



STN10 / TNGX10

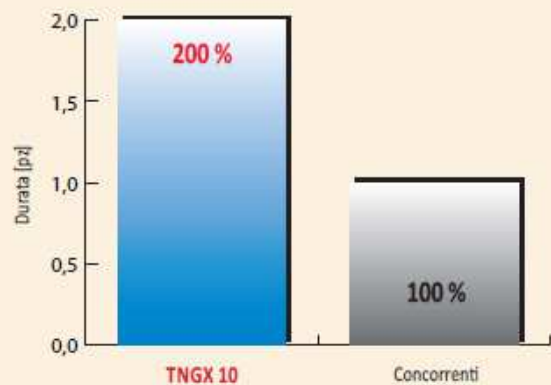
FRESE AD INSERTI



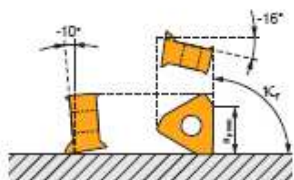
TNGX 10 - ESEMPIO DI LAVORAZIONE

Materiale: SUS304/316
 Gruppo materiali: M3
 Pezzo: componente pompa
 Inserto: TNGX 100404SR-F: M9340
 Refrigerante: sì

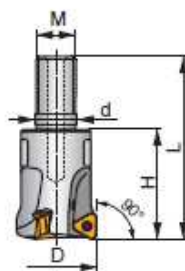
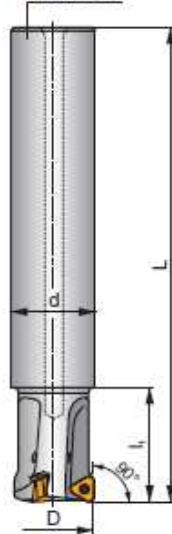
		PRAMET	Concorrenti
Operazione		Spianatura	
Utensile		63A09R -S90TN10-C	D = 63 mm; 4 denti
Velocità di taglio	v_c m/min	120	120
Avanzamento dente	f_z mm/dente	0,12	0,26
Avanzamento	f mm/min	655	631
Profondità di taglio assiale	a_p mm	1	1
Profondità di taglio radiale	a_r mm	50	50
Durata	T pz	2	1
Usura sul fianco	VB mm	0,2	0,2
Rugosità superficiale	R_a μ m	0,8	0,8



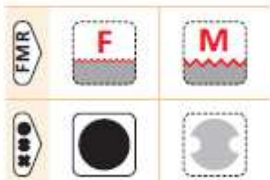
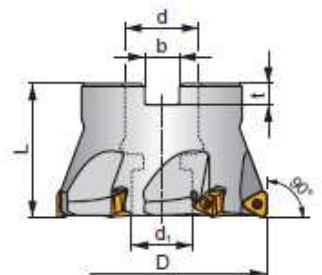
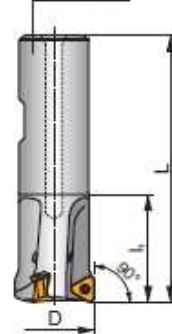
κ_r	90°
a_{pmax}	5 mm



