2017.04

MVX

WIERT O Z P YTKAMI WIELOOSTRZOWYMI

NOWOCZESNA TECHNOLOGIA ZAPEWNIAJ CA DOSKONA SZTYWNO KORPUSU

MITSUBISHI
MITSUBISHI MATERIALS

AMACZ WIÓRA

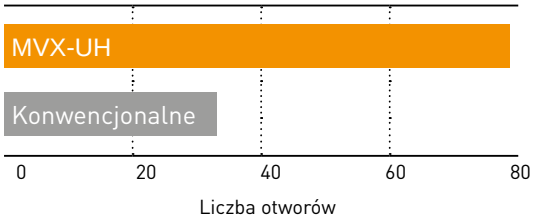
NEW AMACZ UH DO STALI HARTOWANYCH

Wzmocniona krawędź skrawająca płytki do wiercenia stali hartowanych do 45 HRC.

WYDAJNOŚĆ SKRAWANIA

Średnica	MVX1700X3F20
Płytka	Zewnętrzna MC1020-UM Wewnętrzna DP8020-UH
Materiał obrabiany	DIN X40CrMoV51(45HRC)
Prędkość skrawania Vc (m/min)	50
Posuw f (mm/obr.)	0.8
Głębokość otworu ap (mm)	30 (otwór przelotowy)

Porównanie liczby wykonanych otworów



NEW AMACZ UN DO STOPÓW ALUMINIUM

Łamacz wióra UN z ostrą, szlifowaną krawędzią zapewniający znakomitą skuteczność usuwania wiórów. Dzięki gładkim powierzchniom natarcia zapobiega także zgrzewaniu aluminium.

WYDAJNOŚĆ SKRAWANIA

Średnica	MVX1700X5F20
Płytka	Zewnętrzna TF15-UN Wewnętrzna TF15-UN
Materiał obrabiany	JIS ADC12
Prędkość skrawania Vc (m/min)	400
Posuw f (mm/obr.)	0.05
Głębokość otworu ap (mm)	40 (otwór nieprzelotowy)

Porównanie jakości wykończenia powierzchni

AMACZ US DO STALI NIERDZEWNYCH

Mocna krawędź skrawająca

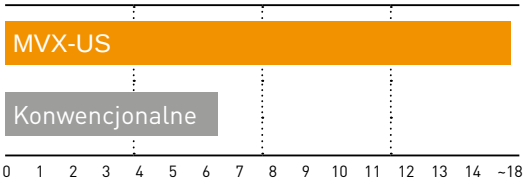
Ostra krawędź skrawająca

Zaprojektowane z myślą o ostrzu wewnętrznym.
Doskonała wytrzymałość na pęknięcia i powstawanie narostu.

WYDAJNOŚĆ SKRAWANIA

Średnica	MVX3000X3F32
Płytka	Zewnętrzna MC1020-UM Wewnętrzna VP15TF-US
Materiał obrabiany	DIN X5CrNi18-10
Prędkość skrawania Vc (m/min)	120
Posuw f (mm/obr.)	0.12
Głębokość otworu ap (mm)	50 mm (otwór przelotowy)

Porównanie długości skrawania



[redacted]

P	MC1020	VP15TF	VP15TF	VP15TF
	UM	UM	UM	UM
M	MC1020	VP15TF	VP15TF	VP15TF
	UM	US	UM	US
K	MC5020	VP15TF	VP15TF	VP15TF
	UM	UM	UM	UM
H	MC1020	DP8020	VP15TF	DP8020
	UM	UH	UM	UH
N	TF15	TF15		
	UN	UN		

