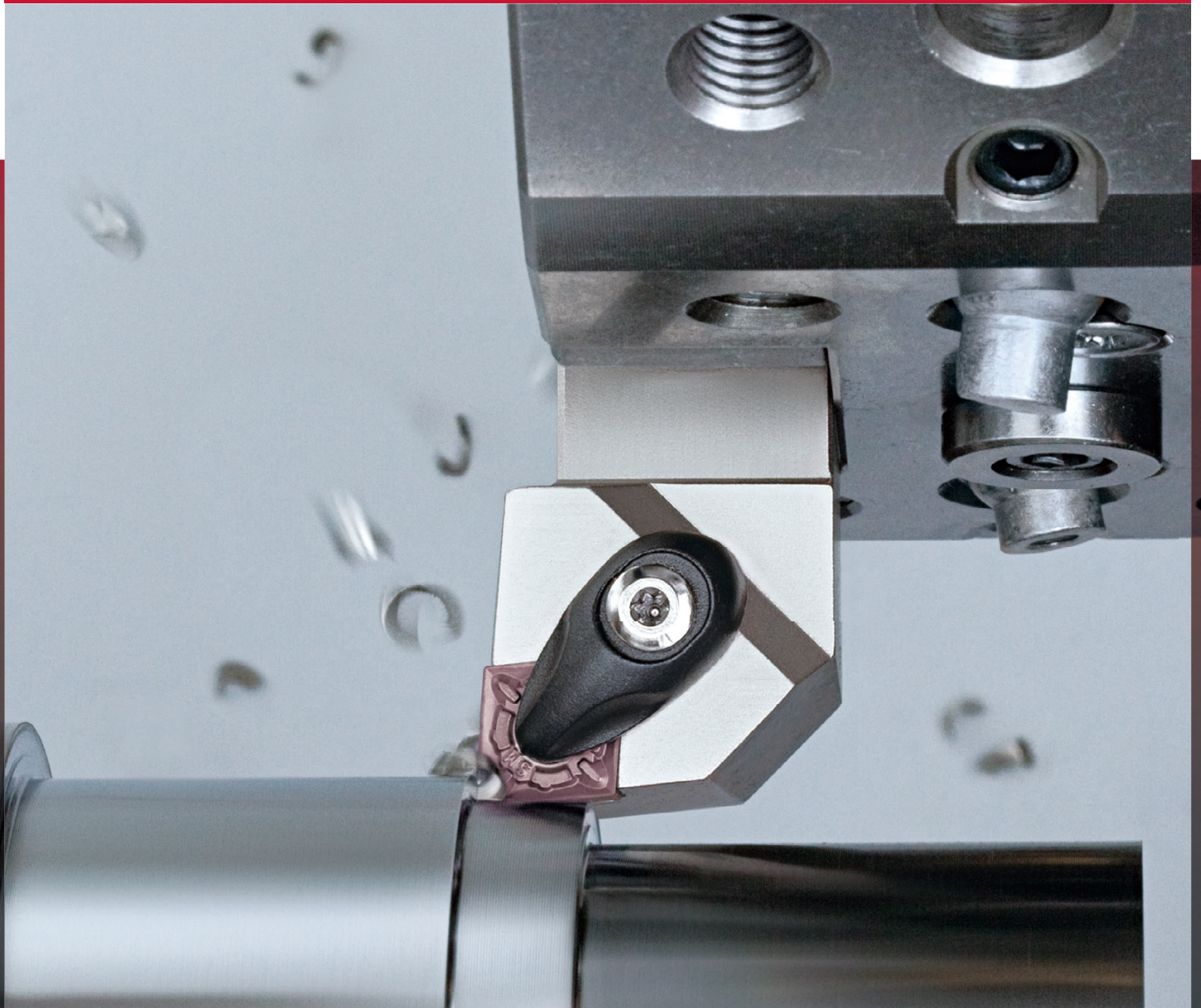


# AH6225

Tungaloy Report No. 88-I1

Grado rivestito PVD di nuova  
generazione per la tornitura  
degli acciai inossidabili



