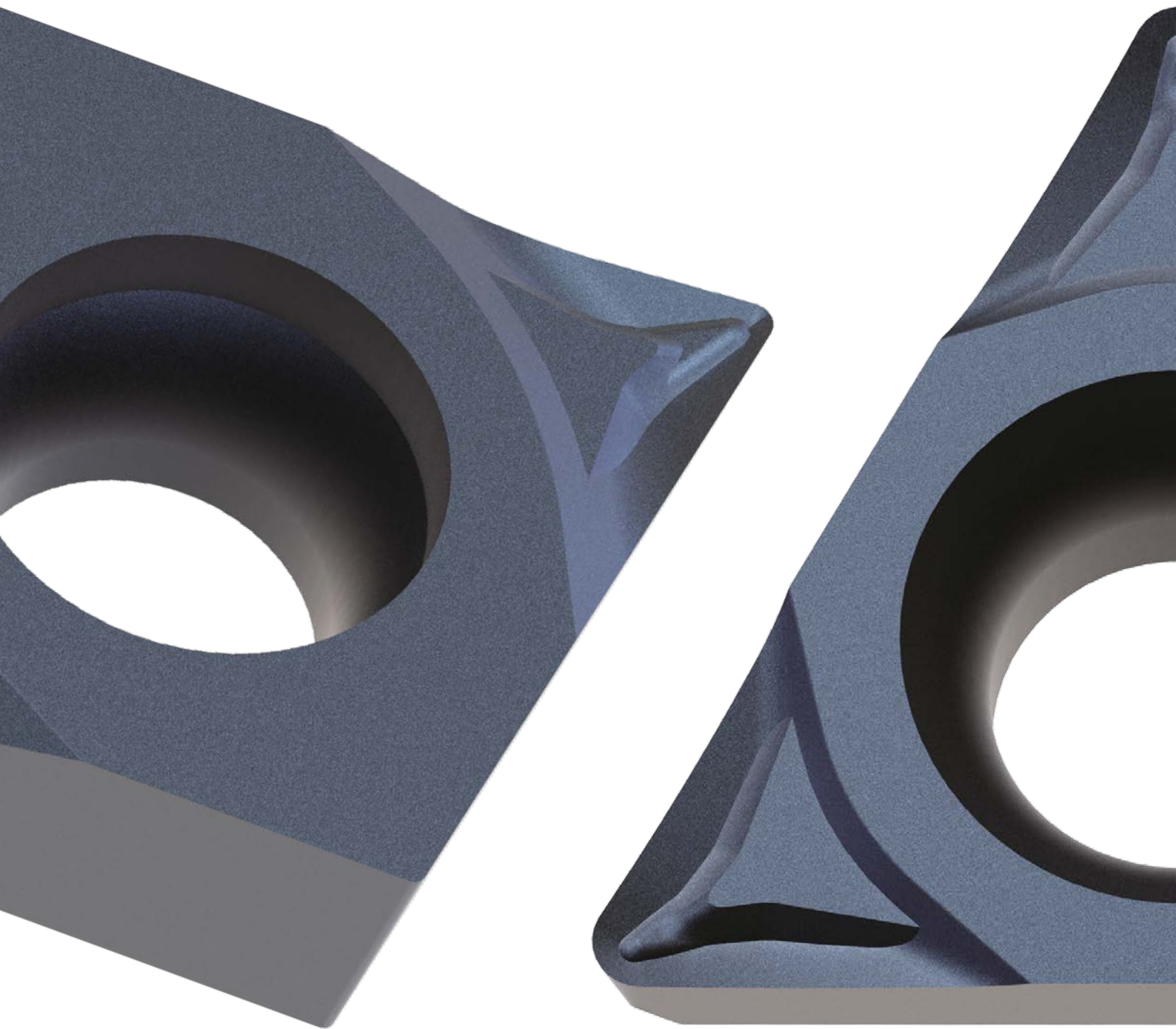


**NEW**

# ROMPITRUCIOLO FSF/FSF-P

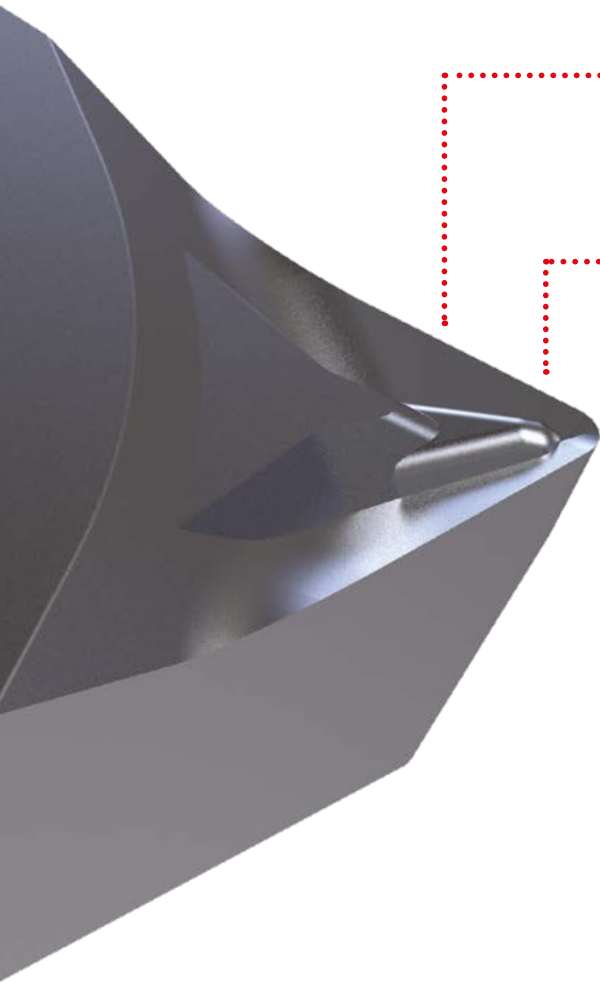
IDEALE PER PICCOLE PROFONDITÀ DI PASSATA E  
OPERAZIONI DI FINITURA

B2101-I



# ROMPITRUCIOLO FSF/FSP-P

## ROMPITRUCIOLO PER PICCOLE