

“UTENSILI PER SCANALATURA E TAGLIO” CON NUOVA GAMMA DI INSERTI

“TOOLS FOR GROOVING AND PARTING” WITH NEW INSERTS RANGE

**GMGR 25..
.X52**

F4530

P M K



**GMGN 25..
.X52**

F4530

P M K



**GMGL 25..
.X52**

F4530

P M K



NEW



SAU
QUALITY TOOLS ENGINEERING

Ø16 - Ø20



In figura utensile destro - Right-hand shown



 VELOCITÀ DI TAGLIO V_c
 V_c . CUTTING SPEED
 V_c . SCHNITTGESCHWINDIGKEIT
 V_c . VITESSE DE COUPE



PAG. 13

SCELTA VELOCE - QUICK PICK

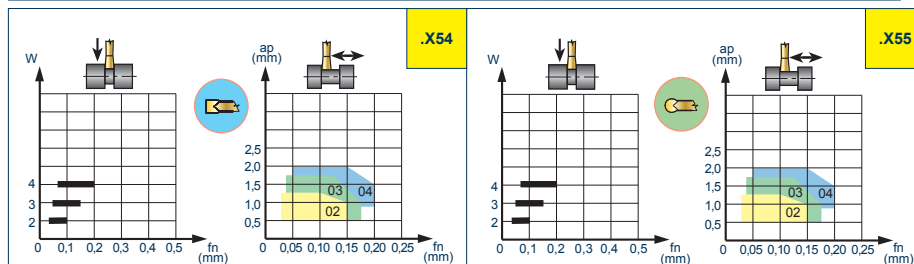
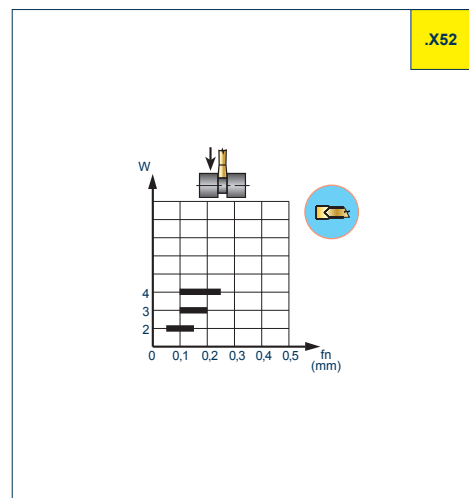


COD.	Prez. List. Price List €	P		M		K		N		S		H		HT	HW	HC						
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
GSGN 14.5-0.2-2 .X52	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●				F4530	T5735	F4645			
GSGN 14.5-0.2-3 .X52	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5-0.4-4 .X52	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5-0.2-2 .X54	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5-0.2-3 .X54	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5-0.3-4 .X54	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5R1.0-2 .X55	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5R1.5-3 .X55	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5R2.0-4 .X55	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min			
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	140	150	130	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	130	140	120	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	100	115	90	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	150	160	90	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	100	120	100	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	160	140		
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	140	130		
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	140	115		
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130				
	RAME E SUE LEGHE - COPPER	26-28	90-110				
	NON METALLICI - PLASTICS	29-30	/				
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320				
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾				
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾				



= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH
ap = mm PROFONDITÀ DI TAGLIO - CUTTING DEPTH

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
● APPLICAZIONE CONSIGLIATA - RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

TRCR/L

Ø 20x20 - 32x32

In figura utensile destro - Right-hand shown

TRIR/L

Ø25 - Ø32

In figura utensile destro - Right-hand shown

GM.. 25..

GS.N 25..

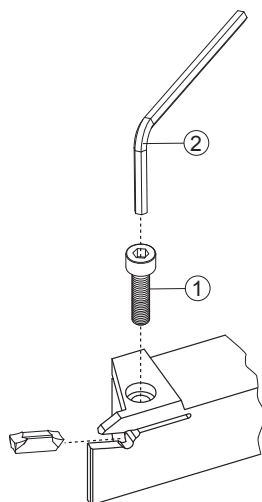
NEW **NEW** **NEW**

..L.. .X52 ..N.. .X52 ..R.. .X52 ..X52 ..X54 ..X55

* ART. TRIR/L... 40.. DISPONIBILI DA DICEMBRE 2019
* ART. TRIR/L... 40.. AVAILABLE FROM DECEMBER 2019
* ART. TRIR/L... 40.. AB DEZEMBER 2109 LIEFERBAR
* ART. TRIR/L... 40.. DISPONIBLE À PARTIR DE DÉCEMBRE 2019