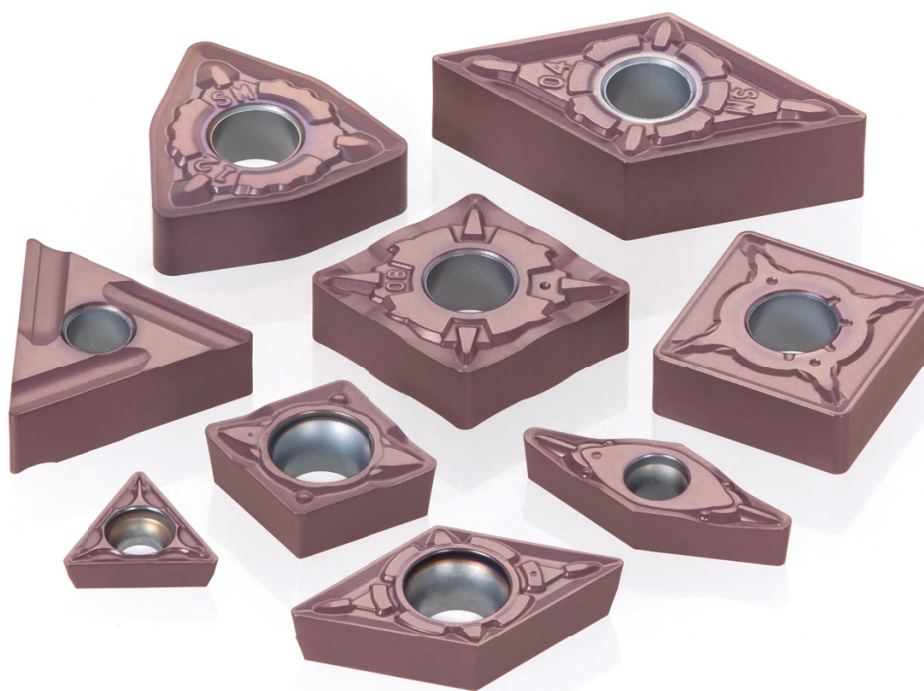


**INDUSTRY 4.0**  
*FEED the SPEED!*



# AH6225

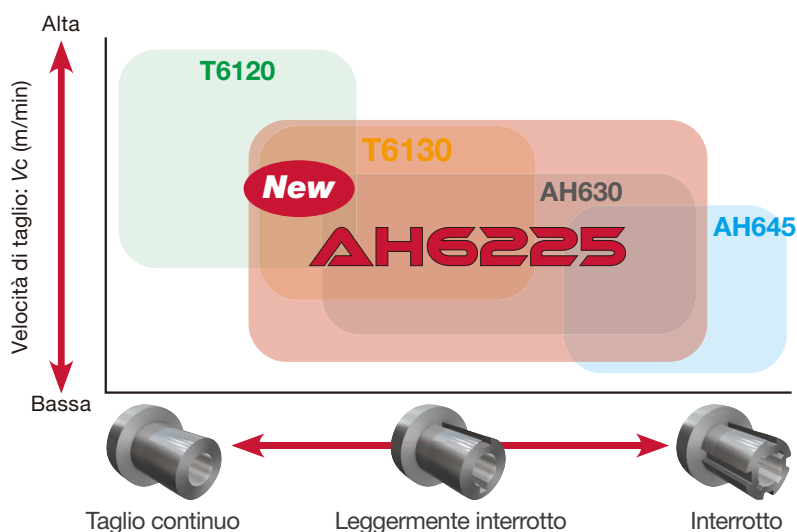
---



**Nuovo grado AH6225**  
**Affidabilità nella tornitura degli acciai inossidabili!**

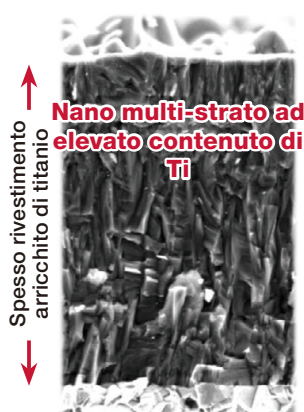
# AH6225

**AH6225** la nuova soluzione versatile per la tornitura dei componenti in acciaio inossidabile!



**New**

## AH6225



**Nano multi-strato ad elevato contenuto di Ti**

### Rivestimento PVD di ultima generazione

#### Arricchito di Titanio

- Rivestimento PVD di elevato spessore, arricchito di titanio che conferisce resistenza agli shock termici.
- Usura per craterizzazione ridotta.

#### A struttura nano-multistrato

Lo strato più esterno, a struttura nano-multistrato e con un elevato contenuto di titanio, è stato realizzato grazie alla più recente tecnologia dei rivestimenti Tungaloy. La nano-struttura e la durezza forniscono un ottimo rapporto tra resistenza all'usura e resistenza alla frattura, migliorando la durata e la prevedibilità dell'inserto.

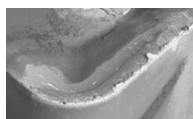
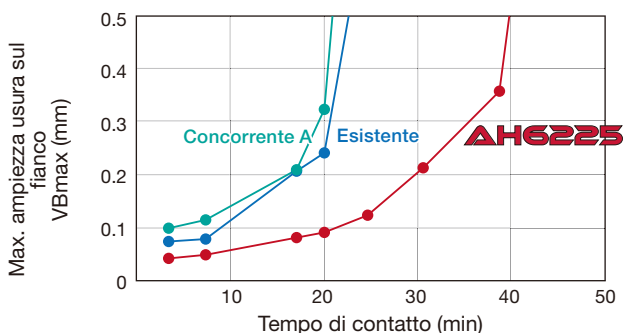
#### Substrato dedicato in metallo duro

Grazie all'elevata conducibilità termica del substrato, il calore generato durante la lavorazione viene dissipato e la temperatura efficacemente ridotta nella zona di contatto. La deformazione plastica diminuisce sensibilmente e il tagliente resta integro più a lungo. Ideale nel taglio continuo.