PROFONDITÀ DI TAGLIO



### TAGLIENTE AFFILATO

L'angolo di spoglia di 25° garantisce un tagliente affilato ed una finitura estremamente accurata.

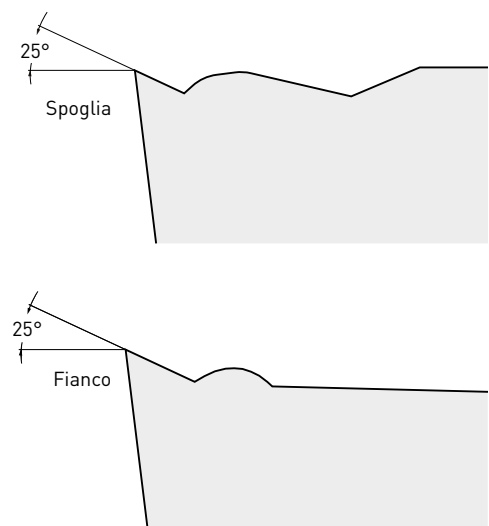
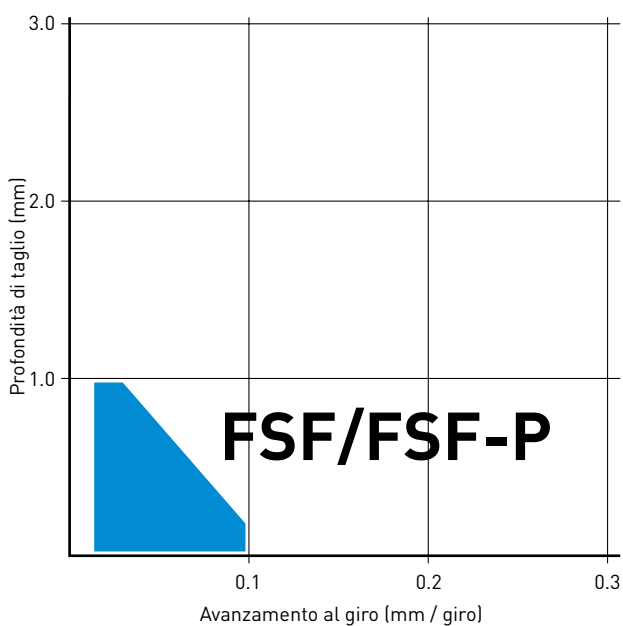
### BASSA RESISTENZA AL TAGLIO

