

Punte a cuspidi intercambiabile

DRILL^{ORCE}**MEISTER**

Tungaloy Report No. 509S3-I

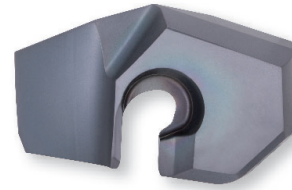
Espansione gamma **con le nuove
cuspidi SMP in grado AH9130**





Grado

Il rivestimento più innovativo per le operazioni di foratura

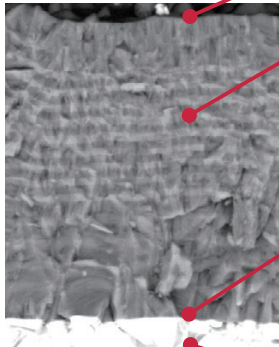


SMP

Cuspide per impieghi generali

Novità

AH9130



Resistenza al tagliante di riporto

Strato di rivestimento resistente all'incollamento.

Resistenza all'usura, all'ossidazione e alla frattura

- 2 strati alternati resistenti all'usura e all'ossidazione.
- La disposizione alternata previene la progressione da scheggiatura a frattura.

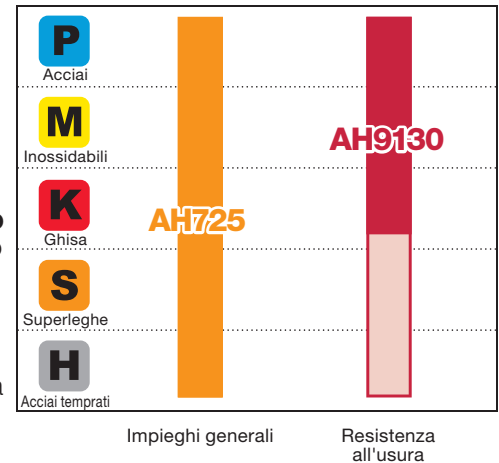
Forte adesione rivestimento-substrato

L'adesione tra strato di rivestimento e substrato determina un'elevata resistenza al fenomeno dello sfogliamento.

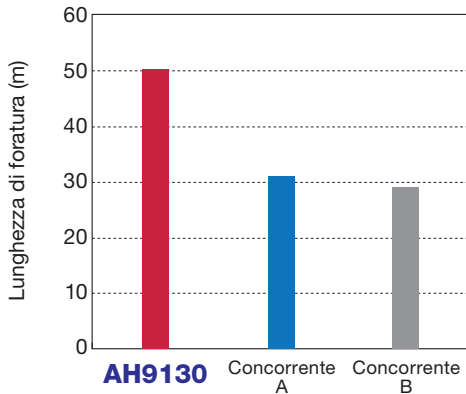
Substrato

Substrato in metallo duro resistente alla frattura e all'usura.

■ Campo di applicazione



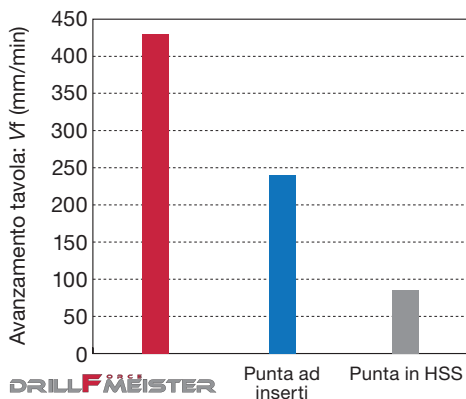
■ Rendimento



Punta : $\varnothing 26$ mm
 Materiale da lavorare : S55C / C55
 Velocità di taglio : $V_c = 100$ m/min
 Avanzamento : $f = 0.35$ mm/giro

La migliore resistenza all'usura del grado AH9130 e il bloccaggio cuspide affidabile aumentano sensibilmente la durata.