MC1020

DP8020

MC5020

VP15TF

TF15

MVX

P M K N H

	DC	L x DC		LBX	LPR	OAL	DCON	DCSFMS	A	
MVX1700X2F20		2	●	41	56	99	20	25	0.5	SO◌X06
MVX1700X3F20		3	●	58	73	116	20	25	0.5	SO◌X06
MVX1700X4F20	17.0	4	●	75	90	133	20	25	0.5	SO◌X06
MVX1700X5F20		5	●	92	107	150	20	25	0.5	SO◌X06
MVX1700X6F20		6	●	109	124	167	20	25	0.5	SO◌X06
MVX1750X2F25		2	●	42	62	112	25	32	0.45	SO◌X06
MVX1750X3F25		3	●	59.5	79.5	129.5	25	32	0.45	SO◌X06
MVX1750X4F25	17.5	4	●	77	97	147	25	32	0.45	SO◌X06
MVX1750X5F25		5	●	94.5	114.5	164.5	25	32	0.45	SO◌X06
MVX1750X6F25		6	●	112	132	182	25	32	0.45	SO◌X06
MVX1800X2F25		2	●	43	63	113	25	32	0.4	SO◌X06
MVX1800X3F25		3	●	61	81	131	25	32	0.4	SO◌X06
MVX1800X4F25	18.0	4	●	79	99	149	25	32	0.4	SO◌X06
MVX1800X5F25		5	●	97	117	167	25	32	0.4	SO◌X06
MVX1800X6F25										

	DC	L x DC	LBX	LPR	OAL	DCON	DCSFMS	A
MVX2000X2F25		2						
	20.0							

P M K N H

	DC	L x DC	LBX	LPR	OAL	DCON	DCSFMS	A
MVX2600X2F32		2						
	26.0							

Numer zamówieniowy	DC	L x DC	Dostępność	LBX	LPR	OAL	DCON	DCSFMS	A	Typ p ytki
MVX3100X2F40		2	●	69	89	154	40	50	0.55	SO◌X09
MVX3100X3F40		3	●	100	120	185	40	50	0.55	SO◌X09
MVX3100X4F40	31.0	4	●	131	151	216	40	50	0.55	SO◌X09
MVX3100X5F40		5	●	162	182	247	40	50	0.55	SO◌X09
MVX3100X6F40		6	●	193	213	278	40	50	0.55	SO◌X09
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	SO◌X09
MVX3200X3F40		3	●	103	123	188	40	50	0.45	SO◌X09
MVX3200X4F40	32.0	4	●	135	155	220	40	50	0.45	SO◌X09
MVX3200X5F40		5	●	167	187	252	40	50	0.45	SO◌X09
MVX3200X6F40		6	●	199	219	284	40	50	0.45	SO◌X09
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	SO◌X09
MVX3300X3F40		3	●	106	126	191	40	50	0.4	SO◌X09
MVX3300X4F40	33.0	4	●	139	159	224	40	50	0.4	SO◌X09
MVX3300X5F40		5	●	172	192	257	40	50	0.4	SO◌X09
MVX3300X6F40		6	●	205	225	290	40	50	0.4	SO◌X09
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	SO◌X11
MVX3400X3F40		3	●	109	139	204	40	50	1.1	SO◌X11
MVX3400X4F40	34.0	4	●	143	173	238	40	50	1.1	SO◌X11
MVX3400X5F40		5	●	177	207	272	40	50	1.1	SO◌X11
MVX3400X6F40		6	●	211	241	306	40	50	1.1	SO◌X11
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	SO◌X11
MVX3500X3F40		3	●	112	142	207	40	50	1.0	SO◌X11
MVX3500X4F40	35.0	4	●	147	177	242	40	50	1.0	SO◌X11
MVX3500X5F40		5	●	182	212	277	40	50	1.0	SO◌X11
MVX3500X6F40		6	●	217	247	312	40	50	1.0	SO◌X11
MVX3550X3F40	35.5	3	●	113.5	143.5	208.5	40	50	1.0	SO◌X11
MVX3600X2F40		2	●	79	109	174	40	50	1.0	SO◌X11
MVX3600X3F40		3	●	115	145	210	40	50	1.0	SO◌X11
MVX3600X4F40	36.0	4	●	151	181	246	40	50	1.0	SO◌X11
MVX3600X5F40		5	●	187	217	282	40	50	1.0	SO◌X11
MVX3600X6F40		6	●	223	253	318	40	50	0.9	SO◌X11
MVX3700X2F40		2	●	81	111	176	40	50	0.9	SO◌X11
MVX3700X3F40		3	●	118	148	213	40	50	0.9	SO◌X11
MVX3700X4F40	37.0	4	●	155	185	250	40	50	0.9	SO◌X11
MVX3700X5F40		5	●	192	222	287	40	50	0.9	SO◌X11
MVX3700X6F40		6	●	229	259	324	40	50	0.9	SO◌X11

