BRAZED TOOLS EINES SOLDADES

Uncoated inserts / Plaquetes no recobertes

KM15

Finishing grade in the K10 range. This carbide grade is for use on cast iron, aluminium and heat-resistant alloys. This grade works well on cobalt based alloys and synthetic materials and is suitable for finishing on heat-resistant alloys.

Qualitat per acabats de grau K10. S'utilitza en ferro fos, alumini i aliatges termorresistents. Aquesta qualitat funciona bé en aliatges amb base de cobalt i en materials sintètics, i també es pot utilitzar per acabats en aliatges termorresistents.

PM25

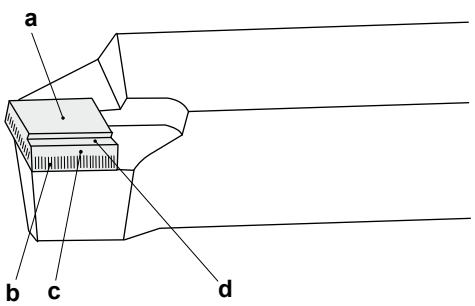
General purpose uncoated grade in the P30 range. This tough, economical grade is suitable for the machining of carbon steels, alloyed steels, tool steels and stainless steels.
PM25 provides toughness and resistance to deformation in roughing and semi-finishing operations.

Qualitat no recoberta de grau P30 per a usos generals. Aquesta qualitat econòmica i tenaç s'utilitza per el mecanitzat d'acers al carboni, acers aliats, acers refractaris i acers inoxidables. Ofereix tenacitat i resistència a la deformació en operacions de desbast i semiacabat.

Grinding / Esmolat

In order to obtain a satisfactory result, it is necessary to have a steady grinding table or holder that can be set to the required angle by means of a graduated scale and by non-vibrating small spindles.
Rough grinding is normally carried out using a silicon carbide grinding wheel. The finish grind or lapping must always be made using a diamond wheel.
Longer life of the cutting edge and less breakage justify the increased cost of correct grinding.
The grinding wheel must be kept clean to ensure that cutting capacity is maintained.
Whenever possible, always grind perpendicular to the cutting edge.

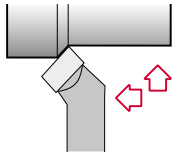
Per obtenir un resultat satisfactori, és necessari tenir una taula d'esmolat ferma o un suport amb petits eixos no vibrants que es pugui regular a l'angle necessari mitjançant una escala graduada.
L'esmolat de desbast es realitza normalment utilitzant una mola de carbur de silici. L'esmolat d'acabat o lapidatge s'ha de fer sempre utilitzant una mola de diamant.
Una duració més llarga de l'aresta de tall i menys trencaments justifiquen l'increment de cost d'un rectificat correcte.
La mola s'ha de mantenir neta per assegurar que es manté la capacitat de tall.
Sempre que sigui possible, esmoleu perpendicularment a l'aresta de tall.



a.- Top face / Cara superior
b.- Secondary clearances / Incidència secundària
c.- Lapped primary clearances / Incidència principal del lapidatge
d.- Chipbreaker groove / Ranura del trencaferritges