Produttività elevata

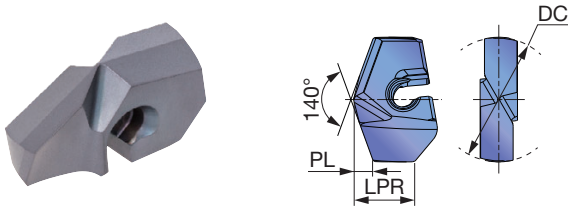


Punta : $\varnothing 33$ mm, L/D = 5
 Materiale da lavorare : S55C / C55

	Velocità di taglio V_c (m/min)	Avanzamento f (mm/giro)	Avanz. tavola V_f (mm/min)
DRILLFORCE MEISTER	100	0.4	430
Punta ad inserti	150	0.15	240
Punta in HSS	20	0.4	85

Bloccaggio cuspide sicuro e corpo rigido forniscono un significativo aumento in produttività.

SMP Impieghi generali



Diametro punta	Tolleranza diametro cuspidi
ø20 - ø29.9	+0.014 / -0.015
ø30 - ø41	+0.014 / -0.02

P Acciai	★	★	
M Acciai inossidabili	★	★	
K Ghisa	★	★	
N Leghe non ferrose	☆	☆	
S Super leghe	☆	★	
H Materiali duri	☆	★	

★ : Prima scelta
☆ : In alternativa

P Acciai	★	★	
M Acciai inossidabili	★	★	
K Ghisa	★	★	
N Leghe non ferrose	☆	☆	
S Super leghe	☆	★	
H Materiali duri	☆	★	

★ : Prima scelta
☆ : In alternativa

Denominazione	DC	LPR	Rivestiti		PL	Dim. sede cuspidi	Punta
			AH9130	AH725			
SMP200	20	9.65	●	●	3.11	20	TIS200F25-*
SMP205	20.5	9.44	●	●	3.2	20	TIS200F25-*
SMP210	21	9.23	●	●	3.29	21	TIS210F25-*
SMP215	21.5	9.02	●	●	3.38	21	TIS210F25-*
SMP220	22	10.54	●	●	3.42	22	TIS220F25-*
SMP222	22.2	10.46	●	●	3.46	22	TIS220F25-*
SMP223	22.3	10.41	●	●	3.47	22	TIS220F25-*
SMP225	22.5	10.33	●	●	3.51	22	TIS220F25-*
SMP230	23	10.12	●	●	3.6	23	TIS230F25-*
SMP235	23.5	9.91	●	●	3.69	23	TIS230F25-*
SMP238	23.8	9.78	●	●	3.75	23	TIS230F25-*
SMP240	24	10.76	●	●	3.73	24	TIS240F32-*
SMP245	24.5	10.55	●	●	3.82	24	TIS240F32-*
SMP247	24.7	10.47	●	●	3.86	24	TIS240F32-*
SMP250	25	10.34	●	●	3.91	25	TIS250F32-*
SMP255	25.5	10.13	●	●	4	25	TIS250F32-*
SMP260	26	11.55	●	●	4.04	26	TIS260F32-*
SMP261	26.1	11.51	●	●	4.06	26	TIS260F32-*
SMP262	26.2	11.47	●	●	4.08	26	TIS260F32-*
SMP263	26.3	11.42	●	●	4.09	26	TIS260F32-*
SMP264	26.4	11.38	●	●	4.11	26	TIS260F32-*
SMP265	26.5	11.34	●	●	4.13	26	TIS260F32-*
SMP266	26.6	11.3	●	●	4.15	26	TIS260F32-*
SMP267	26.7	11.26	●	●	4.17	26	TIS260F32-*
SMP270	27	11.13	●	●	4.22	27	TIS270F32-*
SMP271	27.1	11.09	●	●	4.24	27	TIS270F32-*
SMP272	27.2	11.05	●	●	4.26	27	TIS270F32-*
SMP273	27.3	11	●	●	4.28	27	TIS270F32-*
SMP275	27.5	10.92	●	●	4.31	27	TIS270F32-*
SMP276	27.6	10.88	●	●	4.33	27	TIS270F32-*
SMP280	28	11.74	●	●	4.35	28	TIS280F32-*
SMP281	28.1	11.7	●	●	4.37	28	TIS280F32-*
SMP283	28.3	11.61	★	●	4.4	28	TIS280F32-*
SMP285	28.5	11.53	●	●	4.44	28	TIS280F32-*
SMP286	28.6	11.49	●	●	4.46	28	TIS280F32-*
SMP290	29	11.32	●	●	4.53	29	TIS290F32-*
SMP291	29.1	11.28	●	●	4.55	29	TIS290F32-*
SMP293	29.3	11.19	●	●	4.59	29	TIS290F32-*
SMP295	29.5	11.11	●	●	4.62	29	TIS290F32-*
SMP296	29.6	11.07	●	●	4.64	29	TIS290F32-*
SMP297	29.7	11.03	●	●	4.66	29	TIS290F32-*
SMP298	29.8	10.98	●	●	4.68	29	TIS290F32-*
SMP299	29.9	10.94	●	●	4.7	29	TIS290F32-*
SMP300	30	14.14	●	●	4.67	30	TIS300F32-*
SMP301	30.1	14.1	●	●	4.69	30	TIS300F32-*