ISO	Grado	Substrato			Strato di rivestimento	
		Peso specifico	Durezza (HRA)	T.R.S. (GPa)	Composizione principale	Spessore (µm)
<b>M</b>	AH6225	14.9	91.8	3.1	(TiAl)N - Ti(CN)	5.5

## RENDIMENTO

### M Acciaio inossidabile austenitico X2CrNiMo17-12-2 / SUS316L



**AH6225**  
22 min. di contatto



**Esistente**  
18 min. di contatto

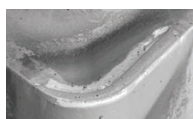
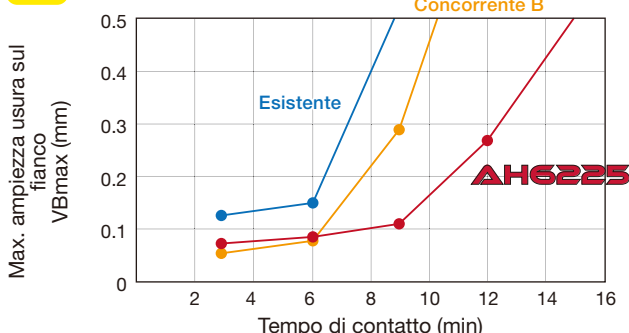


**Concorrente A**  
18 min. di contatto

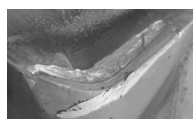
Velocità di taglio :  $V_c = 150$  m/min  
 Avanzamento :  $f = 0.3$  mm/giro  
 Profondità di taglio :  $a_p = 2$  mm  
 Operazione : Taglio continuo  
 Refrigerante : Sì

**AH6225 dimostra la migliore resistenza all'usura.**

### M Acciaio inossidabile martensitico X30Cr13 / SUS420J2



**AH6225**  
9 min. di contatto



**Esistente**  
9 min. di contatto



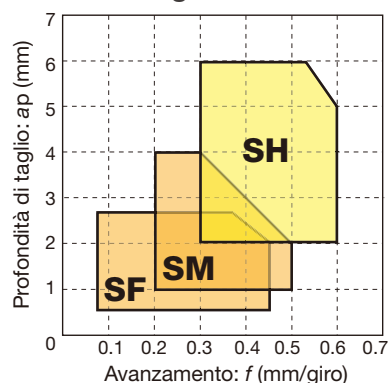
**Concorrente B**  
9 min. di contatto

Velocità di taglio :  $V_c = 200$  m/min  
 Avanzamento :  $f = 0.3$  mm/giro  
 Profondità di taglio :  $a_p = 2$  mm  
 Operazione : Taglio continuo  
 Refrigerante : Sì

**Ottima resistenza all'usura del grado AH6225.**

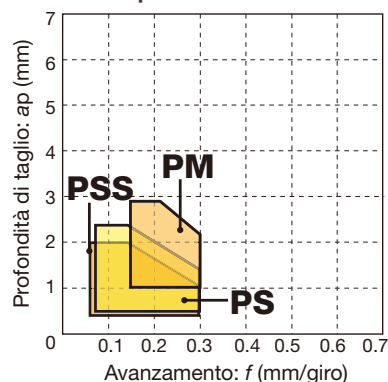
## PARAMETRI DI TAGLIO STANDARD

### Inserti negativi



Materiale da lavorare	Grado	Rompi-truciolo	Velocità di taglio $V_c$ (m/min)	Prof. di taglio $a_p$ (mm)	Avanzamento $f$ (mm/rev)
Acciai inossidabili austenitici	AH6225	SF	90 - 200	0.5 - 2.5	0.08 - 0.45
	AH6225	SM	90 - 200	1 - 4	0.2 - 0.5
	AH6225	SH	90 - 200	2 - 6	0.3 - 0.6
Acciai inossidabili ferritici e martensitici	AH6225	SF	110 - 240	0.5 - 2.5	0.08 - 0.45
	AH6225	SM	110 - 240	1 - 4	0.2 - 0.5
	AH6225	SH	110 - 240	2 - 6	0.3 - 0.6
Acciai inossidabili invecchiamento artificiale	AH6225	SF	60 - 110	0.5 - 2.5	0.08 - 0.45
	AH6225	SM	60 - 110	1 - 4	0.2 - 0.5
	AH6225	SH	60 - 110	2 - 6	0.3 - 0.6

### Inserti positivi



Materiale da lavorare	Grado	Rompi-truciolo	Velocità di taglio $V_c$ (m/min)	Prof. di taglio $a_p$ (mm)	Avanzamento $f$ (mm/rev)
Acciai inossidabili austenitici	AH6225	PSS	90 - 200	0.3 - 2	0.08 - 0.3
	AH6225	PS	90 - 200	0.5 - 2.5	0.08 - 0.3
	AH6225	PM	90 - 200	1 - 3	0.15 - 0.3
Acciai inossidabili ferritici e martensitici	AH6225	PSS	110 - 240	0.3 - 2	0.08 - 0.3
	AH6225	PS	110 - 240	0.5 - 2.5	0.08 - 0.3
	AH6225	PM	110 - 240	1 - 3	0.15 - 0.3
Acciai inossidabili invecchiamento artificiale	AH6225	PSS	60 - 110	0.3 - 2	0.08 - 0.3
	AH6225	PS	60 - 110	0.5 - 2.5	0.08 - 0.3
	AH6225	PM	60 - 110	1 - 3	0.15 - 0.3

## Inserti NEGATIVI

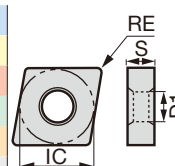
● : Taglio continuo  
 ●● : Taglio leggermente interrotto  
 ✱ : Taglio interrotto

