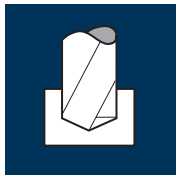
Applicazione



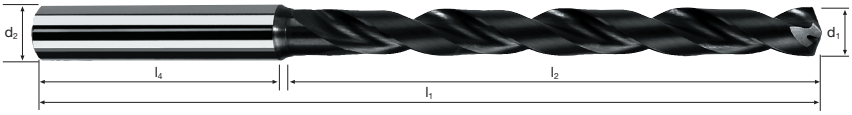
Materiale	d1 [mm]	v_c [m/min]	f [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]	T [sek]
Acciaio < 500 N/mm²	4.00	130	0.085	10345	880	11.0	2.4
	5.00	130	0.105	8275	870	17.0	3.3
	6.00	130	0.125	6895	860	24.5	3.3
	7.00	130	0.145	5910	855	33.0	4.5
	8.00	130	0.170	5175	880	44.0	4.3
	9.00	130	0.190	4600	875	55.5	5.5
	10.00	130	0.210	4140	870	68.5	5.5
	11.00	130	0.230	3760	865	82.0	6.7
	12.00	130	0.255	3450	880	99.5	6.6
Acciaio 500 - 850 N/mm²	4.00	100	0.085	7960	675	8.5	3.1
	5.00	100	0.105	6365	670	13.0	4.3
	6.00	100	0.125	5305	665	19.0	4.3
	7.00	100	0.145	4545	660	25.5	5.8
	8.00	100	0.170	3980	675	34.0	5.6
	9.00	100	0.190	3535	670	42.5	7.2
	10.00	100	0.210	3185	670	52.5	7.2
	11.00	100	0.230	2895	665	63.0	8.7
	12.00	100	0.255	2655	675	76.5	8.6
Acciaio 850 - 1100 N/mm²	4.00	70	0.065	5570	360	4.5	5.8
	5.00	70	0.080	4455	355	7.0	8.1
	6.00	70	0.095	3715	355	10.0	8.0
	7.00	70	0.110	3185	350	13.5	10.9
	8.00	70	0.130	2785	360	18.0	10.5
	9.00	70	0.145	2475	360	23.0	13.5
	10.00	70	0.160	2230	355	28.0	13.6
	11.00	70	0.175	2025	355	33.5	16.3
	12.00	70	0.190	1855	350	39.5	16.5
Acciaio 1100 - 1300 N/mm²	4.00	50	0.055	3980	220	3.0	9.5
	5.00	50	0.065	3185	205	4.0	14.0
	6.00	50	0.080	2655	210	6.0	13.5
	7.00	50	0.095	2275	215	8.5	17.8
	8.00	50	0.105	1990	210	10.5	18.1
	9.00	50	0.120	1770	210	13.5	23.1
	10.00	50	0.135	1590	215	17.0	22.4
	11.00	50	0.145	1445	210	20.0	27.6
	12.00	50	0.160	1325	210	24.0	27.5