Geometria a bassa resistenza di taglio con lieve sporgenza del rompitruciolo.

### ROMPITRUCIOLO A PIÙ STADI

Adatto alle variazioni di profondità di taglio.

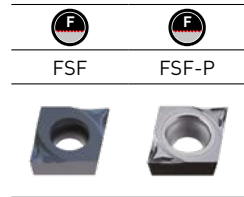
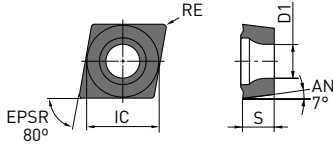
## CAMPO DI APPLICAZIONE



# CCGT

## INSERTI POSITIVI 7° (CON FORO)

### Classe G



| Codice di ordinazione | F M |   | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC    | S    | RE   | D1  |
|-----------------------|-----|---|--------|--------|--------|--------|-------|-------|------|------|-----|
|                       | F   | M |        |        |        |        |       |       |      |      |     |
| CCGT03S101M-FSF       | F   |   | ●      |        |        |        |       | 3.97  | 1.39 | 0.1  | 2.0 |
| CCGT03S102M-FSF       | F   |   | ●      |        |        |        |       | 3.97  | 1.39 | 0.2  | 2.0 |
| CCGT04T001M-FSF       | F   |   | ●      |        |        |        |       | 4.76  | 1.79 | 0.1  | 2.4 |
| CCGT04T002M-FSF       | F   |   | ●      |        |        |        |       | 4.76  | 1.79 | 0.2  | 2.4 |
| CCGT060201M-FSF       | F   |   | ●      |        |        |        |       | 6.35  | 2.38 | 0.1  | 2.8 |
| CCGT060202M-FSF       | F   |   | ●      |        |        |        |       | 6.35  | 2.38 | 0.2  | 2.8 |
| CCGT060204M-FSF       | F   |   | ●      |        |        |        |       | 6.35  | 2.38 | 0.4  | 2.8 |
| CCGT03S101M-FSF-P     | F   |   |        | ●      | ●      |        |       | 3.97  | 1.39 | 0.1  | 2.0 |
| CCGT03S102M-FSF-P     | F   |   |        | ●      | ●      |        |       | 3.97  | 1.39 | 0.2  | 2.0 |
| CCGT04T001M-FSF-P     | F   |   |        | ●      | ●      |        |       | 4.76  | 1.79 | 0.1  | 2.4 |
| CCGT04T002M-FSF-P     | F   |   |        | ●      | ●      |        |       | 4.76  | 1.79 | 0.2  | 2.4 |
| CCGT0602V5M-FSF-P     | F   |   |        | ●      |        | ●      |       | 6.35  | 2.38 | 0.05 | 2.8 |
| CCGT060201M-FSF-P     | F   |   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.1  | 2.8 |
| CCGT060202M-FSF-P     | F   |   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.2  | 2.8 |
| CCGT060204M-FSF-P     | F   |   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.4  | 2.8 |
| CCGT09T3V5M-FSF-P     | F   |   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.05 | 4.4 |
| CCGT09T301M-FSF-P     | F   |   |        | ●      | ●      | ●      |       | 9.525 | 3.97 | 0.1  | 4.4 |
| CCGT09T302M-FSF-P     | F   |   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.2  | 4.4 |
| CCGT09T304M-FSF-P     | F   |   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.4  | 4.4 |