ART.		Prezzo Listino Price List	(mm)									①	②
		€	W	h=h1	b	f	Tmax	l1	l2	Nm			
TRCR/L	2020 25-3	115,00	3	20	20	20,0	22	125	38,5	5,0+6,0	GS..25..-3	VTZ 0516	5425
TRCR/L	2020 25-4	115,00	4	20	20	20,0	22	125	40,5	5,0+6,0	GS..25..-4	VTZ 0516	5425
TRCR/L	2525 25-3	125,30	3	25	25	25,3	22	150	38,5	5,0+6,0	GS..25..-3	VTZ 0516	5425
TRCR/L	2525 25-4	125,30	4	25	25	25,5	22	150	38,5	5,0+6,0	GS..25..-4	VTZ 0516	5425
TRCR/L	2525 25-5	125,30	5	25	25	25,5	22	150	38,5	5,0+6,0	GS..25..-5	VTZ 0516	5425
TRCR/L	2525 25-6	125,30	6	25	25	25,6	22	150	38,5	5,0+6,0	GS..25..-6	VTZ 0516	5425
TRCR/L	3232 25-4	155,00	4	32	32	32,0	22	170	40,5	5,0+6,0	GS..25..-4	VTZ 0516	5425
TRCR/L	3232 25-5	155,00	5	32	32	32,0	22	170	40,5	5,0+6,0	GS..25..-5	VTZ 0516	5425
TRCR/L	3232 25-6	155,00	6	32	32	32,0	22	170	40,5	5,0+6,0	GS..25..-6	VTZ 0516	5425

ART.		Prezzo Listino Price List	(mm)												
		€	W	Ød	ØDmin	f	H	Tmax	I1	I2	Nm				
TRIR/L	25 25-3	227,80	3	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-3	SM 522	5420	
TRIR/L	25 25-4	227,80	4	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-4	SM 522	5420	
TRIR/L	25 25-5	227,80	5	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-5	SM 522	5420	
TRIR/L	25 25-6	227,80	6	25	32	22,5	24,0	10,0	200,5	39,0	5,0+6,0	GS..25..-6	SM 522	5420	
TRIR/L	32 25-3	255,00	3	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-3	SM 522	5420	
TRIR/L	32 25-4	255,00	4	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-4	SM 522	5420	
TRIR/L	32 25-5	255,00	5	32	42	27,5	31,0	11,0	250,0	51,5	5,0+6,0	GS..25..-5	SM 522	5420	
TRIR/L	32 25-6	255,00	6	32	47	34,4	31,0	17,5	250,0	52,0	5,0+6,0	GS..25..-6	SM 522	5420	
*TRIR/L	40 25-4	New 350,00	4	40	53	32,5	38,5	12,0	300,0	63,0	5,0+6,0	GS..25..-4	SM 522	5420	
*TRIR/L	40 25-5	New 350,00	5	40	53	32,5	38,5	12,0	300,0	64,0	5,0+6,0	GS..25..-5	SM 522	5420	
*TRIR/L	40 25-6	New 350,00	6	40	57	34,4	38,5	17,5	300,0	65,0	5,0+6,0	GS..25..-6	SM 522	5420	



DISPONIBILITÀ INSERTI
INSERTS STOCK
WENDEPLATTEN-LIEFERBEREITSCHAFT
DISPONIBILITÉ PLAQUETTES

PANORAMICA E IMPIEGO QUALITÀ INSERTI
OVERVIEW AND INSERT GRADE APPLICATION
ÜBERSICHT UND PLATTENSORTENANWENDUNG
PANORAMIQUE ET EMPLOI QUALITÉ PLAQUETTES

VELOCITÀ DI TAGLIO Vc
Vc. CUTTING SPEED
Vc. SCHNITTGESCHWINDIGKEIT
Vc. VITESSE DE COUPE



PAG. 12



PAG. 12-13



PAG. 13

SCELTA VELOCE - QUICK PICK

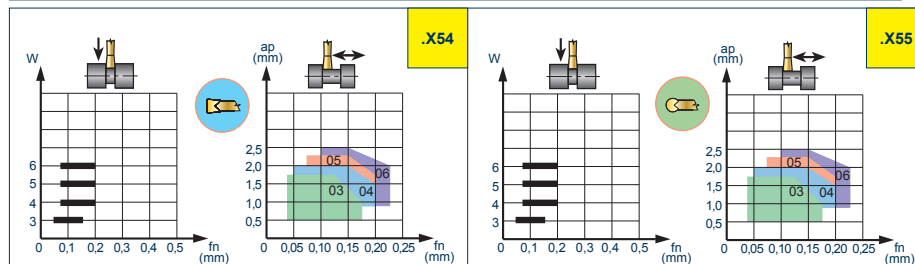
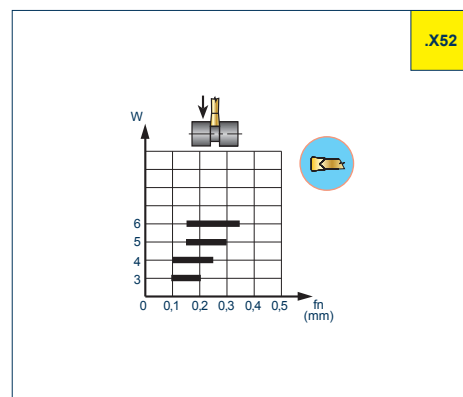