Materiale	d1 [mm]	v_c [m/min]	f [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]	T [sek]
Acciaio per lavorazione a freddo (12% Cr) fortemente legati [1.2379] Acciaio inossidabile [Cr-Ni/1.4301]	4.00	50	0.045	3980	180	2.5	11.6
	5.00	50	0.055	3185	175	3.5	16.4
	6.00	50	0.070	2655	185	5.0	15.4
	7.00	50	0.080	2275	180	7.0	21.2
	8.00	50	0.090	1990	180	9.0	21.1
	9.00	50	0.105	1770	185	12.0	26.2
	10.00	50	0.115	1590	185	14.5	26.0
	11.00	50	0.125	1445	180	17.0	32.2
	12.00	50	0.135	1325	180	20.5	32.1
Ghisa (grigia / sferoidale)	4.00	150	0.090	11935	1075	13.5	1.9
	5.00	150	0.115	9550	1100	21.5	2.6
	6.00	150	0.135	7960	1075	30.5	2.6
	7.00	150	0.160	6820	1090	42.0	3.5
	8.00	150	0.185	5970	1105	55.5	3.4
	9.00	150	0.205	5305	1090	69.5	4.4
	10.00	150	0.230	4775	1100	86.5	4.4
	11.00	150	0.250	4340	1085	103.0	5.3
	12.00	150	0.275	3980	1095	124.0	5.3
Alluminio malleabile Si < 6%	4.00	200	0.080	15915	1275	16.0	1.6
	5.00	200	0.100	12730	1275	25.0	2.2
	6.00	200	0.120	10610	1275	36.0	2.2
	7.00	200	0.140	9095	1275	49.0	3.0
	8.00	200	0.160	7960	1275	64.0	3.0
	9.00	200	0.180	7075	1275	81.0	3.8
	10.00	200	0.200	6365	1275	100.0	3.8
	11.00	200	0.220	5785	1275	121.0	4.5
	12.00	200	0.240	5305	1275	144.0	4.5

Punte elicoidali Supradrill® N

8xd

HM MG10

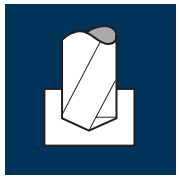


Rm < 850 | **Rm** 850-1100 | **Rm** 1100-1300 | **Inox** Stainless | **GG(G) Aluminium**

Esempio: **N° Ordine** — Articolo **B52020** — Codice-ø **.0400**

ø Code	d_1 m7	d_2 h6	l_1	l_2	l_4	L_{max}	DURO-SD B52020	B53020
.0400	4.0	6	82	44	36	34.9		●
.0420	4.2	6	82	44	36	34.8		●
.0450	4.5	6	82	44	36	34.6		●
.0480	4.8	6	82	44	36	34.4		●
.0500	5.0	6	95	57	36	47.7		●
.0550	5.5	6	95	57	36	47.5		●
.0580	5.8	6	95	57	36	47.3		●
.0600	6.0	6	95	57	36	47.4		●
.0650	6.5	8	115	76	36	65.0		●
.0680	6.8	8	115	76	36	64.8		●
.0700	7.0	8	115	76	36	64.7		●
.0750	7.5	8	115	76	36	64.4		●
.0780	7.8	8	115	76	36	64.3		●
.0800	8.0	8	115	76	36	64.3		●
.0850	8.5	10	138	95	40	81.0		●
.0900	9.0	10	138	95	40	80.7		●
.0950	9.5	10	138	95	40	80.4		●
.1000	10.0	10	138	95	40	80.2		●
.1050	10.5	12	162	114	45	97.0		●
.1100	11.0	12	162	114	45	96.6		●
.1150	11.5	12	162	114	45	96.4		●
.1200	12.0	12	162	114	45	96.2		●

Applicazione



Materiale	d1 [mm]	v_c [m/min]	f [mm]	n [min^{-1}]	v_f [mm/min]	Q [cm^3/min]	T [sek]
Acciaio < 500 N/mm²	12.50	130	0.265	3310	875	107.5	7.7
	13.00	130	0.275	3185	875	116.0	7.7
	13.50	130	0.285	3065	875	125.0	7.7
	14.00	130	0.295	2955	870	134.0	7.7
	14.50	130	0.305	2855	870	143.5	8.9
	15.00	130	0.315	2760	870	153.5	8.9
	16.00	130	0.335	2585	865	174.0	8.9
Acciaio 500 - 850 N/mm²	12.50	100	0.265	2545	675	83.0	10.0
	13.00	100	0.275	2450	675	89.5	10.0
	13.50	100	0.285	2360	675	96.5	10.0
	14.00	100	0.295	2275	670	103.0	10.0
	14.50	100	0.305	2195	670	110.5	11.5
	15.00	100	0.315	2120	670	118.5	11.5
	16.00	100	0.335	1990	665	133.5	11.5
Acciaio 850 - 1100 N/mm²	12.50	70	0.200	1785	355	43.5	19.1
	13.00	70	0.210	1715	360	48.0	18.8
	13.50	70	0.215	1650	355	51.0	19.0
	14.00	70	0.225	1590	360	55.5	18.7
	14.50	70	0.230	1535	355	58.5	21.8
	15.00	70	0.240	1485	355	62.5	21.7
	16.00	70	0.255	1395	355	71.5	21.6
Acciaio 1100 - 1300 N/mm²	12.50	50	0.165	1275	210	26.0	32.3
	13.00	50	0.175	1225	215	28.5	31.4
	13.50	50	0.180	1180	210	30.0	32.1
	14.00	50	0.185	1135	210	32.5	32.0
	14.50	50	0.195	1100	215	35.5	36.0
	15.00	50	0.200	1060	210	37.0	36.7
	16.00	50	0.215	995	215	43.0	35.7