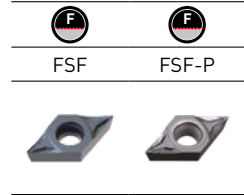
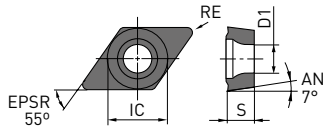
1/1



# DCGT

## INSERTI POSITIVI 7° (CON FORO)

### Classe G



| Codice di ordinazione | F M | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC    | S    | RE   | D1  |
|-----------------------|-----|--------|--------|--------|--------|-------|-------|------|------|-----|
|                       |     |        |        |        |        |       |       |      |      |     |
| DCGT070201M-FSF       | F   | ●      |        |        |        |       | 6.35  | 2.38 | 0.1  | 2.8 |
| DCGT070202M-FSF       | F   | ●      |        |        |        |       | 6.35  | 2.38 | 0.2  | 2.8 |
| DCGT11T301M-FSF       | F   | ●      |        |        |        |       | 9.525 | 3.97 | 0.1  | 4.4 |
| DCGT11T302M-FSF       | F   | ●      |        |        |        |       | 9.525 | 3.97 | 0.2  | 4.4 |
| DCGT0702V5M-FSF-P     | F   |        | ●      |        | ●      |       | 6.35  | 2.38 | 0.05 | 2.8 |
| DCGT070201M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.1  | 2.8 |
| DCGT070202M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.2  | 2.8 |
| DCGT11T3V5M-FSF-P     | F   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.05 | 4.4 |
| DCGT11T301M-FSF-P     | F   |        | ●      | ●      | ●      |       | 9.525 | 3.97 | 0.1  | 4.4 |
| DCGT11T302M-FSF-P     | F   |        | ●      | ●      | ●      |       | 9.525 | 3.97 | 0.2  | 4.4 |
| DCGT11T304M-FSF-P     | F   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.4  | 4.4 |

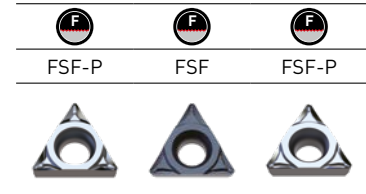
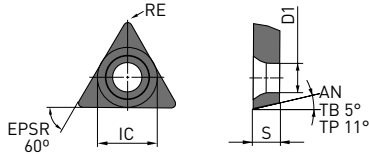
1/1



# TBGT, TPGH

## INSERTI POSITIVI 5°, 11° (CON FORO)

### Classe G



| Codice di ordinazione |   | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC   | S    | RE  | D1  |
|-----------------------|---|--------|--------|--------|--------|-------|------|------|-----|-----|
|                       |   |        |        |        |        |       |      |      |     |     |
| TBGT060102M-FSF-P     | F |        | ●      |        | ●      |       | 3.97 | 1.59 | 0.2 | 2.3 |
| TPGH090201M-FSF       | F | ●      |        |        |        |       | 5.56 | 2.38 | 0.1 | 2.9 |
| TPGH090202M-FSF       | F | ●      |        |        |        |       | 5.56 | 2.38 | 0.2 | 2.9 |
| TPGH090204M-FSF       | F | ●      |        |        |        |       | 5.56 | 2.38 | 0.4 | 2.9 |
| TPGH080201M-FSF-P     | F |        | ●      | ●      | ●      |       | 4.76 | 2.38 | 0.1 | 2.4 |
| TPGH080202M-FSF-P     | F |        | ●      |        | ●      |       | 4.76 | 2.38 | 0.2 | 2.4 |
| TPGH090201M-FSF-P     | F |        | ●      | ●      | ●      |       | 5.56 | 2.38 | 0.1 | 2.9 |
| TPGH090202M-FSF-P     | F |        | ●      | ●      | ●      |       | 5.56 | 2.38 | 0.2 | 2.9 |
| TPGH090204M-FSF-P     | F |        | ●      | ●      | ●      |       | 5.56 | 2.38 | 0.4 | 2.9 |