SCELTA VELOCE - QUICK PICK														Tenacità + Toughness -				HT	HW	HC																	
COD.		Prez List. Price List €	P			M			K			N			S			H			CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS				GM..	N	L	R							
			F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R				W	r	l	T	a°	b°								
GMGL	25-0.2-3 .X52	12,00	○	○	○	○	○	○	○	○	○	○	○	○																							
GMGN	25-0.2-3 .X52	12,00	○	●	○	○	○	○	○	○	○	○	○	○																							
GMGR	25-0.2-3 .X52	12,00	○	○	○	○	○	○	○	○	○	○	○	○																							
GSGN	25-0.2-3 .X52	16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
GSGN	25-0.4-4 .X52	17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
GSGN	25-0.4-5 .X52	19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
GSGN	25-0.4-6 .X52	20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25-0.2-3 .X54	16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25-0.3-4 .X54	17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25-0.3-5 .X54	19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25-0.3-6 .X54	20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25R1.5-3 .X55	16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
		16,80	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25R2.0-4 .X55	17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
		17,60	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25R2.5-5 .X55	19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
		19,20	○	●	○	○	○	○	○	○	○	○	○	○																							
GSTN	25R3.0-6 .X55	20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
		20,70	○	●	○	○	○	○	○	○	○	○	○	○																							
CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY																																					
SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY																																					

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS			VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min					
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL		1-5	125-300	F4530	T5735	F4645			
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL		6-9	180-350	140	150	130			
	ACCIAIO ALTO LEGATO - ALLOY STEEL		10-11	200-325	100	115	90			
M	INOX MARTENS. - STAINLESS STEEL MART		12-13	200-240	150	160	90			
	INOX AUST. DUPLEX - STAINLESS STEEL AUST		14.1-14.2	180-230	100	120	100			
	GHISA GRIGIA - GREY CAST IRON		15-16	180-260	160	140				
K	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE		17-18	160-250	140	130				
	GHISA MALLEABILE - MALLEABLE CAST IRON		19-20	130-230	140	115				
	ALLUMINIO E SUE LEGHE - ALUMINIUM		21-25	60-130						
N	RAME E SUE LEGHE - COPPER		26-28	90-110						
	NON METALLICI - PLASTICS		29-30	/						
	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY		31-35	200-320						
S	TITANIO E SUE LEGHE - TITANIUM		36-37	400-1050 ¹⁾						
	ACCIAIO TEMPRATO - HARDENED STEEL		38-41	45-60 ²⁾						



= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

ap = mm PROFONDITÀ DI TAGLIO - CUTTING DEPTH

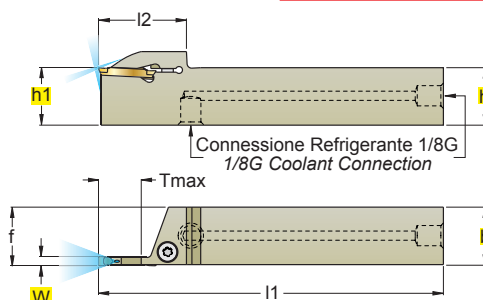
$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOLHENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
○○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Ø 20x20 - 25x25



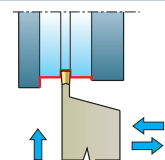
In figura utensile destro
Right-hand shown

 IL VANTAGGIO DI PERFORMANCE S'OTTIENE SOLO CON L'ALTA PRESSIONE DEL REFRIGERANTE 20+80 bar, LE POMPE UTILIZZATE DEVONO AVERE UN FILTRAGGIO DEL LIQUIDO DI RITORNO.

 THE PERFORMANCE ADVANTAGE CAN BE ACHIEVED ONLY WITH HIGH COOLANT PRESSURE (20+80 BAR). THE PUMPS USED MUST BE EQUIPPED WITH RETURN-FLOW FILTRATION

 DER LEISTUNGSVORTEIL IST NUR BE HOHEM KÜHLMITTELDRUCK (20+80 BAR) ERZIELBAR. DIE EINGESETZTEN PUMPEN MÜSSEN MIT EINER RÜCKLAUFFILTERUNG AUSGESTATTET SEIN

 L'AVANTAGE DE PERFORMANCE NE S'OBTIENT QUE PAR LA HAUTE PRESSION DU REFRIGERANT 20+80 bars, LES POMPES UTILISEES DOIVENT ETRE DOTEES D'UN FILTRE DU LIQUIDE DE RETOUR



GS.N
14,5..