Materiale	d1 [mm]	v_c [m/min]	f [mm]	n [min^{-1}]	v_f [mm/min]	Q [cm^3/min]	T [sek]
Acciaio per lavorazione a freddo (12% Cr) fortemente legati [1.2379] Acciaio inossidabile [Cr-Ni/1.4301]	12.50	50	0.145	1275	185	22.5	36.6
	13.00	50	0.150	1225	185	24.5	36.5
	13.50	50	0.155	1180	185	26.5	36.4
	14.00	50	0.160	1135	180	27.5	37.4
	14.50	50	0.165	1100	180	29.5	43.0
	15.00	50	0.170	1060	180	32.0	42.9
	16.00	50	0.185	995	185	37.0	41.5
Ghisa (grigia / sferoidale)	12.50	150	0.285	3820	1090	134.0	6.2
	13.00	150	0.295	3675	1085	144.0	6.2
	13.50	150	0.310	3535	1095	156.5	6.2
	14.00	150	0.320	3410	1090	168.0	6.2
	14.50	150	0.330	3295	1085	179.0	7.1
	15.00	150	0.345	3185	1100	194.5	7.0
	16.00	150	0.365	2985	1090	219.0	7.0
Alluminio malleabile Si < 6%	12.50	200	0.250	5095	1275	156.5	5.3
	13.00	200	0.260	4895	1275	169.0	5.3
	13.50	200	0.270	4715	1275	182.5	5.3
	14.00	200	0.280	4545	1275	196.5	5.3
	14.50	200	0.290	4390	1275	210.5	6.1
	15.00	200	0.300	4245	1275	225.5	6.1
	16.00	200	0.320	3980	1275	256.5	6.0

Punte elicoidali Supradrill® N

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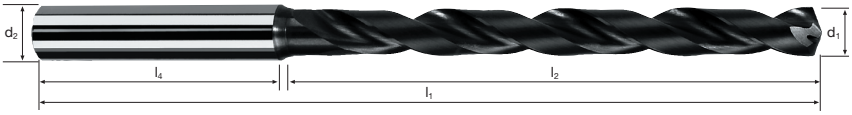
HM MG10



Rm < 850	**Rm** 850-1100	**Rm** 1100-1300					**Inox** Stainless		**GG(G) Aluminium**

Esempio: **N° Ordine** — Articolo **B52020** — Codice-ø **.1250**

ø Code	d_1 m7	d_2 h6	l_1	l_2	l_4	L_{max}		DURO-SD **B52020**	DURO-SD **B53020**
.1250	12.5	14	181	133	45	113.0		●	
.1300	13.0	14	181	133	45	112.6		●	
.1350	13.5	14	181	133	45	112.3		●	
.1400	14.0	14	181	133	45	112.1		●	
.1450	14.5	16	203	152	48	128.9		●	
.1500	15.0	16	203	152	48	128.6		●	
.1600	16.0	16	203	152	48	128.0		●	