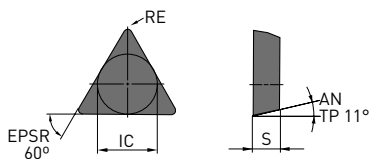
1/1



# TPGB

## INSERTI POSITIVI 11° (SENZA FORO)

### Classe G



Tagliente  
robusto

Petto piano



| Codice di ordinazione |   | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC    | S    | RE   | D1 |
|-----------------------|---|--------|--------|--------|--------|-------|-------|------|------|----|
|                       |   |        |        |        |        |       |       |      |      |    |
| TPGB110202            | M |        |        |        |        | ●     | 6.35  | 2.38 | 0.2  | —  |
| TPGB110204            | M |        |        |        |        | ●     | 6.35  | 2.38 | 0.4  | —  |
| TPGB160304            | M |        |        |        |        | ●     | 9.525 | 3.18 | 0.4  | —  |
| TPGB160308            | M |        |        |        |        | ●     | 9.525 | 3.18 | 0.8  | —  |
| TPGB080202            | M |        |        |        |        | ●     | 4.76  | 2.38 | 0.2  | —  |
| TPGB080204            | M |        |        |        |        | ●     | 4.76  | 2.38 | 0.4  | —  |
| TPGB080208            | M |        |        |        |        | ●     | 4.76  | 2.38 | 0.8  | —  |
| TPGB090202            | M |        |        |        |        | ●     | 5.56  | 2.38 | 0.2  | —  |
| TPGB090204            | M |        |        |        |        | ●     | 5.56  | 2.38 | 0.4  | —  |
| TPGB1102V5            | M |        |        |        |        | ●     | 6.35  | 2.38 | 0.05 | —  |
| TPGN090202            | — |        |        |        |        | ●     | 5.56  | 2.38 | 0.2  | —  |
| TPGN090204            | — |        |        |        |        | ●     | 5.56  | 2.38 | 0.4  | —  |
| TPGN090208            | — |        |        |        |        | ●     | 5.56  | 2.38 | 0.8  | —  |

1/1

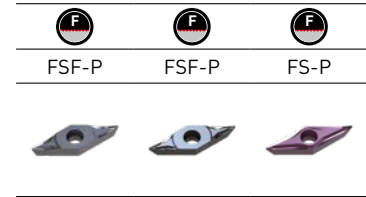
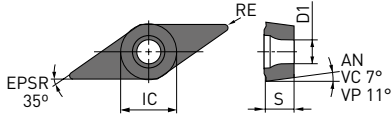
● : Materiale disponibile. ★ : Materiale disponibile in Giappone.



# VCGT, VPGT

## INSERTI POSITIVI 7°, 11° (CON FORO)

Classe G



| Codice di ordinazione | F M | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC   | S    | RE  | D1  |
|-----------------------|-----|--------|--------|--------|--------|-------|------|------|-----|-----|
|                       |     |        |        |        |        |       |      |      |     |     |
| VCGT110301M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35 | 3.18 | 0.1 | 2.8 |
| VCGT110302M-FSF-P     | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.2 | 2.8 |
| VCGT110304M-FSF-P     | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.4 | 2.8 |
| VPGT110301M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35 | 3.18 | 0.1 | 2.9 |
| VPGT110302M-FSF-P     | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.2 | 2.9 |
| VPGT110304M-FSF-P     | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.4 | 2.9 |
| VPGT110301M-FS-P      | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.1 | 2.9 |
| VPGT110302M-FS-P      | F   |        | ●      |        | ●      |       | 6.35 | 3.18 | 0.2 | 2.9 |