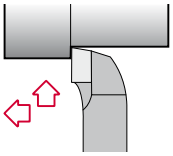
Toolholders
Portaeines

ISO 2 45º



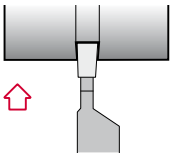
Page
Pàgina A272

ISO 6 90º



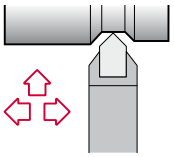
Page
Pàgina A272

ISO 7 90º



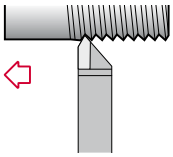
Page
Pàgina A273

ISO 351 80º



Page
Pàgina A273

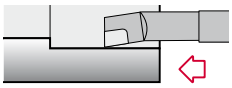
UI 30 60º



Page
Pàgina A274

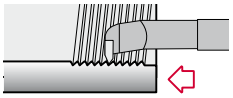
Boring bars
Barres de mandrinar

ISO 9 90º



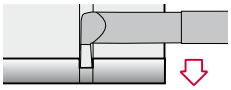
Page
Pàgina A275

UI 40 60º



Page
Pàgina A275

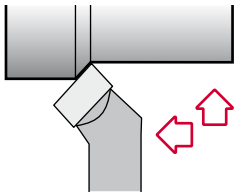
UI 50 90º

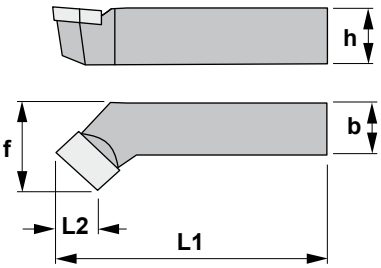


Page
Pàgina A276

Characteristics:
Brazed toolholder.
DIN 4972

Característiques:
Eina soldada exterior.



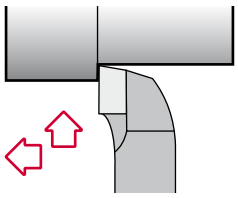


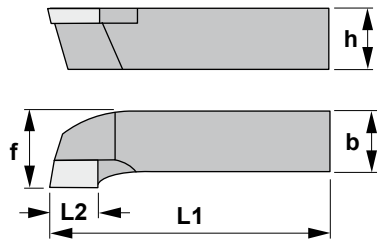
ISO 2 45°

Reference Referència	h	b	L1	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
ISO2 1010 R	10	10	90	8	14	C8	0,070	○	○
ISO2 1010 L	10	10	90	8	14	C8	0,070	○	○
ISO2 1212 R	12	12	100	10	17	ABC10	0,100	○	●
ISO2 1212 L	12	12	100	10	17	ABC10	0,100	○	●
ISO2 1616 R	16	16	110	12	22	ABC12	0,200	●	●
ISO2 1616 L	16	16	110	12	22	ABC12	0,200	●	●
ISO2 2020 R	20	20	125	16	28	ABC16	0,400	●	●
ISO2 2020 L	20	20	125	16	28	ABC16	0,400	●	●
ISO2 2525 R	25	25	140	20	35	ABC20	0,650	●	●
ISO2 2525 L	25	25	140	20	35	ABC20	0,650	●	●

Characteristics:
Brazed toolholder.
DIN 4980

Característiques:
Eina soldada exterior.

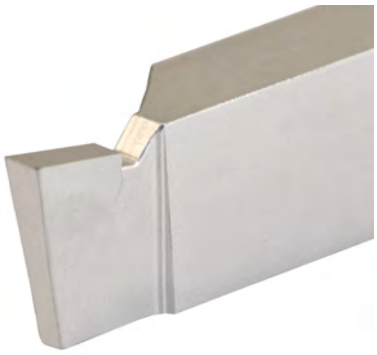




AVAILABILITY / DISPONIBILITAT
● Standard item / Article estàndard
○ Check availability / Consulti disponibilitat

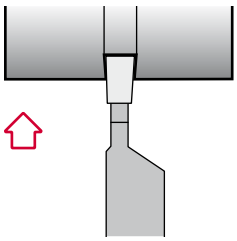
ISO 6 90°

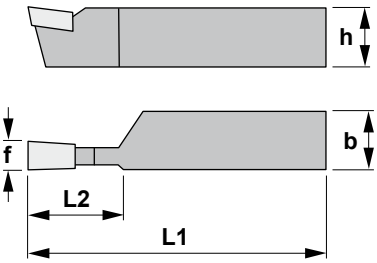
Reference Referència	h	b	L1	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
ISO6 1010 R	10	10	90	8	14	C8	0,070	○	○
ISO6 1010 L	10	10	90	8	14	C8	0,070	○	○
ISO6 1212 R	12	12	100	10	17	ABC10	0,100	○	●
ISO6 1212 L	12	12	100	10	17	ABC10	0,100	○	●
ISO6 1616 R	16	16	110	12	22	ABC12	0,200	●	●
ISO6 1616 L	16	16	110	12	22	ABC12	0,200	●	●
ISO6 2020 R	20	20	125	16	28	ABC16	0,400	●	●
ISO6 2020 L	20	20	125	16	28	ABC16	0,400	●	●
ISO6 2525 R	25	25	140	20	35	ABC20	0,650	●	●
ISO6 2525 L	25	25	140	20	35	ABC20	0,650	●	●



Characteristics:
Brazed toolholder.
DIN 4981

Característiques:
Eina soldada exterior.