Denominazione	DC	LPR	Rivestiti		PL	Dim. sede cuspidi	Punta
			AH9130	AH725			
SMP302	30.2	14.06	●	●	4.71	30	TIS300F32-*
SMP303	30.3	14.01	●	●	4.72	30	TIS300F32-*
SMP304	30.4	13.97	★	●	4.74	30	TIS300F32-*
SMP305	30.5	13.93	●	●	4.76	30	TIS300F32-*
SMP307	30.7	13.85	★	●	4.8	30	TIS300F32-*
SMP308	30.8	13.8	●	●	4.82	30	TIS300F32-*
SMP310	31	13.72	●	●	4.85	31	TIS310F32-*
SMP311	31.1	13.68	●	●	4.87	31	TIS310F32-*
SMP313	31.3	13.59	★	●	4.91	31	TIS310F32-*
SMP315	31.5	13.51	●	●	4.94	31	TIS310F32-*
SMP318	31.8	13.38	●	●	5	31	TIS310F32-*
SMP320	32	14.53	●	●	4.98	32	TIS320F40-*
SMP321	32.1	14.49	●	●	5	32	TIS320F40-*
SMP322	32.2	14.45	●	●	5.02	32	TIS320F40-*
SMP325	32.5	14.32	●	●	5.07	32	TIS320F40-*
SMP328	32.8	14.19	●	●	5.13	32	TIS320F40-*
SMP330	33	14.11	●	●	5.16	33	TIS330F40-*
SMP331	33.1	14.07	●	●	5.18	33	TIS330F40-*
SMP333	33.3	13.98	●	●	5.22	33	TIS330F40-*
SMP335	33.5	13.9	●	●	5.25	33	TIS330F40-*
SMP339	33.9	13.73	★	●	5.33	33	TIS330F40-*
SMP340	34	13.69	●	●	5.34	34	TIS340F40-*
SMP341	34.1	13.65	●	●	5.36	34	TIS340F40-*
SMP343	34.3	13.56	★	●	5.4	34	TIS340F40-*
SMP345	34.5	13.48	●	●	5.44	34	TIS340F40-*
SMP349	34.9	13.31	●	●	5.51	34	TIS340F40-*
SMP350	35	16.56	●	●	5.44	35	TIS350F40-*
SMP351	35.1	16.52	●	●	5.46	35	TIS350F40-*
SMP352	35.2	16.48	●	●	5.48	35	TIS350F40-*
SMP355	35.5	16.35	●	●	5.53	35	TIS350F40-*
SMP357	35.7	16.27	●	●	5.57	35	TIS350F40-*
SMP360	36	16.14	●	●	5.62	36	TIS360F40-*
SMP361	36.1	16.1	●	●	5.64	36	TIS360F40-*
SMP362	36.2	16.06	●	●	5.66	36	TIS360F40-*
SMP365	36.5	15.93	●	●	5.71	36	TIS360F40-*
SMP366	36.6	15.89	●	●	5.73	36	TIS360F40-*
SMP370	37	15.72	●	●	5.8	37	TIS370F40-*
SMP371	37.1	15.68	●	●	5.82	37	TIS370F40-*
SMP373	37.3	15.59	●	●	5.86	37	TIS370F40-*
SMP374	37.4	15.55	●	●	5.88	37	TIS370F40-*
SMP375	37.5	15.51	●	●	5.9	37	TIS370F40-*
SMP380	38	17	●	●	5.91	38	TIS380F40-*