.X52

Prezzo
Listino
Price List

(mm)



Nm



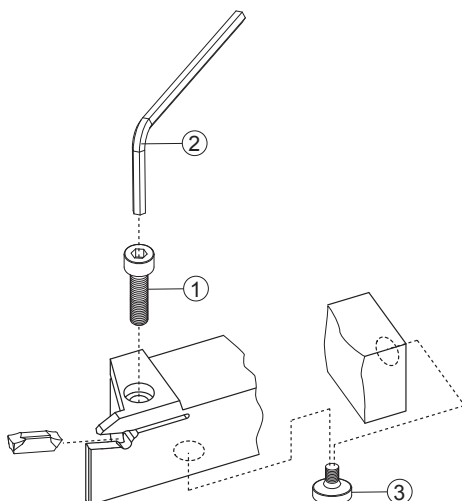
1

2

3

TRWR/L	2020 14-2	138,00	2	20	20	20	12,5	125	35,5	5,0+6,0	GS..14.5..2	VTZ 0516	5425	R 1/8
TRWR/L	2020 14-3	138,00	3	20	20	20	12,5	125	35,5	5,0+6,0	GS..14.5..3	VTZ 0516	5425	R 1/8
TRWR/L	2020 14-4	138,00	4	20	20	20	12,5	125	35,5	5,0+6,0	GS..14.5..4	VTZ 0516	5425	R 1/8
TRWR/L	2525 14-2	144,90	2	25	25	25,3	12,5	150	36,0	5,0+6,0	GS..14.5..2	VTZ 0516	5425	R 1/8
TRWR/L	2525 14-3	144,90	3	25	25	25,5	12,5	150	36,0	5,0+6,0	GS..14.5..3	VTZ 0516	5425	R 1/8
TRWR/L	2525 14-4	144,90	4	25	25	25,5	12,5	150	36,0	5,0+6,0	GS..14.5..4	VTZ 0516	5425	R 1/8

The image displays a collection of hydraulic components arranged in a grid. The first three items are straight fitted hoses of different lengths (150mm, 225mm, and 300mm). The fourth item is a cooling lubricant nozzle. The fifth item is a straight fitting, the sixth is an adapter, the seventh is a 90° fitting, and the eighth is a B-SEAL M10.



 DISPONIBILITÀ INSERTI
 INSERTS STOCK
 WENDEPLATTEN-LIEFERBEREITSCHAFT
 DISPONIBILITÉ PLAQUETTES

 PANORAMICA E IMPIEGO QUALITÀ INSERTI
 OVERVIEW AND INSERT GRADE APPLICATION
 ÜBERSICHT UND PLATTENSORTENANWENDUNG
 PANORAMIQUE ET EMPLOI QUALITÉ PLAQUETTES

 VELOCITÀ DI TAGLIO V_c
 V_c. CUTTING SPEED
 V_c. SCHNITTGESCHWINDIGKEIT
 V_c. VITESSE DE COUPE



PAG. 12



PAG. 12-13



PAG. 13

SCELTA VELOCE - QUICK PICK

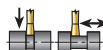
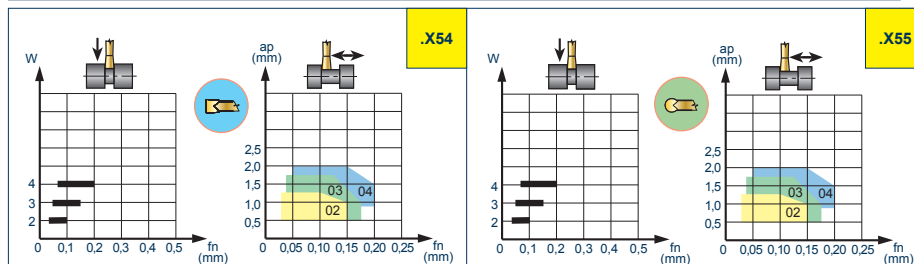
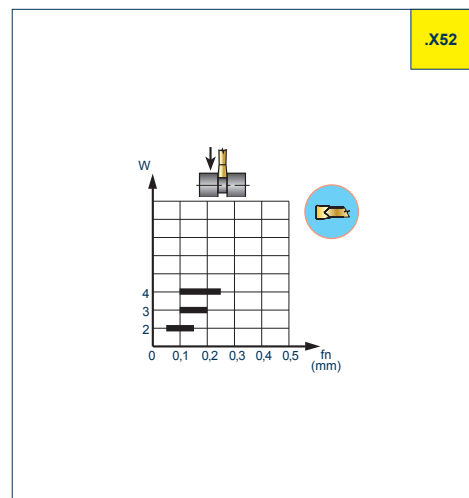