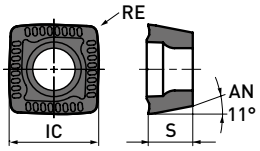
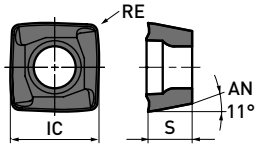
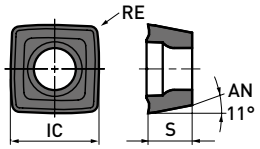
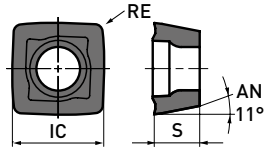
Numer zamówieniowy	DC	L x DC	Dostępność	LBX	LPR	OAL	DCON	DCSFMS	A	Typ płytki
MVX4400X2F40	44.0	2	●	95	125	190	40	50	1.1	SO◯X13
MVX4400X3F40		3	●	139	169	234	40	50	1.1	SO◯X13
MVX4400X4F40		4	●	183	213	278	40	63	1.1	SO◯X13
MVX4400X4F50		4	★	183	213	288	50	63	1.1	SO◯X13
MVX4400X5F40		5	●	227	257	322	40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

	DC	L x DC		LBX	LPR	OAL	DCON	DCSFMS	A	
MVX5700X2F40		2	●	121	161	226	40	68	1.5	S0◌X18
MVX5700X3F40		3	●	178	218	283	40	68	1.5	S0◌X18
MVX5700X4F40	57.0	4	●	235	275	340	40	68	1.5	S0◌X18
MVX5700X4F50		4	★	235	275	350	50	68	1.5	S0◌X18
MVX5700X5F40		5	●	292	332	397	40	68	1.5	S0◌X18
MVX5700X5F50		5	★	292	332	407	50	68	1.5	S0◌X18
MVX5800X2F40		2	●	123	163	228	40	68	1.4	S0◌X18
MVX5800X3F40		3	●	181	221	286	40	68	1.4	S0◌X18
MVX5800X4F40	58.0	4	●	239	279	344	40	68	1.4	S0◌X18
MVX5800X4F50		4	★	239	279	354	50	68	1.4	S0◌X18
MVX5800X5F40		5	●	297	337	402	40	68	1.4	S0◌X18
MVX5800X5F50		5	★	297	337	412	50	68	1.4	S0◌X18
MVX5900X2F40		2	●	125	165	230	40	68	1.3	S0◌X18
MVX5900X3F40		3	●	184	224	289	40	68	1.3	S0◌X18
MVX5900X4F40	59.0	4	●	243	283	348	40	68	1.3	S0◌X18
MVX5900X4F50		4	★	243	283	358	50	68	1.3	S0◌X18
MVX5900X5F40		5	●	302	342	407	40	68	1.3	S0◌X18
MVX5900X5F50		5	★	302	342	417	50	68	1.3	S0◌X18
MVX6000X2F40		2	●	127	167	232	40	68	1.2	S0◌X18
MVX6000X3F40		3	●	187	227	292	40	68	1.2	S0◌X18
MVX6000X4F40	60.0	4	●	247	287	352	40	68	1.2	S0◌X18
MVX6000X4F50		4	★	247	287	362	50	68	1.2	S0◌X18
MVX6000X5F40		5	●	307	347	412	40	68	1.2	S0◌X18
MVX6000X5F50		5	★	307	347	422	50	68	1.2	S0◌X18
MVX6100X2F40		2	●	129	169	234	40	68	1.1	S0◌X18
MVX6100X3F40		3	●	190	230	295	40	68	1.1	S0◌X18
MVX6100X4F40	61.0	4	●	251	291	356	40	68	1.1	S0◌X18
MVX6100X4F50		4	★	251	291	366	50	68	1.1	S0◌X18
MVX6100X5F40		5	●	312	352	417	40	68	1.1	S0◌X18
MVX6100X5F50		5	★	312	352	427	50	68	1.1	S0◌X18
MVX6200X2F40		2								
	62.0									