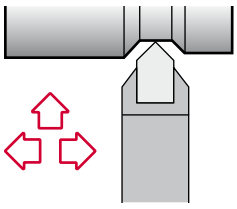


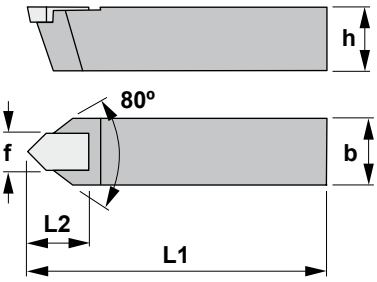
ISO 7 90°

Reference Referència	h	b	L1	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
ISO7 1208 R	12	08	100	12	3	D3	0,070	○	●
ISO7 1208 L	12	08	100	12	3	D3	0,070	○	●
ISO7 1610 R	16	10	110	14	4	D4	0,150	●	●
ISO7 1610 L	16	10	110	14	4	D4	0,150	●	●
ISO7 2012 R	20	12	125	16	5	D5	0,200	●	●
ISO7 2012 L	20	12	125	16	5	D5	0,200	●	●
ISO7 2516 R	25	16	140	20	6	D6	0,400	●	●
ISO7 2516 L	25	16	140	20	6	D6	0,400	●	●
ISO7 3220 R	32	20	170	25	8	D8	0,750	●	●
ISO7 3220 L	32	20	170	25	8	D8	0,750	●	●

Characteristics:
Brazed toolholder.
DIN 4975

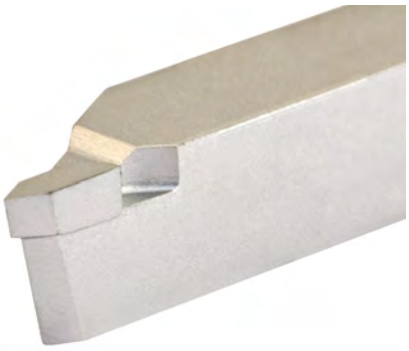
Característiques:
Eina soldada exterior.





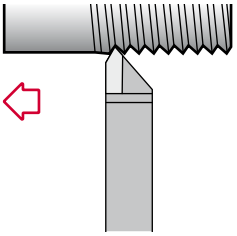
ISO 351 80º

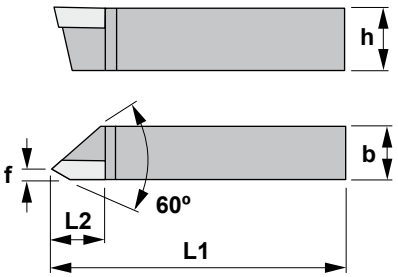
Reference Referència	h	b	L1	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
ISO351 1212 N	12	12	100	10	5	E5	0,100	○	○
ISO351 1616 N	16	16	110	12	6	E6	0,200	○	○
ISO351 2020 N	20	20	125	16	8	E8	0,400	○	○
ISO351 2525 N	25	25	140	18	10	E10	0,650	○	○



Characteristics:
Brazed toolholder.
ISO 352

Característiques:
Eina soldada exterior.



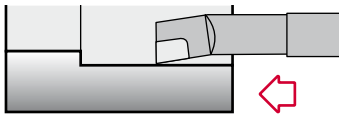


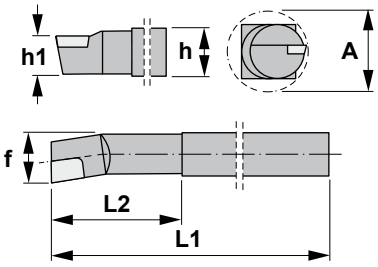
UI 30 60º

Reference Referència	h	b	L1	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
UI 30 60° 1212 R	12	12	100	12	1,8	E5	0,100	●	●
UI 30 60° 1616 R	16	16	110	14	2,0	E6	0,200	●	●
UI 30 60° 2020 R	20	20	125	16	2,5	E8	0,350	●	●
UI 30 60° 2525 R	25	25	140	18	3,0	E10	0,600	●	●