COD.	Prez. List. Price List €	P		M		K		N		S		H		HT	HW	HC						
		F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
GSGN 14.5-0.2-2 .X52	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●				F4530	T5735	F4645			
GSGN 14.5-0.2-3 .X52	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSGN 14.5-0.4-4 .X52	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5-0.2-2 .X54	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5-0.2-3 .X54	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5-0.3-4 .X54	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5R1.0-2 .X55	15,50 15,50 15,50	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5R1.5-3 .X55	16,00 16,00 16,00	●	●	●	●	●	●	●	●	●	●	●	●									
GSTN 14.5R2.0-4 .X55	16,60 16,60 16,60	●	●	●	●	●	●	●	●	●	●	●	●									

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min			
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	140	150	130	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	130	140	120	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	100	115	90	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	150	160	90	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	100	120	100	
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	160	140		
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	140	130		
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	140	115		
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130				
	RAME E SUE LEGHE - COPPER	26-28	90-110				
	NON METALLICI - PLASTICS	29-30	/				
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320				
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾				
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾				



= SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH
ap = mm PROFONDITÀ DI TAGLIO - CUTTING DEPTH

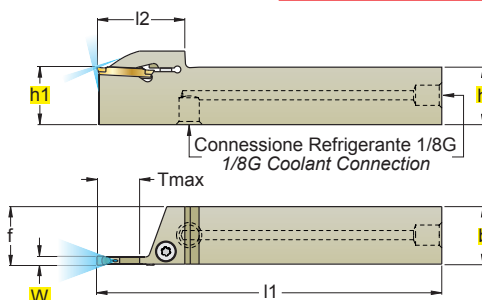
$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
 ● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
 ○ ○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

□ 20x20 - 25x25



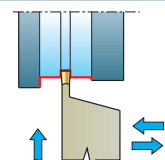
Connessione Refrigerante 1/8G
1/8G Coolant Connection

 IL VANTAGGIO DI PERFORMANCE SI OTTIENE SOLO CON L'ALTA PRESSIONE DEL REFRIGERANTE 20+80 bar, LE POMPE UTILIZZATE DEVONO AVERE UN FILTRAGGIO DEL LIQUIDO DI RITORNO.

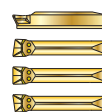
 THE PERFORMANCE ADVANTAGE CAN BE ACHIEVED ONLY WITH HIGH COOLANT PRESSURE (20+80 BAR). THE PUMPS USED MUST BE EQUIPPED WITH RETURN-FLOW FILTRATION

 DER LEISTUNGSVORTEIL IST NUR BE HOHEM KÜHLMITTELDRUCK (20+80 BAR) ERZIELBAR. DIE EINGESETZTEN PUMPEN MÜSSEN MIT EINER RÜCKLAUFFILTERUNG AUSGESTATTET SEIN

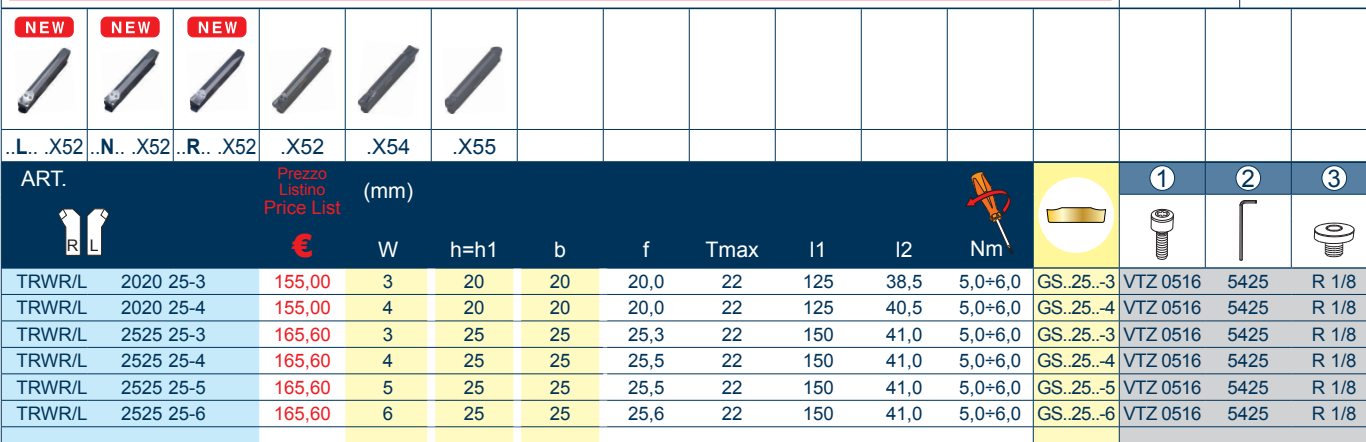
 L'AVANTAGE DE PERFORMANCE NE S'OBTIENT QUE PAR LA HAUTE PRESSION DU REFRIGERANT 20+80 bars, LES POMPES UTILISEES DOIVENT ETRE DOTEES D'UN FILTRE DU LIQUIDE DE RETOUR.