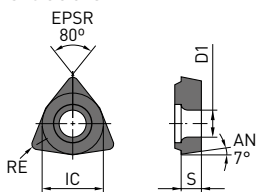
1/1



# WCGT

## INSERTI POSITIVI 7° (CON FORO)

Classe G



| Codice di ordinazione | F M | MP9025 | MS7025 | MS9025 | VP30RT | HT110 | IC    | S    | RE  | D1  |
|-----------------------|-----|--------|--------|--------|--------|-------|-------|------|-----|-----|
|                       |     |        |        |        |        |       |       |      |     |     |
| WCGT020101M-FSF-P     | F   |        | ●      | ●      | ●      |       | 3.97  | 1.59 | 0.1 | 2.3 |
| WCGT020102M-FSF-P     | F   |        | ●      | ●      | ●      |       | 3.97  | 1.59 | 0.2 | 2.3 |
| WCGTL30201M-FSF-P     | F   |        | ●      | ●      | ●      |       | 4.76  | 2.38 | 0.1 | 2.3 |
| WCGTL30202M-FSF-P     | F   |        | ●      | ●      | ●      |       | 4.76  | 2.38 | 0.2 | 2.3 |
| WCGT040201M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.1 | 2.8 |
| WCGT040202M-FSF-P     | F   |        | ●      | ●      | ●      |       | 6.35  | 2.38 | 0.2 | 2.8 |
| WCGT06T301M-FSF-P     | F   |        |        | ●      |        |       | 9.525 | 3.97 | 0.1 | 4.4 |
| WCGT06T302M-FSF-P     | F   |        | ●      | ●      | ●      |       | 9.525 | 3.97 | 0.2 | 4.4 |
| WCGT06T304M-FSF-P     | F   |        | ●      |        | ●      |       | 9.525 | 3.97 | 0.4 | 4.4 |



1/1



# ROMPITRUCIOLO FSF/FSP-P

## CONDIZIONI DI TAGLIO CONSIGLIATE

### VELOCITÀ DI TAGLIO

| Materiale  | Proprietà   |   | Condizione di taglio | MP9025 Vc | MS7025 Vc | MS9025 Vc | VP30RT Vc | HT110 Vc  |
|--|---|---|----------------------|-----------|-----------|-----------|-----------|-----------|
| P  | Ferro magnetico dolce, acciaio dolce                      | ≤180 HB   | F                    | ●         | —         | 100 – 300 | —         | —         |
|  |   |   |                      | ✱         | —         | —         | 155 – 190 | —         |
|  | Acciaio al carbonio, acciaio legato                       | 180–280 HB  | F                    | ●         | —         | 40 – 130  | —         | —         |
|  |   |   |                      | ✱         | —         | —         | 115 – 140 | —         |
|  | Acciaio al carbonio, acciaio legato                       | 280–350 HB  | F                    | ✱         | —         | —         | 80 – 100  | —         |
| M  | Acciaio inossidabile austenitico                          | ≤200 HB   | F                    | ●         | —         | 40 – 100  | 60 – 150  | —         |
|  |   |   |                      | ✱         | —         | —         | 50 – 90   | —         |
|  | Acciaio inossidabile ferritico e martensitico             | ≤200 HB   | F                    | ●         | —         | 40 – 100  | —         | —         |
|  |   |   |                      | ✱         | —         | —         | 50 – 90   | —         |
|  | Acciai inossidabili austenitici, ferritici e martensitici | >200 HB   | F                    | ✱         | —         | —         | —         | 40 – 75   |
|  | Acciaio inossidabile elettromagnetico                     | 230 HBW   | F                    | ●         | —         | 40 – 160  | 50 – 180  | —         |
|  | Acciaio duplex inossidabile                               | ≤280 HB   | F                    | ✱         | —         | —         | —         | 35 – 60   |
| Acciaio inossidabile temprato per precipitazione | <450 HB   | F   | ✱                    | 70 – 85   | 40 – 80   | 50 – 100  | —         |           |
| K  | Ghisa grigia  | ≤350 MPa  | M                    | ●✱        | —         | —         | —         | 90 – 125  |
|  | Ghisa sferoidale  | ≤450 MPa  | M                    | ●●✱       | —         | —         | —         | 70 – 100  |
|  | Ghisa sferoidale  | ≤800 MPa  | M                    | ●●✱       | —         | —         | —         | 60 – 90   |
| N  | Leghe di alluminio  | —   | M                    | ●●✱       | —         | —         | —         | 300 – 700 |
| S  | Leghe resistenti al calore                                | —   | F                    | ●         | —         | —         | 40 – 140  | —         |
|  |   |   |                      | ✱         | 25 – 40   | —         | —         | —         |