# CN



**Rombico, 80°  
con foro**

<b>P</b> Acciai ✱	
<b>M</b> Inossidabili ●●	
<b>K</b> Ghisa	
<b>N</b> Non ferrosi	
<b>S</b> Super leghe	
<b>H</b> Materiali duri	



Applicazione	Rompitruciolo	Denominazione	Rivestito		Dimensioni (mm)				
			AH6225		RE	IC	S	D1	
Finitura	 	<b>SF</b> CNMG120404-SF ●			0.4	12.7	4.76	5.16	
		CNMG120408-SF ●			0.8	12.7	4.76	5.16	
		CNMG120412-SF ●			1.2	12.7	4.76	5.16	
	 	<b>SS</b> CNMG120404-SS ●			0.4	12.7	4.76	5.16	
		CNMG120408-SS ●			0.8	12.7	4.76	5.16	
		CNMG120412-SS ●			1.2	12.7	4.76	5.16	
	Taglio medio	 	<b>SM</b> CNMG120404-SM ●			0.4	12.7	4.76	5.16
			CNMG120408-SM ●			0.8	12.7	4.76	5.16
			CNMG120412-SM ●			1.2	12.7	4.76	5.16
 		<b>SA</b> CNMG120404-SA ●			0.4	12.7	4.76	5.16	
		CNMG120408-SA ●			0.8	12.7	4.76	5.16	
		CNMG120412-SA ●			1.2	12.7	4.76	5.16	
 		<b>S</b> CNMG120404R-S ●			0.4	12.7	4.76	5.16	
		CNMG120404L-S ●			0.4	12.7	4.76	5.16	
		CNMG120408R-S ●			0.8	12.7	4.76	5.16	
		CNMG120408L-S ●			0.8	12.7	6.35	5.16	
Taglio medio-pesante		 	<b>SH</b> CNMG120408-SH ●			0.8	12.7	4.76	5.16
	CNMG120412-SH ●				1.2	12.7	4.76	5.16	
	CNMG120416-SH ●				1.6	12.7	4.76	5.16	

● : Novità

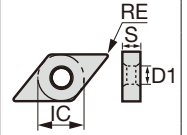
# Inserti NEGATIVI

- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✳ : Taglio interrotto

## DN

Rombico, 55°  
con foro

	P	M	K	N	S	H
Acciai	✳					
Inossidabili	●	●				
Ghisa			●			
Non ferrosi				●		
Super leghe					●	
Materiali duri						●



Applicazione	Rompitruciolo	Denominazione	Rivestito						Dimensioni (mm)						
			AH6225						RE	IC	S	D1			
Finitura		<b>SF</b> DNMG150404-SF ●								0.4	12.7	4.76	5.16		
		DNMG150408-SF ●								0.8	12.7	4.76	5.16		
		DNMG150604-SF ●									0.4	12.7	6.35	5.16	
		DNMG150608-SF ●									0.8	12.7	6.35	5.16	
Taglio medio		<b>SM</b> DNMG150404-SM ●									0.4	12.7	4.76	5.16	
		DNMG150408-SM ●									0.8	12.7	4.76	5.16	
		DNMG150412-SM ●									1.2	12.7	4.76	5.16	
		DNMG150604-SM ●										0.4	12.7	6.35	5.16
		DNMG150608-SM ●										0.8	12.7	6.35	5.16
		DNMG150612-SM ●										1.2	12.7	6.35	5.16
Taglio medio-pesante		<b>S</b> DNMG150404R-S ●									0.4	12.7	4.76	5.16	
		DNMG150404L-S ●									0.4	12.7	4.76	5.16	
		DNMG150408R-S ●										0.8	12.7	4.76	5.16
		DNMG150408L-S ●										0.8	12.7	4.76	5.16
		DNMG150604R-S ●										0.4	12.7	6.35	5.16
		DNMG150604L-S ●										0.4	12.7	6.35	5.16
		DNMG150608R-S ●										0.8	12.7	6.35	5.16
		DNMG150608L-S ●										0.8	12.7	6.35	5.16
		<b>SH</b> DNMG150408-SH ●										0.8	12.7	4.76	5.16
		DNMG150412-SH ●										1.2	12.7	4.76	5.16
DNMG150416-SH ●										1.6	12.7	4.76	5.16		
DNMG150608-SH ●										0.8	12.7	6.35	5.16		
DNMG150612-SH ●										1.2	12.7	6.35	5.16		

● : Novità

## Inserti NEGATIVI

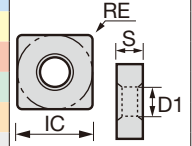
- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✱ : Taglio interrotto


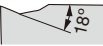
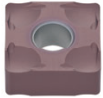


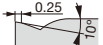




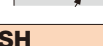


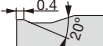

# SN



**Quadrato, 90°  
con foro**

<b>P</b> Acciai ✱	
<b>M</b> Inossidabili ●◐	
<b>K</b> Ghisa	
<b>N</b> Non ferrosi	
<b>S</b> Super leghe	
<b>H</b> Materiali duri	