40.77 lmr[40 -1.38 lmr[406.249 -.626 -5.072 lr1.574 -2.041 13

17 – 19.5

P YTKI

	Numer zamówieniowy	MC5020*	MC1020*	VP15TF	DP8020	TF15	IC	S	RE	rednica wiert a	Kszta t
	UM										
	SOMX063005-UM	●	●	●			6.0	3.0	0.5	Ø17 - Ø19.5	
	SOMX073505-UM	●	●	●			7.0	3.5	0.5	Ø20 - Ø22.5	
	SOMX084005-UM	●	●	●			8.3	4.0	0.5	Ø23 - Ø27.5	
	SOMX094506-UM	●	●	●			9.7	4.5	0.6	Ø28 - Ø33	
	SOMX115506-UM	●	●	●			11.6	5.5	0.6	Ø33.5 - Ø39	
	SOMX136008-UM	●	●	●			13.8	6.0	0.8	Ø40 - Ø46	
	SOMX166508-UM	●	●	●			16.5	6.5	0.8	Ø47 - Ø56	
	SOMX187008-UM	●	●	●			18.2	7.0	0.8	Ø57 - Ø63	
	US										
	SOMX063005-US			●			6.0	3.0	0.5	Ø17 - Ø19.5	
	SOMX073505-US			●			7.0	3.5	0.5	Ø20 - Ø22.5	
	SOMX084005-US			●			8.3	4.0	0.5	Ø23 - Ø27.5	
	SOMX094506-US			●			9.7	4.5	0.6	Ø28 - Ø33	
	SOMX115506-US			●			11.6	5.5	0.6	Ø33.5 - Ø39	
	SOMX136008-US			●			13.8	6.0	0.8	Ø40 - Ø46	
	SOMX166508-US			●			16.5	6.5	0.8	Ø47 - Ø56	
	SOMX187008-US			●			18.2	7.0	0.8	Ø57 - Ø63	
	UH										
NEW	SOMX062905-UH				●		6.0	2.9	0.5	Ø17 - Ø19.5	
NEW	SOMX073405-UH				●		7.0	3.4	0.5	Ø20 - Ø22.5	
NEW	SOMX083905-UH				●		8.3	3.9	0.5	Ø23 - Ø27.5	
NEW	SOMX094406-UH				●		9.7	4.4	0.6	Ø28 - Ø33	
NEW	SOMX115406-UH				●		11.6	5.4	0.6	Ø33.5 - Ø39	
NEW	SOMX135908-UH				●		13.8	5.9	0.8	Ø40 - Ø46	
NEW	SOMX166408-UH				●		16.5	6.4	0.8	Ø47 - Ø56	
NEW	SOMX186908-UH				●		18.2	6.9	0.8	Ø57 - Ø63	
	UN										
NEW	SOGX063005-UN					●	6.0	3.0	0.5	Ø17 - Ø19.5	
NEW	SOGX073505-UN					●	7.0	3.5	0.5	Ø20 - Ø22.5	
NEW	SOGX084005-UN					●	8.3	4.0	0.5	Ø23 - Ø27.5	
NEW	SOGX094506-UN					●	9.7	4.5	0.6	Ø28 - Ø33	
NEW	SOGX115506-UN					●	11.6	5.5	0.6	Ø33.5 - Ø39	
NEW	SOGX136008-UN					●	13.8	6.0	0.8	Ø40 - Ø46	
NEW	SOGX166508-UN					●	16.5	6.5	0.8	Ø47 - Ø56	
NEW	SOGX187008-UN					●	18.2	7.0	0.8	Ø57 - Ø63	

*Płytki MC1020 i MC5020 są wykonane wyłącznie do użytku w charakterze płytek zewnętrznych.