● : Novità
★ : da ottobre 2022
● : Standard stock
Confezione = 1 pz

P	Acciai	★	★
M	Acciai inossidabili	★	★
K	Ghisa	★	★
N	Leghe non-ferrose	☆	☆
S	Super leghe	☆	★
H	Materiali duri	☆	★

★ : Prima scelta
☆ : In alternativa

Denominazione	DC	LPR	Rivestiti		PL	Dim. sede cuspidi	Punta
			AH9130	AH725			
SMP381	38.1	16.96		●	5.93	38	TIS380F40-*
SMP383	38.3	16.87	★		5.96	38	TIS380F40-*
SMP385	38.5	16.79		●	6	38	TIS380F40-*
SMP388	38.8	16.66		●	6.06	38	TIS380F40-*
SMP390	39	16.58		●	6.09	39	TIS390F40-*
SMP391	39.1	16.54	●	●	6.11	39	TIS390F40-*
SMP395	39.5	16.37		●	6.18	39	TIS390F40-*
SMP397	39.7	16.29		●	6.22	39	TIS390F40-*
SMP398	39.8	16.24		●	6.24	39	TIS390F40-*
SMP400	40	16.16		●	6.27	40	TIS400F40-*

P	Acciai	★	★
M	Acciai inossidabili	★	★
K	Ghisa	★	★
N	Leghe non-ferrose	☆	☆
S	Super leghe	☆	★
H	Materiali duri	☆	★

★ : Prima scelta
☆ : In alternativa

Denominazione	DC	LPR	Rivestiti		PL	Dim. sede cuspidi	Punta
			AH9130	AH725			
SMP401	40.1	16.12		●	6.29	40	TIS400F40-*
SMP402	40.2	16.08	★		6.31	40	TIS400F40-*
SMP403	40.3	16.03	★		6.33	40	TIS400F40-*
SMP405	40.5	15.95		●	6.37	40	TIS400F40-*
SMP408	40.8	15.82	★		6.42	40	TIS400F40-*
SMP410	41	15.74		●	6.46	40	TIS400F40-*

● : Novità
★ : da ottobre 2022
● : Standard stock
Confezione = 1 pz

Articoli collegati



PARAMETRI DI TAGLIO STANDARD

ISO	Materiale da lavorare	Velocità di taglio Vc (m/min)	Avanzamento: f (mm/giro)		
			ø20 - ø29.9	ø30 - ø35.9	ø36 - ø41
P	Acciai a basso tenore di carbonio (C15, C20, ecc.)	80 - 140	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
	Acciai al carbonio e acciai legati (S55C / C55, SCM440 / 42CrMo4, ecc.)	80 - 130	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
	Acciai pre-tempra (NAK80, PX5, ecc.)	50 - 100	0.2 - 0.5	0.2 - 0.5	0.2 - 0.55
M	Acciai inossidabili (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, ecc.)	40 - 80	0.15 - 0.3	0.2 - 0.3	0.2 - 0.35
K	Ghisa grigia (FC250 / 250, FC300 / 300, ecc.)	80 - 180	0.25 - 0.55	0.25 - 0.55	0.3 - 0.6
	Ghisa sferoidale (400-15, 600-3, ecc.)	80 - 140	0.25 - 0.55	0.25 - 0.55	0.3 - 0.6
N	Materiali non ferrosi	100 - 200	0.4 - 0.6	0.4 - 0.6	0.5 - 0.7
S	Leghe resistenti al calore (Inconel718, ecc.)	20 - 50	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25
	Leghe di titanio (Ti-6Al-4V, ecc.)	20 - 50	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25
H	Materiali temprati	20 - 60	0.1 - 0.2	0.1 - 0.2	0.1 - 0.25



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