Applicazione	Rompitruciolo	Denominazione	Rivestito										Dimensioni (mm)						
			AH6225												RE	IC	S	D1	
Finitura	<b>SF</b>	<b>SNMG120404-SF</b>	●													0.4	12.7	4.76	5.16
		<b>SNMG120408-SF</b>	●													0.8	12.7	4.76	5.16
																			
	<b>SS</b>	<b>SNMG120404-SS</b>	●													0.4	12.7	4.76	5.16
		<b>SNMG120408-SS</b>	●													0.8	12.7	4.76	5.16
		<b>SNMG120412-SS</b>	●													1.2	12.7	4.76	5.16
Taglio medio	<b>SM</b>	<b>SNMG120408-SM</b>	●													0.8	12.7	4.76	5.16
		<b>SNMG120412-SM</b>	●													1.2	12.7	4.76	5.16
																			
	<b>SA</b>	<b>SNMG120404-SA</b>	●													0.4	12.7	4.76	5.16
		<b>SNMG120408-SA</b>	●													0.8	12.7	4.76	5.16
		<b>SNMG120412-SA</b>	●													1.2	12.7	4.76	5.16
Taglio medio-pesante	<b>S</b>	<b>SNMG120404R-S</b>	●													0.4	12.7	4.76	5.16
		<b>SNMG120404L-S</b>	●													0.4	12.7	4.76	5.16
		<b>SNMG120408R-S</b>	●													0.8	12.7	4.76	5.16
		<b>SNMG120408L-S</b>	●													0.8	12.7	4.76	5.16
																			
	<b>SH</b>	<b>SNMG120408-SH</b>	●													0.8	12.7	4.76	5.16
	<b>SNMG120412-SH</b>	●													1.2	12.7	4.76	5.16	
																			
																			

● : Novità



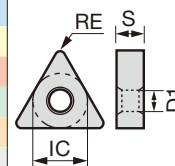
# Inserti **NEGATIVI**

- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✦ : Taglio interrotto

## TN



<b>P</b> Acciai ✦																				
<b>M</b> Inossidabili ●●																				
<b>K</b> Ghisa																				
<b>N</b> Non ferrosi																				
<b>S</b> Super leghe																				
<b>H</b> Materiali duri																				



Applicazione	Rompitruciolo	Denominazione	Rivestito		Dimensioni (mm)					
			AH6225		RE	IC	S	D1		
Finitura		<b>SF</b> <b>TNMG160404-SF</b>	●			0.4	9.525	4.76	3.81	
		TNMG160408-SF	●			0.8	9.525	4.76	3.81	
		TNMG160412-SF	●			1.2	9.525	4.76	3.81	
		<b>SS</b> <b>TNMG160404-SS</b>	●			0.4	9.525	4.76	3.81	
		TNMG160408-SS	●			0.8	9.525	4.76	3.81	
		TNMG160412-SS	●			1.2	9.525	4.76	3.81	
	Taglio medio		<b>SM</b> <b>TNMG160404-SM</b>	●			0.4	9.525	4.76	3.81
			TNMG160408-SM	●			0.8	9.525	4.76	3.81
			TNMG160412-SM	●			1.2	9.525	4.76	3.81
		<b>SA</b> <b>TNMG160404-SA</b>	●			0.4	9.525	4.76	3.81	
		TNMG160408-SA	●			0.8	9.525	4.76	3.81	
		TNMG160412-SA	●			1.2	9.525	4.76	3.81	
Taglio medio-pesante			<b>S</b> <b>TNMG160404R-S</b>	●			0.4	9.525	4.76	3.81
			TNMG160404L-S	●			0.4	9.525	4.76	3.81
			TNMG160408R-S	●			0.8	9.525	4.76	3.81
	TNMG160408L-S		●			0.8	9.525	4.76	3.81	

● : Novità

## Inserti NEGATIVI

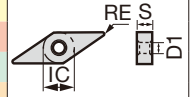
- : Taglio continuo
- : Taglio leggermente interrotto
- ✶ : Taglio interrotto

# VN



**Rombico, 35° con foro**

<b>P</b> Acciai ✶	
<b>M</b> Inossidabili ●●	
<b>K</b> Ghisa	
<b>N</b> Non ferrosi	
<b>S</b> Super leghe	
<b>H</b> Materiali duri	



Applicazione	Rompitruciolo	Denominazione	Rivestito				Dimensioni (mm)				
			AH6225				RE	IC	S	D1	
Finitura		<b>SF</b> VNMG160404-SF ●					0.4	9.525	4.76	3.81	
		VNMG160408-SF ●					0.8	9.525	4.76	3.81	
		<b>SS</b> VNMG160404-SS ●						0.4	9.525	4.76	3.81
		VNMG160408-SS ●						0.8	9.525	4.76	3.81
		VNMG160412-SS ●						1.2	9.525	4.76	3.81
Taglio medio		<b>SM</b> VNMG160404-SM ●						0.4	9.525	4.76	3.81
		VNMG160408-SM ●						0.8	9.525	4.76	3.81
		VNMG160412-SM ●						1.2	9.525	4.76	3.81

● : Novità

# Inserti NEGATIVI

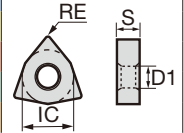
● : Taglio continuo  
 ● : Taglio leggermente interrotto  
 ✖ : Taglio interrotto

