

 DrillLine

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Tungaloy Report No. 67S2-I

Nuove cuspidi DMH, ottima resistenza alla frattura



INDUSTRY 4.0
FEED the SPEED!



Per maggiori informazioni

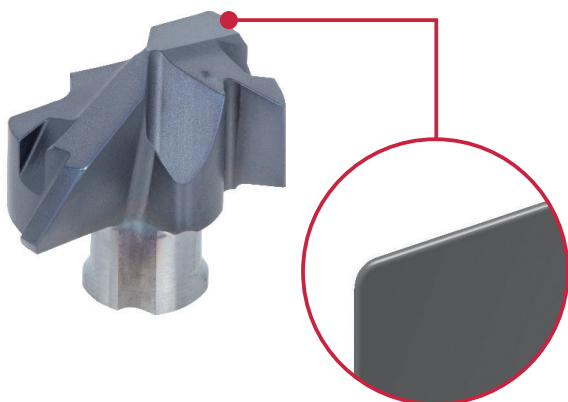
Vita utensile maggiore nelle operazioni complesse

New

DMH

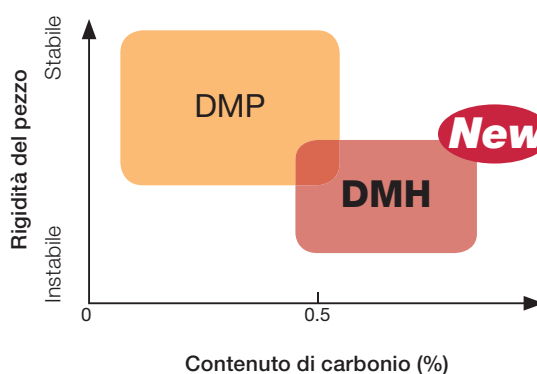
Preparazione del tagliente resistente agli urti

- Taglienti robusti ideali nelle operazioni di foratura più gravose e complesse.
- In abbinamento al grado AH9130, versatile e resistente all'usura.

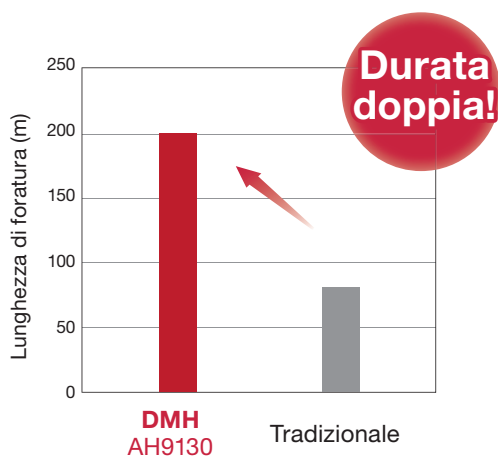


Spigolo rinforzato

■ Campo di applicazione cuspidi DMH



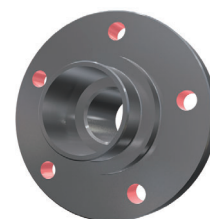
Maggior durata, assenza rotture ai vertici



DMH AH9130



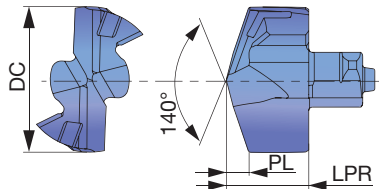
Tradizionale



P	Punta	: $\phi 13.7$ mm, L/D = 3
	Materiale	: acciaio ad alto tenore di carbonio
	Cuspide	: DMH137
	Grado	: AH9130
	Vel. di taglio	: $V_c = 90$ m/min
	Avanzamento	: $f = 0.3$ mm/giro
	Profondità foro	: $H = 20$ mm
Refrigerante	: Esterno	