GM..
25..



GS.N
25..



• Tubo dritto raccordato
Fitted hose, straight

150mm

• Tubo dritto raccordato
Fitted hose, straight

225mm

• Tubo dritto raccordato
Fitted hose, straight

300mm

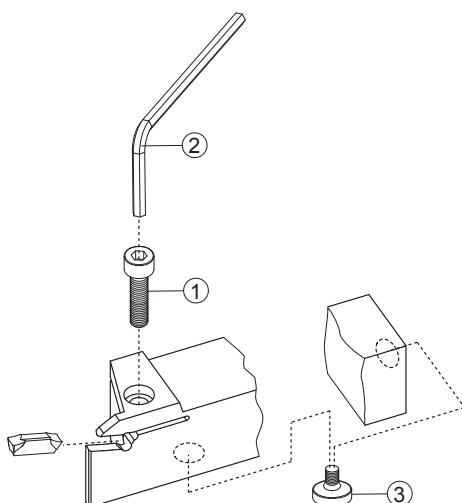
• Ogiva lubrorefrigerante
Cooling lubricant hose cone

• Raccordo dritto
Straight fitting

• Riduzione
Adapter

• Raccordo 90°
90° Fitting

• B-SEAL M10



 DISPONIBILITÀ INSERTI
 INSERTS STOCK
 WENDEPLATTEN-LIEFERBEREITSCHAFT
 DISPONIBILITÉ PLAQUETTES

 PANORAMICA E IMPIEGO QUALITÀ INSERTI
 OVERVIEW AND INSERT GRADE APPLICATION
 ÜBERSICHT UND PLATTENSORTENANWENDUNG
 PANORAMIQUE ET EMPLOI QUALITÉ PLAQUETTES

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



PAG. 12



PAG. 12-13

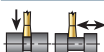
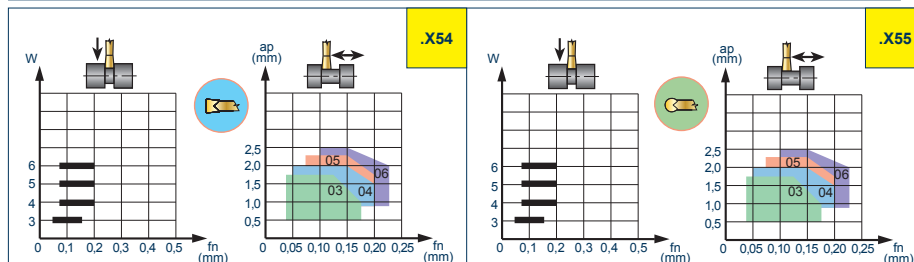
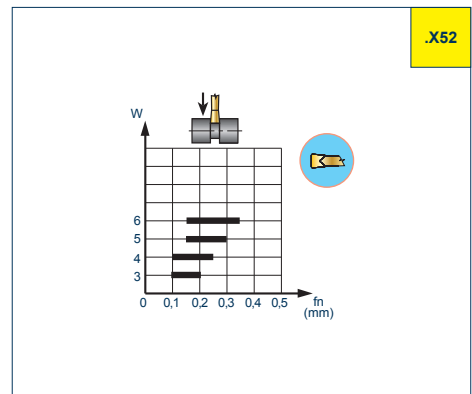


PAG. 13

Tenacità +
Toughness -

[illegible]

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	Vc m/min					
				F4530	T5735	F4645			
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	NON METALLICI - PLASTICS	29-30	/						
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	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ⁽¹⁾						
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ⁽²⁾						



Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min^{-1}) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
f = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
w = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH
ap = mm PROFONDITÀ DI TAGLIO - CUTTING DEPTH

$$n = \frac{V_c \cdot 1000}{\varnothing D \cdot 3.14} = \text{giri/min (min}^{-1}\text{)}$$

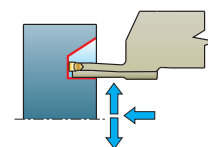
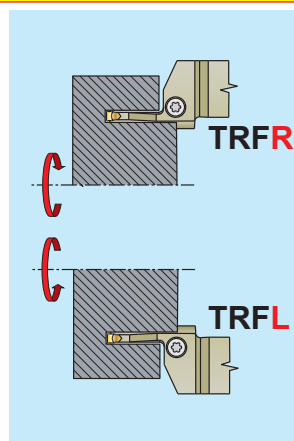
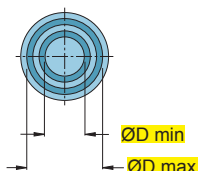
$$V_f = f_n \cdot n = \text{mm/min}$$

- DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
●● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
EMPFOLHENER EINSATZ - APPLICATION CONSEILLÉE

- ☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICATION POSSIBLE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

25x25

 **UTENSILE PER SCANALATURA FRONTALE**
 **TOOLHOLDER FOR FACE GROOVING**
 AXIALEINSTECHWERKZEUG
 **OUTIL POUR GORGES FRONTALES**



Two views of a tapered shaft. The top view shows a tapered shaft with a central hole and a keyway. The bottom view shows the same shaft from a different perspective, highlighting the keyway and the central hole.

													
L...X52	N...X52	R...X52	.X52	.X54	.X55								

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



PAG. 12



PAG. 12-13

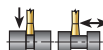
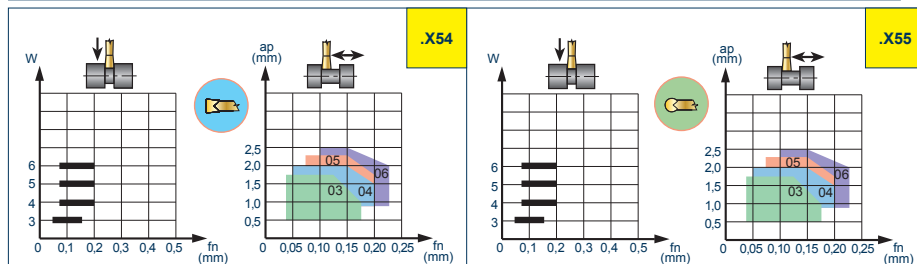
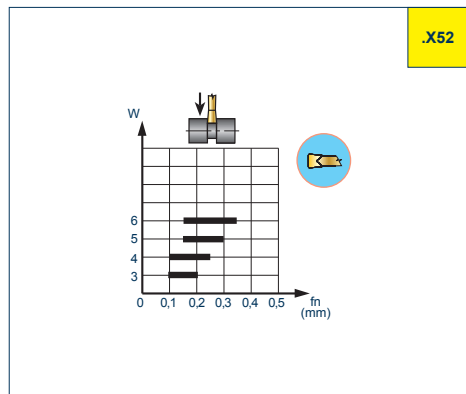


PAG. 13

Tenacità +
Toughness -

SCELTA VELOCE - QUICK PICK										Tenacità + Toughness -				HT	HW	HC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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GSTN 25-0.3-6 .X54		20,70	○	○	○	○	○	○	○	○	○																6,0	0,3	25	5,0	10°	—																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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GSTN 25R1.5-3 .X55		16,80	○	○	○	○	○	○	○	○	○																3,0	1,5	25	2,2	8°	—																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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GSTN 25R2.0-4 .X55		17,60	○	○	○	○	○	○	○	○	○																4,0	2,0	25	3,2	8°	—																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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GSTN 25R2.5-5 .X55		19,20	○	○	○	○	○	○	○	○	○																5,0	2,5	25	4,1	8°	—																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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GSTN 25R3.0-6 .X55		20,70	○	○	○	○	○	○	○	○	○																6,0	3,0	25	5,0	8°	—																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
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MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ¹⁾ HRC ²⁾	Vc m/min					
				F4530	T5735	F4645			
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	140	150	130			
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350	130	140	120			
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325	100	115	90			
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240	150	160	90			
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	100	120	100			
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260	160	140				
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250	140	130				
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230	140	115				
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130						
	RAME E SUE LEGHE - COPPER	26-28	90-110						
	NON METALLICI - PLASTICS	29-30	/						
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320						
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ¹⁾						
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ²⁾						



= SCANALATURA - GROOVING

ap = mm PROFONDITÀ DI TAGLIO - CUTTING DEPTH

$$n = \frac{V_c \cdot 1000}{\varnothing D \cdot 3.14} = \text{giri/min (min}^{-1}\text{)}$$

$$V_f = f_n \cdot n = \text{mm/min}$$

- ☐ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / ☐ NEW
☐ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Disponibilità inserti - Inserts stock - Wendepplatten-Lieferbereitschaft - Disponibilité plaquettes