## WN



Trigonale, 80°  
con foro

<b>P</b>	Acciai	✖																							
<b>M</b>	Inossidabili	●●																							
<b>K</b>	Ghisa	●●																							
<b>N</b>	Non ferrosi	●●																							
<b>S</b>	Super leghe	●●																							
<b>H</b>	Materiali duri	●●																							

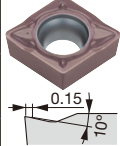
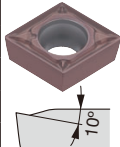
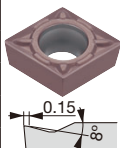


Applicazione	Rompitruciolo	Denominazione	Rivestito																				Dimensioni (mm)								
			AH6225																						RE	IC	S	D1			
Finitura	<b>SF</b>	WNUMG080404-SF	●																							0.4	12.7	4.76	5.16		
		WNUMG080408-SF	●																								0.8	12.7	4.76	5.16	
			<b>SS</b>	WNUMG080404-SS	●																							0.4	12.7	4.76	5.16
				WNUMG080408-SS	●																								0.8	12.7	4.76
	WNUMG080412-SS	●																									1.2	12.7	4.76	5.16	
Taglio medio	<b>SM</b>	WNUMG080404-SM	●																							0.4	12.7	4.76	5.16		
		WNUMG080408-SM	●																								0.8	12.7	4.76	5.16	
		WNUMG080412-SM	●																								1.2	12.7	4.76	5.16	
			<b>SA</b>	WNUMG080408-SA	●																							0.8	12.7	4.76	5.16
				WNUMG080412-SA	●																								1.2	12.7	4.76
		<b>SH</b>	WNUMG080408-SH	●																							0.8	12.7	4.76	5.16	
			WNUMG080412-SH	●																								1.2	12.7	4.76	5.16

● : Novità

## Inserti POSITIVI

- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✱ : Taglio interrotto

Applicazione		Rompitruciolo	Denominazione	Rivestito																Dimensioni (mm)			
				AH6225																RE	IC	S	D1
Finitura e taglio leggero		<b>PSS</b>	<b>CCMT060204-PSS</b>	●																0.4	6.35	2.38	2.8
			CCMT060208-PSS	●																0.8	6.35	2.38	2.8
			CCMT09T304-PSS	●																0.4	9.525	3.97	4.4
			CCMT09T308-PSS	●																0.8	9.525	3.97	4.4
Finitura e taglio medio		<b>PS</b>	<b>CCMT060202-PS</b>	●															0.2	6.35	2.38	2.8	
			CCMT060204-PS	●																0.4	6.35	2.38	2.8
			CCMT060208-PS	●																0.8	6.35	2.38	2.8
			CCMT09T302-PS	●																0.2	9.525	3.97	4.4
			CCMT09T304-PS	●																0.4	9.525	3.97	4.4
Taglio medio			CCMT09T308-PS	●														0.8	9.525	3.97	4.4		
		<b>PM</b>	<b>CCMT060204-PM</b>	●															0.4	6.35	2.38	2.8	
			CCMT060208-PM	●																0.8	6.35	2.38	2.8
			CCMT09T304-PM	●																0.4	9.525	3.97	4.4
		CCMT09T308-PM	●															0.8	9.525	3.97	4.4		

● : Novità

# Inserti POSITIVI

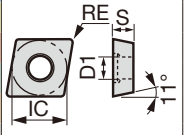
- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✱ : Taglio interrotto

# CP



**Rombico, 80°  
con foro  
Positivo 11°**

<b>P</b>	Acciai	✱																			
<b>M</b>	Inossidabili	●																			
<b>K</b>	Ghisa																				
<b>N</b>	Non ferrosi																				
<b>S</b>	Super leghe																				
<b>H</b>	Materiali duri																				



Applicazione	Rompitruciolo	Denominazione	Rivestito												Dimensioni (mm)						
			AH6225													RE	IC	S	D1		
Finitura e taglio leggero	 10°	<b>PSS</b>	●															0.4	9.525	3.18	4.4
			●																0.8	9.525	3.18
Finitura e taglio medio	 10°	<b>PS</b>	●															0.4	9.525	3.18	4.4
			●																0.8	9.525	3.18
Taglio medio	 8°	<b>PM</b>	●															0.4	9.525	3.18	4.4
			●																0.8	9.525	3.18

● : Novità

## Inserti POSITIVI

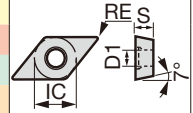
- : Taglio continuo
- : Taglio leggermente interrotto
- ✱ : Taglio interrotto

### DC

Rombico, 55°  
con foro  
Positivo 7°



	P	M	K	N	S	H
Acciai	✱					
Inossidabili	●●	●●	●●	●●	●●	●●
Ghisa			●●	●●	●●	●●
Non ferrosi				●●	●●	●●
Super leghe					●●	●●
Materiali duri						●●