CUSPIDI

DMH



Diametro punta	ø10 - ø19.5
Tolleranza diametro cuspidi	±0.01

Denominazione	DC	Grado AH9130	LPR	PL	Dim. sede	Corpo punta
DMH100	10	●	6.1	1.47	10	TID*100*
DMH103	10.3	●	6.1	1.52	10	TID*100*
DMH105	10.5	●	6.1	1.56	10	TID*105*
DMH108	10.8	●	6.1	1.62	10	TID*105*
DMH110	11	●	6.5	1.67	11	TID*110*
DMH115	11.5	●	6.5	1.76	11	TID*115*
DMH120	12	●	6.8	1.82	12	TID*120*
DMH125	12.5	●	6.8	1.91	12	TID*125*
DMH126	12.6	●	6.8	1.93	12	TID*125*
DMH130	13	●	7.4	1.96	13	TID*130*
DMH133	13.3	●	7.4	2.01	13	TID*130*
DMH135	13.5	●	7.4	2.05	13	TID*135*
DMH137	13.7	●	7.4	2.09	13	TID*135*
DMH138	13.8	●	7.4	2.11	13	TID*135*
DMH139	13.9	●	7.4	2.12	13	TID*135*
DMH140	14	●	8	2.12	14	TID*140*
DMH142	14.2	●	8	2.16	14	TID*142*
DMH145	14.5	●	8	2.21	14	TID*145*
DMH150	15	●	8.5	2.27	15	TID*150*
DMH152	15.2	●	8.5	2.31	15	TID*150*
DMH155	15.5	●	8.5	2.36	15	TID*150*
DMH160	16	●	9.1	2.42	16	TID*160*
DMH165	16.5	●	9.1	2.51	16	TID*160*
DMH170	17	●	9.7	2.59	17	TID*170*
DMH175	17.5	●	9.7	2.68	17	TID*170*
DMH180	18	●	10.3	2.73	18	TID*180*
DMH185	18.5	●	10.3	2.82	18	TID*180*
DMH190	19	●	10.8	2.88	19	TID*190*
DMH194	19.4	●	10.8	2.95	19	TID*190*
DMH195	19.5	●	10.8	2.97	19	TID*190*

●: Standard stock

PARAMETRI DI TAGLIO STANDARD

ISO	Materiale da lavorare	Velocità di taglio Vc (m/min)	Avanzamento: f (mm/giro)			
			DC (mm)			
			ø10 - ø11.9	ø12 - ø13.9	ø14 - ø15.9	ø16 - ø19.9
P	Acciai a basso tenore di C (< 0.3) (SS400 / St42-1, SM490 / St52-3, S25C / C25, ecc.)	80 - 140	0.15 - 0.28	0.18 - 0.3	0.2 - 0.35	0.25 - 0.45
	Acciai ad alto tenore di C (> 0.3) (S45C / C45, S55C / C55, ecc.)	70 - 120	0.15 - 0.28	0.18 - 0.3	0.2 - 0.35	0.25 - 0.45
	Acciai debolmente legati (SCM415, ecc.)	70 - 120	0.14 - 0.28	0.16 - 0.32	0.18 - 0.35	0.23 - 0.4
	Acciai legati (SCM440 / 42CrMo4, SCr420 / 20Cr4, ecc.)	40 - 90	0.14 - 0.28	0.16 - 0.32	0.18 - 0.35	0.23 - 0.4
M	Acciai inossidabili (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-2, ecc.)	30 - 70	0.12 - 0.18	0.14 - 0.2	0.16 - 0.24	0.16 - 0.26
K	Ghisa grigia (FC250 / GG25, ecc.)	80 - 180	0.2 - 0.35	0.25 - 0.4	0.3 - 0.45	0.35 - 0.55
	Ghisa sferoidale (FCD700 / GGG70, ecc.)	80 - 140	0.2 - 0.35	0.25 - 0.4	0.3 - 0.45	0.35 - 0.55
N	Leghe di alluminio (ADC12, ecc.)	80 - 220	0.25 - 0.4	0.3 - 0.45	0.35 - 0.5	0.4 - 0.6
S	Leghe di titanio (Ti-6Al-4V, ecc.)	20 - 50	0.08 - 0.15	0.1 - 0.18	0.12 - 0.2	0.14 - 0.22
	Leghe a base Nickel	20 - 50	0.08 - 0.13	0.1 - 0.15	0.12 - 0.18	0.12 - 0.22
H	Acciai temprati	20 - 50	0.08 - 0.15	0.1 - 0.18	0.12 - 0.2	0.14 - 0.22

- I parametri di taglio possono variare in funzione della rigidità e potenza della macchina e del materiale da lavorare.
- Il diametro del foro può variare in funzione della rigidità della macchina o dei parametri di taglio.

- In caso di punte L/D = 8 & 12, fare riferimento ai valori medio-minimi indicati in tabella.

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