)
		UH												
	135 (100 – 170)	UM	0.10 (0.06 – 0.18)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.12 (0.08 – 0.18)	0.10 (0.08 – 0.12)	0.10 (0.08 – 0.12)	0.09 (0.08 – 0.10)	0.14 (0.08 – 0.20)	0.12 (0.08 – 0.16)	0.12 (0.08 – 0.16)	0.10 (0.08 – 0.12)
		UH												
M	130 (80 – 180)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
	130 (80 – 180)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
	120 (80 – 165)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
	120 (80 – 165)	US	0.10 (0.06 – 0.14)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.10 (0.06 – 0.14)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)	0.10 (0.06 – 0.14)	0.09 (0.06 – 0.12)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.10)
		UM	0.08 (0.06 – 0.12)	0.07 (0.06 – 0.08)	0.07 (0.06 – 0.08)	0.06 (0.06 – 0.07)	0.09 (0.06 – 0.12)	0.07 (0.06 – 0.09)	0.07 (0.06 – 0.09)	0.06 (0.06 – 0.08)	0.09 (0.06 – 0.12)	0.08 (0.06 – 0.10)	0.08 (0.06 – 0.10)	0.07 (0.06 – 0.08)
K	160 (130 – 195)	UM	0.14 (0.10 – 0.18)	0.10 (0.10 – 0.12)	0.10 (0.10 – 0.12)	0.07 (0.06 – 0.08)	0.15 (0.10 – 0.20)	0.11 (0.10 – 0.13)	0.11 (0.10 – 0.13)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
	100 (80 – 135)	UM	0.13 (0.10 – 0.16)	0.10 (0.10 – 0.11)	0.10 (0.10 – 0.11)	0.07 (0.06 – 0.08)	0.14 (0.10 – 0.18)	0.11 (0.10 – 0.12)	0.11 (0.10 – 0.12)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
	100 (70 – 125)	UM	0.13 (0.10 – 0.16)	0.10 (0.10 – 0.11)	0.10 (0.10 – 0.11)	0.07 (0.06 – 0.08)	0.14 (0.10 – 0.18)	0.11 (0.10 – 0.12)	0.11 (0.10 – 0.12)	0.09 (0.08 – 0.10)	0.15 (0.10 – 0.20)	0.12 (0.10 – 0.13)	0.12 (0.10 – 0.13)	0.11 (0.10 – 0.12)
N	200 (100 – 350)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	150 (100 – 200)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
	150 (100 – 200)	UN	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)	0.12 (0.05 – 0.20)	0.12 (0.05 – 0.18)	0.12 (0.05 – 0.18)	0.08 (0.05 – 0.12)
H	50 (30 – 80)	UH	0.09 (0.06 – 0.14)	0.07 (0.06 – 0.09)	–	–	0.09 (0.06 – 0.14)	0.07 (0.06 – 0.09)	–	–	0.11 (0.06 – 0.16)	0.09 (0.06 – 0.012)	–	–

1. Reduce un 30 % la velocidad de corte al usar VP15TF como placa exterior.
2. L/D = 3 es la profundidad máxima recomendada si se utiliza refrigerante externo.
3. La refrigeración interna es esencial para el taladrado de acero inoxidable.

NOTAS

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