Applicazione	Rompitruciolo	Denominazione	Rivestito				Dimensioni (mm)			
			AH6225				RE	IC	S	D1
Finitura e taglio leggero		<b>PSS</b> DCMT070204-PSS ●					0.4	6.35	2.38	2.8
		DCMT11T304-PSS ●					0.4	9.525	3.97	4.4
		DCMT11T308-PSS ●					0.8	9.525	3.97	4.4
Finitura e taglio medio		<b>PS</b> DCMT070204-PS ●					0.4	6.35	2.38	2.8
		DCMT11T302-PS ●					0.2	9.525	3.97	4.4
		DCMT11T304-PS ●					0.4	9.525	3.97	4.4
		DCMT11T308-PS ●					0.8	9.525	3.97	4.4
Taglio medio		<b>PM</b> DCMT070204-PM ●					0.4	6.35	2.38	2.8
		DCMT11T304-PM ●					0.4	9.525	3.97	4.4
		DCMT11T308-PM ●					0.8	9.525	3.97	4.4

● : Novità

# Inserti POSITIVI

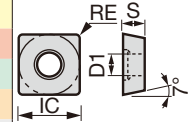
- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✱ : Taglio interrotto

## SC



**Quadrato, 90°  
con foro  
Positivo 7°**

P	Acciai	✱																				
M	Inossidabili	●●																				
K	Ghisa																					
N	Non ferrosi																					
S	Super leghe																					
H	Materiali duri																					



Applicazione		Rivestito	Dimensioni (mm)			
Rompitruciolo	Denominazione	AH6225	RE	IC	S	D1
<b>PS</b> 	<b>SCMT09T304-PS</b>	●	0.4	9.525	3.97	4.4
	<b>SCMT09T308-PS</b>	●	0.8	9.525	3.97	4.4
<b>PM</b> 	<b>SCMT09T304-PM</b>	●	0.4	9.525	3.97	4.4
	<b>SCMT09T308-PM</b>	●	0.8	9.525	3.97	4.4

● : Novità

## Inserti POSITIVI

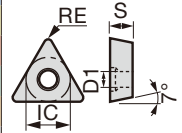
- : Taglio continuo
- ◐ : Taglio leggermente interrotto
- ✱ : Taglio interrotto

### TC



Triangolare, 60°  
con foro  
Positivo 7°

	P	M	K	N	S	H
Acciai	✱					
Inossidabili		●				
Ghisa			●			
Non ferrosi				●		
Super leghe					●	
Materiali duri						●



Applicazione	Rompitruciolo	Denominazione	Rivestito				Dimensioni (mm)			
			AH6225				RE	IC	S	D1
Finitura e taglio medio		<b>PS</b> TCMT110204-PS	●				0.4	6.35	2.38	2.8
		TCMT110208-PS	●				0.8	6.35	2.38	2.8
		TCMT16T304-PS	●				0.4	9.525	3.97	4.4
		TCMT16T308-PS	●				0.8	9.525	3.97	4.4
Taglio medio		<b>PM</b> TCMT110204-PM	●				0.4	6.35	2.38	2.8
		TCMT110208-PM	●				0.8	6.35	2.38	2.8
		TCMT16T304-PM	●				0.4	9.525	3.97	4.4
		TCMT16T308-PM	●				0.8	9.525	3.97	4.4

● : Novità



# Inserti POSITIVI

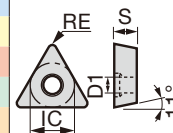
● : Taglio continuo  
● : Taglio leggermente interrotto  
✶ : Taglio interrotto


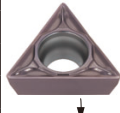

## TP

Triangolare, 60°  
 con foro  
 Positivo 11°



	P	M	K	N	S	H
Acciai						
Inossidabili						
Ghisa						
Non ferrosi						
Super leghe						
Materiali duri						

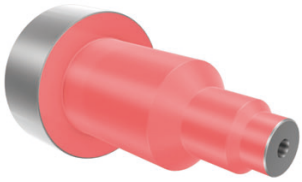
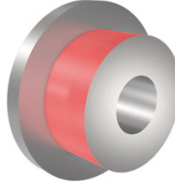
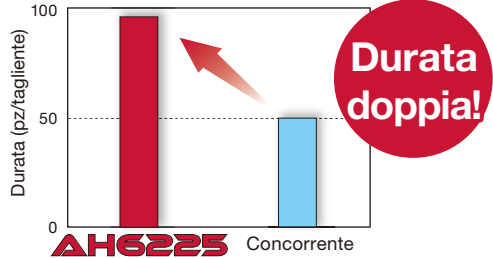
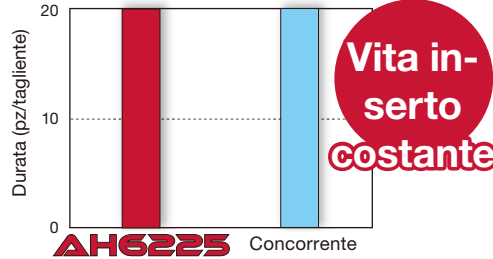
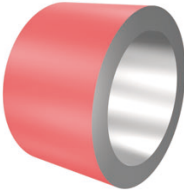
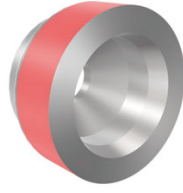
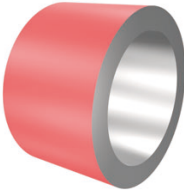
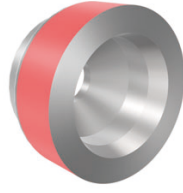
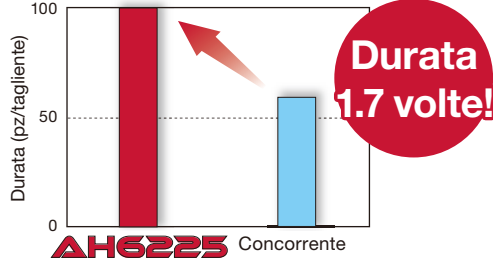
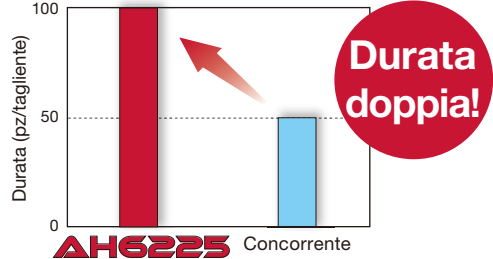