Characteristics:
Brazed boring bar.
UNI 4111

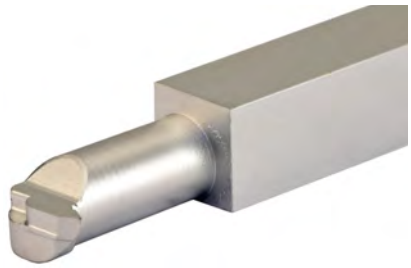
Característiques:
Eina soldada interior.





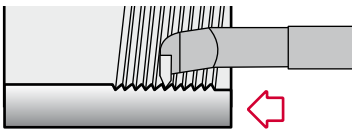
ISO 9 90°

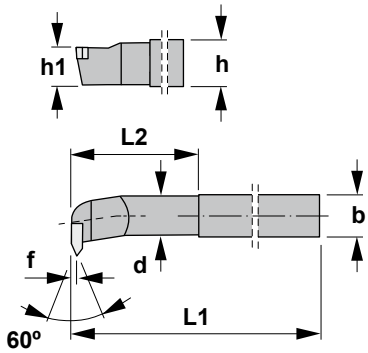
Reference Referència	h=b	h1	L	b2	L2	f	A	Insert size Mida plaqueta	Kg	KM15	PM25
ISO9 0808 R	8	6,4	125	3,1	40	11	14	C7	0,060	●	●
ISO9 1010 R	10	8,0	150	4,0	50	14	18	C7	0,100	●	●
ISO9 1212 R	12	9,6	180	5,1	63	17	21	C8	0,250	●	●
ISO9 1616 R	16	12,8	210	6,2	80	22	27	ABC 10	0,400	●	●
ISO9 2020 R	20	16,0	250	8,3	100	28	34	ABC 12	0,700	●	●
ISO9 2525 R	25	20,0	300	10,0	125	35	43	ABC 16	1,300	●	●
ISO9 3232 R	32	25,6	355	12,0	160	44	52	ABC 20	2,500	●	●



Characteristics:
Brazed boring bar.
ISO 353

Característiques:
Eina soldada interior.





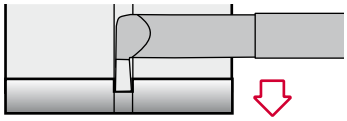
AVAILABILITY / DISPONIBILITAT
● Standard item / Article estàndard
○ Check availability / Consulti disponibilitat

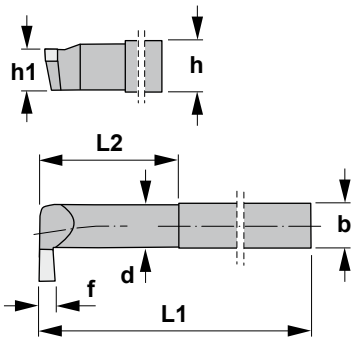
UI 40 60º

Reference Referència	d	h=b	L	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
UI 40 60° 1010 R	10	10	100	26	1,8	E4	0,070	●	●
UI 40 60° 1212 R	12	12	110	26	1,8	E4	0,200	●	●
UI 40 60° 1616 R	16	16	140	33	2,0	E5	0,250	●	●
UI 40 60° 2020 R	20	20	160	41	2,0	E6	0,450	●	●
UI 40 60° 2525 R	25	25	180	49	2,5	E8	0,750	●	●

Characteristics:
Brazed boring bar.
ISO 354

Característiques:
Eina soldada interior.





UI 50 90°

Reference Referència	d	h=b	L	L2	f	Insert size Mida plaqueta	Kg	KM15	PM25
UI 50 90° 1010 R	10	10	140	52	3	D3	0,100	●	●
UI 50 90° 1212 R	12	12	160	56	4	D4	0,200	●	●
UI 50 90° 1616 R	16	16	180	63	5	D5	0,350	●	●
UI 50 90° 2020 R	20	20	210	80	6	D6	0,700	●	●
UI 50 90° 2525 R	25	25	250	100	8	D8	1,250	●	●