1/1

### Rompitrucolo

### f (mm/giro)

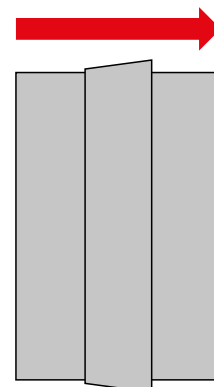
### ap (mm)

|             |            |            |
|-------------|------------|------------|
| FSF, FSP-P  | 0.02 – 0.1 | 0.02 – 1.0 |
| FS-P        | 0.04 – 0.2 | 0.2 – 0.9  |
| Standard    | 0.08 – 0.3 | 0.3 – 2.0  |
| Petto piano | 0.08 – 0.3 | 0.3 – 2.0  |

## ESEMPI DI APPLICAZIONE

### TORNITURA ESTERNA

|                       |  |
|-----------------------|--|
| Materiale da lavorare | DIN 1.4301 (X5CrNi18-10)   |
| Inserto               | DCGT11T301M-FSF-P  |
| Grado                 | MS9025   |
| Vc (m/min)            | 120  |
| f (mm / giro)         | 0.02   |
| ap (mm)               | 0.1  |
| Modalità di taglio    | Taglio a umido (lotio)   |
| Risultato             | La scheggiatura del tagliente è stata eliminata e l'espulsione del truciolo è risultata efficace.<br>Ora è possibile lavorare 750 pezzi rispetto ai 150 pezzi della durata utensile convenzionale. |



Condizioni di taglio: ● : Taglio stabile ● : Taglio generico ✱ : Taglio instabile  
Area di taglio : F : Lavorazione di finitura M : Taglio medio

## FILIALI EUROPEE

### GERMANY

MMC HARTMETALL GMBH  
Comeniusstr. 2 . 40670 Meerbusch  
Phone +49 2159 91890 . Fax +49 2159 918966  
Email admin@mmchg.de

### UK Office

MMC HARDMETAL UK LTD  
1 Centurion Court, Centurion Way  
Tamworth, B77 5PN  
Phone +44 1827 312312  
Email enquiries@mitsubishicarbide.co.uk

### UK Deliveries / Returns

Unit 4 B5K Business Park, Quartz Close  
Tamworth, B77 4GR

### SPAIN

MITSUBISHI MATERIALS ESPAÑA, S.A.  
Calle Emperador 2 . 46136 Museros / Valencia  
Phone +34 96 1441711  
Email comercial@mmevalencia.es

### FRANCE

MMC METAL FRANCE S.A.R.L.  
6, Rue Jacques Monod . 91400 Orsay  
Phone +33 1 69 35 53 53 . Fax +33 1 69 35 53 50  
Email mmfsales@mmc-metal-france.fr

### POLAND

MMC HARDMETAL POLAND SP. Z O.O  
Al. Armii Krajowej 61 . 50-541 Wrocław  
Phone +48 71335 1620 . Fax +48 71335 1621  
Email sales@mitsubishicarbide.com.pl

### ITALY

MMC ITALIA S.R.L.  
Viale Certosa 144 . 20156 Milano  
Phone +39 0293 77031 . Fax +39 0293 589093  
Email info@mmc-italia.it

### TURKEY

MMC HARTMETALL GMBH ALMANYA - İZMİR MERKEZ ŞUBESİ  
Adalet Mahallesi Anadolu Caddesi No: 41-1 . 15001 35530 Bayraklı / İzmir  
Phone +90 232 5015000 . Fax +90 232 5015007  
Email info@mmchg.com.tr

[www.mmc-carbide.com](http://www.mmc-carbide.com)

DISTRIBUITO DA:

┌

┐

└

┘

B210I-I 

Publicata da: MMC Hartmetall GmbH – A Sales Company of  MITSUBISHI MATERIALS | 2025.04