Applicazione	Rompitrucolo	Denominazione	Rivestito				Dimensioni (mm)			
			AH6225				RE	IC	S	D1
Finitura e taglio leggero		<b>PSS</b> TPMT090204-PSS ●					0.4	5.56	2.38	2.5
		TPMT090208-PSS ●					0.8	5.56	2.38	2.5
		TPMT110204-PSS ●					0.4	6.35	2.38	2.8
		TPMT110304-PSS ●					0.4	6.35	3.18	3.4
		TPMT130304-PSS ●					0.4	7.94	3.18	3.4
		TPMT130308-PSS ●					0.8	7.94	3.18	3.4
		TPMT16T304-PSS ●					0.4	9.525	3.97	4.4
		TPMT16T308-PSS ●					0.8	9.525	3.97	4.4
Finitura e taglio medio		<b>PS</b> TPMT090202-PS ●					0.2	5.56	2.38	2.5
		TPMT090204-PS ●					0.4	5.56	2.38	2.5
		TPMT090208-PS ●					0.8	5.56	2.38	2.5
		TPMT110204-PS ●					0.4	6.35	2.38	2.8
		TPMT110304-PS ●					0.4	6.35	3.18	3.4
		TPMT130304-PS ●					0.4	7.94	3.18	3.4
		TPMT130308-PS ●					0.8	7.94	3.18	3.4
		TPMT16T304-PS ●					0.4	9.525	3.97	4.4
TPMT16T308-PS ●					0.8	9.525	3.97	4.4		
Taglio medio		<b>PM</b> TPMT090204-PM ●					0.4	5.56	2.38	2.5
		TPMT090208-PM ●					0.8	5.56	2.38	2.5
		TPMT110204-PM ●					0.4	6.35	2.38	2.8
		TPMT110304-PM ●					0.4	6.35	3.18	3.4
		TPMT130304-PM ●					0.4	7.94	3.18	3.4
		TPMT130308-PM ●					0.8	7.94	3.18	3.4
		TPMT16T304-PM ●					0.4	9.525	3.97	4.4
		TPMT16T308-PM ●					0.8	9.525	3.97	4.4

● : Novità



ESEMPI DI LAVORAZIONE

Pezzo		Componente di un giunto	Componente di una valvola a sfera	
Inserto		CNMG120404-SM	CNMG120408-SM	
Grado		AH6225	AH6225	
Materiale da lavorare		X5CrNi18-9 / SUS304	X5CrNi18-9 / SUS304	
		 <b>M</b>	 <b>M</b>	
Parametri di taglio	Velocità di taglio: Vc (m/min)	80	150	
	Avanzamento : f (mm/giro)	0.1	0.2	
	Prof. di taglio : ap (mm)	1	1.5	
	Operazione	Tornitura esterna	Tornitura esterna	
	Refrigerante	Sì	Sì	
Risultati	 <p><b>Durata doppia!</b></p> <p>AH6225 ha raddoppiato la vita inserto e ridotto le rotture improvvise, aumentando la produttività del cliente.</p>		 <p><b>Vita inserto costante</b></p> <p>Oltre alla durata richiesta di 20 pezzi a tagliente, l'inserto in AH6225 ha garantito affidabilità operativa eliminando le rotture improvvise.</p>	
	 <b>M</b>		 <b>M</b>	
Pezzo		Componente di un manicotto	Componente di macchina	
Inserto		TNMG160408-SM	VNMG160404-SF	
Grado		AH6225	AH6225	
Materiale da lavorare		Acciaio inossidabile super duplex	SUS440 (Acciaio inossidabile martensitico)	
		 <b>M</b>	 <b>M</b>	
Parametri di taglio	Velocità di taglio: Vc (m/min)	150	100	
	Avanzamento : f (mm/giro)	0.25	0.1	
	Prof. di taglio : ap (mm)	1	0.5	
	Operazione	Tornitura esterna	Tornitura esterna	
	Refrigerante	Sì	Sì	
Risultati	 <p><b>Durata 1.7 volte!</b></p> <p>AH6225 si è usurato molto meno, la durata è stata di 100 pz a tagliente, abbondantemente sopra i 60 pz minimi richiesti.</p>		 <p><b>Durata doppia!</b></p> <p>Con l'inserto in AH6225 la durata è aumentata notevolmente.</p>	

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