ZALECANE PARAMETRY SKRAWANIA

	Materia obrabiany	Twardo«‡	Vc (m/min)	amacz wiórka	Ø17 - Ø19.5 f (mm/obr.)				Ø20 - Ø23.5 f (mm/obr.)			
			LxDC=2-6		LxDC=2.3	LxDC=4	LxDC=5	LxDC=6	LxDC=2.3	LxDC=4	LxDC=5	LxDC=6
P	Stal konstrukcyjna (C15, Ck15)	≤180HB	200 (180-235)	UM	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)	0.06 (0.04 - 0.08)	0.06 (0.04 - 0.07)	0.06 (0.04 - 0.07)	0.04 (0.04 - 0.05)
				UH								
	Stale węglowe, stopowe (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)	0.05 (0.04 - 0.06)	0.10 (0.06 - 0.18)	0.09 (0.06 - 0.12)	0.09 (0.06 - 0.12)	0.07 (0.06 - 0.08)
				UH								
	Stale węglowe, stopowe (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)	0.05 (0.04 - 0.06)	0.10 (0.06 - 0.18)	0.09 (0.06 - 0.12)	0.09 (0.06 - 0.12)	0.07 (0.06 - 0.08)
				UH								
	Stal narzędziowa stopowa (X210Cr12)	≤350HB	135 (100-170)	UM	0.08 (0.06 - 0.14)	0.08 (0.06 - 0.09)	0.08 (0.06 - 0.09)	0.05 (0.04 - 0.06)	0.10 (0.06 - 0.18)	0.09 (0.06 - 0.12)	0.09 (0.06 - 0.12)	0.07 (0.06 - 0.08)
				UH								
M	Austenityczna stal nierdzewna (X5CrNi18-10, X5CrNiMo17-12-2)	≤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)	0.10 (0.06 - 0.14)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
	Austenityczna stal nierdzewna (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)	0.10 (0.06 - 0.14)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
	Ferrytyczna i martenzytyczna stal nierdzewna (X12Cr13, X6Cr17)	≤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)	0.10 (0.06 - 0.14)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
	Stal ferrytyczna, martenzytyczna Stal nierdzewna (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)	0.10 (0.06 - 0.14)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
				UM	0.06 (0.04 - 0.08)	0.05 (0.04 - 0.06)	0.05 (0.04 - 0.06)	0.04 (0.04 - 0.05)	0.08 (0.06 - 0.12)	0.07 (0.06 - 0.08)	0.07 (0.06 - 0.08)	0.06 (0.06 - 0.07)
K	Żeliwo szare (GG25, GG30)	Wytrzy-małość na rozciąganie <350 MPa	160 (130-195)	UM	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)	0.14 (0.10 - 0.18)	0.10 (0.10 - 0.12)	0.10 (0.10 - 0.12)	0.07 (0.06 - 0.08)
	Żeliwo sferoidalne (GG40)	Wytrzy-małość na rozciąganie 450 MPa	100 (80-135)	UM	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)	0.13 (0.10 - 0.16)	0.10 (0.10 - 0.11)	0.10 (0.10 - 0.11)	0.07 (0.06 - 0.08)
	Żeliwo sferoidalne (GGG70)	Wytrzy-małość na rozciąganie <800 MPa	100 (70-125)	UM	0.11 (0.08 - 0.14)	0.09 (0.08 - 0.10)	0.09 (0.08 - 0.10)	0.05 (0.04 - 0.06)	0.13 (0.10 - 0.16)	0.10 (0.10 - 0.11)	0.10 (0.10 - 0.11)	0.07 (0.06 - 0.08)
N	Stop aluminium (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)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Stop aluminium (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)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Stop aluminium (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)	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	Stale hartowane (X40CrMoV51, 55NiCrMoV6)	38 - 45HRC	50 (30-80)	UH	0.08 (0.04 - 0.12)	0.06 (0.04 - 0.09)	-	-	0.09 (0.06 - 0.14)	0.07 (0.06 - 0.09)	-	-