DIN 1835A



DIN 1835B



	0,03 - 0,08
	0,03 - 0,06



ISO	D	L	d	d ₁	l ₁	H	M	b	t											
	18A2R050A20-STN10-C	18	180	20	-	50	-	-	-	2	-	29100	✓	0,4	GI292	SQ300				
	20A2R029A20-STN10-C	20	150	20	-	29	-	-	-	2	-	27600	✓	0,3	GI292	SQ300				
	20A3R029A20-STN10-C	20	150	20	-	29	-	-	-	3	-	27600	✓	0,3	GI292	SQ300				
	22A3R050A25-STN10-C	22	180	25	-	50	-	-	-	3	-	26300	✓	0,6	GI292	SQ300				
	25A3R034A25-STN10-C	25	170	25	-	34	-	-	-	3	-	24700	✓	0,6	GI292	SQ300				
	25A4R034A25-STN10-C	25	170	25	-	34	-	-	-	4	✓	24700	✓	0,6	GI292	SQ300				
	30A4R050A32-STN10-C	30	200	32	-	50	-	-	-	4	✓	22500	✓	1,0	GI292	SQ300				
	32A4R037A32-STN10-C	32	195	32	-	37	-	-	-	4	✓	21800	✓	1,1	GI292	SQ300				
	32A5R037A32-STN10-C	32	195	32	-	37	-	-	-	5	✓	21800	✓	1,1	GI292	SQ300				
	35A5R080A32-STN10-C	35	200	32	-	80	-	-	-	5	✓	20800	✓	1,1	GI292	SQ300				
	20A2R032B20-STN10-C	20	90	16	-	32	-	-	-	2	-	27600	✓	0,2	GI292	SQ300				
	20A3R032B20-STN10-C	20	90	20	-	32	-	-	-	3	-	27600	✓	0,2	GI292	SQ300				
	25A3R042B25-STN10-C	25	100	20	-	42	-	-	-	3	-	24700	✓	0,3	GI292	SQ300				
	25A4R042B25-STN10-C	25	100	25	-	42	-	-	-	4	✓	24700	✓	0,3	GI292	SQ300				
	32A4R042B32-STN10-C	32	110	25	-	42	-	-	-	4	✓	21800	✓	0,6	GI292	SQ300				
	32A5R042B32-STN10-C	32	110	32	-	42	-	-	-	5	✓	21800	✓	0,6	GI292	SQ300				
	20A2R026M10-STN10-C	20	45	10,5	-	26	M10	-	-	2	-	27600	✓	0,1	GI292	SQ300				
	20A3R026M10-STN10-C	20	45	10,5	-	26	M10	-	-	3	-	27600	✓	0,1	GI292	SQ300				
	25A3R033M12-STN10-C	25	55	12,5	-	33	M12	-	-	3	-	24700	✓	0,1	GI292	SQ300				
	25A4R033M12-STN10-C	25	55	12,5	-	33	M12	-	-	4	✓	24700	✓	0,1	GI292	SQ300				
	32A4R043M16-STN10-C	32	66	17	-	43	M16	-	-	4	✓	21800	✓	0,2	GI292	SQ300				
	32A5R043M16-STN10-C	32	66	17	-	43	M16	-	-	5	✓	21800	✓	0,2	GI292	SQ300				

ISO	D	L	d	d ₁	l ₁	H	M	b	t											
	40A04R-S90TN10-C	40	40	16	14	-	-	8,4	5,6	4	✓	19500	✓	0,2	GI292	SQ302				
	40A06R-S90TN10-C	40	40	16	14	-	-	8,4	5,6	6	✓	19500	✓	0,2	GI292	SQ302				
	50A05R-S90TN10-C	50	40	22	18	-	-	10,4	6,3	5	✓	17400	✓	0,3	GI292	SQ303				
	50A07R-S90TN10-C	50	40	22	18	-	-	10,4	6,3	7	✓	17400	✓	0,3	GI292	SQ303				
	63A06R-S90TN10-C	63	40	22	18	-	-	10,4	6,3	6	✓	15500	✓	0,5	GI292	SQ303				
	63A09R-S90TN10-C	63	40	22	18	-	-	10,4	6,3	9	✓	15500	✓	0,5	GI292	SQ303				
	80A10R-S90TN10-C	80	50	27	38	-	-	12,4	7	10	✓	13800	✓	1,0	GI292	SQ301				AC001



G1292



TNGX 1004..



SQ300



US 52506-T07P



D-T07P/T09P



FG-15



Flag T07P



HS 0830C

SQ302

US 52506-T07P

D-T07P/T09P

FG-15

HS 0830C

SQ303

US 52506-T07P

D-T07P/T09P

FG-15

HS 1030C

SQ301

US 52506-T07P

D-T07P/T09P

FG-15



AC001



KS 1230

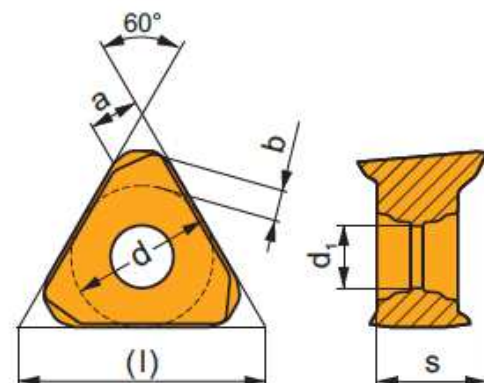


K.FMH27

TNGX 10



1004

d
6,000d₁
2,8l
10,390s
4,69

Raggi 0,2 - 0,4 - 0,8