ZALECANE PARAMETRY SKRAWANIA

	Materia obrabiany	Twardo«‡	Vc (m/min)	amacz wióra	Ø24 - Ø29.5 f (mm/obr.)				Ø30 - Ø63 f (mm/obr.)			
			LxDC=2-6		LxDC=2.3	LxDC=4	LxDC=5	LxDC=6	LxDC=2.3	LxDC=4	LxDC=5	LxDC=6
P	Stal konstrukcyjna (C15, Ck15)	≤180HB	200 (180-235)	UM	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								
	Stale węglowe, stopowe (Ck45, 41CrMo4)	180 - 280HB	140 (115 -180)	UM	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								
	Stale węglowe, stopowe (100Cr6)	280 - 350HB	100 (75-140)	UM	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								
	Stal narzędziowa stopowa (X210Cr12)	≤350HB	135 (100-170)	UM	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	Austenityczna stal nierdzewna (X5CrNi18-10, X5CrNiMo17-12-2)	≤200HB	130 (80-180)	US	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	0.09 (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)
	Austenityczna stal nierdzewna (X2CrNiN18-9, X5CrNiMoN17-11-2)	>200HB	130 (80-180)	US	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	0.09 (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)
	Ferrytyczna i martenzytyczna stal nierdzewna (X12Cr13, X6Cr17)	≤200HB	120 (80-165)	US	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	0.09 (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)
	Stal ferrytyczna, martenzytyczna Stal nierdzewna (X17CrNi16-2, X30Cr13)	>200HB	120 (80-165)	US	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	0.09 (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	Żeliwo szare (GG25, GG30)	Wytrzy-małość na rozciąganie <350 MPa	160 (130-195)	UM	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)
	Żeliwo sferoidalne (GG40)	Wytrzy-małość na rozciąganie 450 MPa	100 (80-135)	UM	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)
	Żeliwo sferoidalne (GGG70)	Wytrzy-małość na rozciąganie <800 MPa	100 (70-125)	UM	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	Stop aluminium (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)	0.12 (0.05 - 0.20)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Stop aluminium (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)	0.12 (0.05 - 0.20)	0.12 (0.05 - 0.18)	0.12 (0.05 - 0.18)	0.08 (0.05 - 0.12)
	Stop aluminium (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)	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	Stale hartowane (X40CrMoV51, 55NiCrMoV6)	38 - 45HRC	50 (30-80)	UH	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. Zmniejszyć prędkość skrawania o 30%, gdy stosowana jest płytka zewnętrzna VP15TF.
2. Przy stosowaniu wyłącznie chłodzenia zewnętrznego zalecany maksymalny wysięg wynosi L/D = 3.
3. Przy wierceniu stali nierdzewnej bardzo potrzebne są przelotowe kanały doprowadzenia chłodziwa.

[redacted]

			DCB	DCON	BD	LF	L5	*	
JFS2520-10		●	20	25	33	43	30	0.1	F20
JFS2520-20		●	20	25	33	43	30	0.2	F20
JFS2520-30	JFS-1	●	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		●	25	32	40	50	34	0.1	F25
JFS3225-20		●	25	32	40	50	34	0.2	F25
JFS3225-30	JFS-2	●	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		●	32	40	48	55	40	0.1	F32
JFS4032-20		●	32	40	48	55	40	0.2	F32
JFS4032-30	JFS-3	●	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

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