GM..				GS..				HW				HC														
								NON RIVESTITI CEMENTED CARBIDE GRADES				RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS														
ART.	COD.			W	r	l	T	a°	b°					F4530	T5735	F4645										
 X52 ±0,04 	GMGL 25-0.2-3 .X52			3,0	0,2	25	2,2	10°	6					■												
	NEW																									
 X52 ±0,04 	GMGN 25-0.2-3 .X52			3,0	0,2	25	2,2	10°	—					■												
	NEW																									
 X52 ±0,04 	GMGR 25-0.2-3 .X52			3,0	0,2	25	2,2	10°	6					■												
	NEW																									
 X52 ±0,04 	GSGN 14.5-0.2-2 .X52			2,0	0,2	14,5	1,5	10°	—					■	■	■										
	GSGN 14.5-0.2-3 .X52			3,0	0,2	14,5	2,2	10°	—					■	■	■										
	GSGN 14.5-0.4-4 .X52 New			4,0	0,4	14,5	3,2	10°	—					■	■	■										
 X52 ±0,04 	GSGN 25-0.2-3 .X52			3,0	0,2	25	2,2	11°	—					■	■	■										
	GSGN 25-0.4-4 .X52 New			4,0	0,4	25	3,2	11°	—					■	■	■										
	GSGN 25-0.4-5 .X52 New			5,0	0,4	25	4,1	10°	—					■	■	■										
	GSGN 25-0.4-6 .X52 New			6,0	0,4	25	5,0	10°	—					■	■	■										
 X54 ±0,04 	GSTN 14.5-0.2-2 .X54			2,0	0,2	14,5	1,5	10°	—					■	■	■										
	GSTN 14.5-0.2-3 .X54			3,0	0,2	14,5	2,2	11°	—					■	■	■										
	GSTN 14.5-0.3-4 .X54			4,0	0,3	14,5	3,2	11°	—					■	■	■										
 X54 ±0,04 	GSTN 25-0.2-3 .X54			3,0	0,2	25	2,2	11°	—					■	■	■										
	GSTN 25-0.3-4 .X54			4,0	0,3	25	3,2	11°	—					■	■	■										
	GSTN 25-0.3-5 .X54			5,0	0,3	25	4,1	10°	—					■	■	■										
	GSTN 25-0.3-6 .X54			6,0	0,3	25	5,0	10°	—					■	■	■										
 X55 ±0,04 	GSTN 14.5R1.0-2 .X55			2,0	1,0	14,5	1,5	8°	—					■	■	■										
	GSTN 14.5R1.5-3 .X55			3,0	1,5	14,5	2,2	8°	—					■	■	■										
	GSTN 14.5R2.0-4 .X55			4,0	2,0	14,5	3,2	8°	—					■	■	■										
 X55 ±0,04 	GSTN 25R1.5-3 .X55			3,0	1,5	25	2,2	8°	—					■	■	■										
	GSTN 25R2.0-4 .X55			4,0	2,0	25	3,2	8°	—					■	■	■										
	GSTN 25R2.5-5 .X55			5,0	2,5	25	4,1	8°	—					■	■	■										
	GSTN 25R3.0-6 .X55			6,0	3,0	25	5,0	8°	—					■	■	■										
MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX															F4530	T5735	F4645									
P	ACCIAIO - STEEL - STAHL - ACIER														●	●	●									
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE														●	○	●									
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE														●	●										
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM																									
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉISTANTES À LA CHALEUR																									
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																									

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW
● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW
○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION - MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Panoramica qualità - General view - Qualitätsübersicht - Vue d'ensemble qualité																							
DIN ISO 513	P ACCIAI STEELS STAHL ACIERS						M ACCIAI INOSSIDABILI STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE				K GHISE CAST IRON GRAUGUSS FONTE GRISE					N NON FERROSII NONFERROUS NICHTEISENMA PAS FERREUX				S NON FERROSII NONFERROUS NICHTEISENMA PAS FERREUX			
	01	10	20	30	40	50	10	20	30	40	01	10	20	30	40	10	20	30	40	10	20	30	40
HT																							
HW																							
HC				F4530	T5735	F4645			F4530	T5735	F4645			F4530	T5735								
	TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ																						
	RESISTENZA ALL'USURA - RESISTANCE TO WEAR - VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE																						
	AVANZAMENTO - FEED - VORSCHUB - AVANCE																						
	VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE																						
HT	CERMET						HW					HC											
							METALLO DURO NON RICOPERTO UNCOATED CARBIDE UNBESCHICHTETES HARTMETALL MÉTAL DUR PAS RECOUVERT					METALLO DURO RICOPERTO COATED CARBIDE BESCHICHTETES HARTMETALL MÉTAL DUR RECOUVERT											

Impiego delle qualità - Application of the grade - Einsatz der verschiedenen sorten - Utilisation de les qualités

● APPLICAZIONE CONSIGLIATA
 RECOMMENDED APPLICATION
 EMPFOHLENER EINSATZ
 APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE
 POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG
 APPLICATION POSSIBLE

● APPLICAZIONE CONSIGLIATA
 RECOMMENDED APPLICATION
 EMPFOHLENER EINSATZ
 APPLICATION CONSEILLÉE

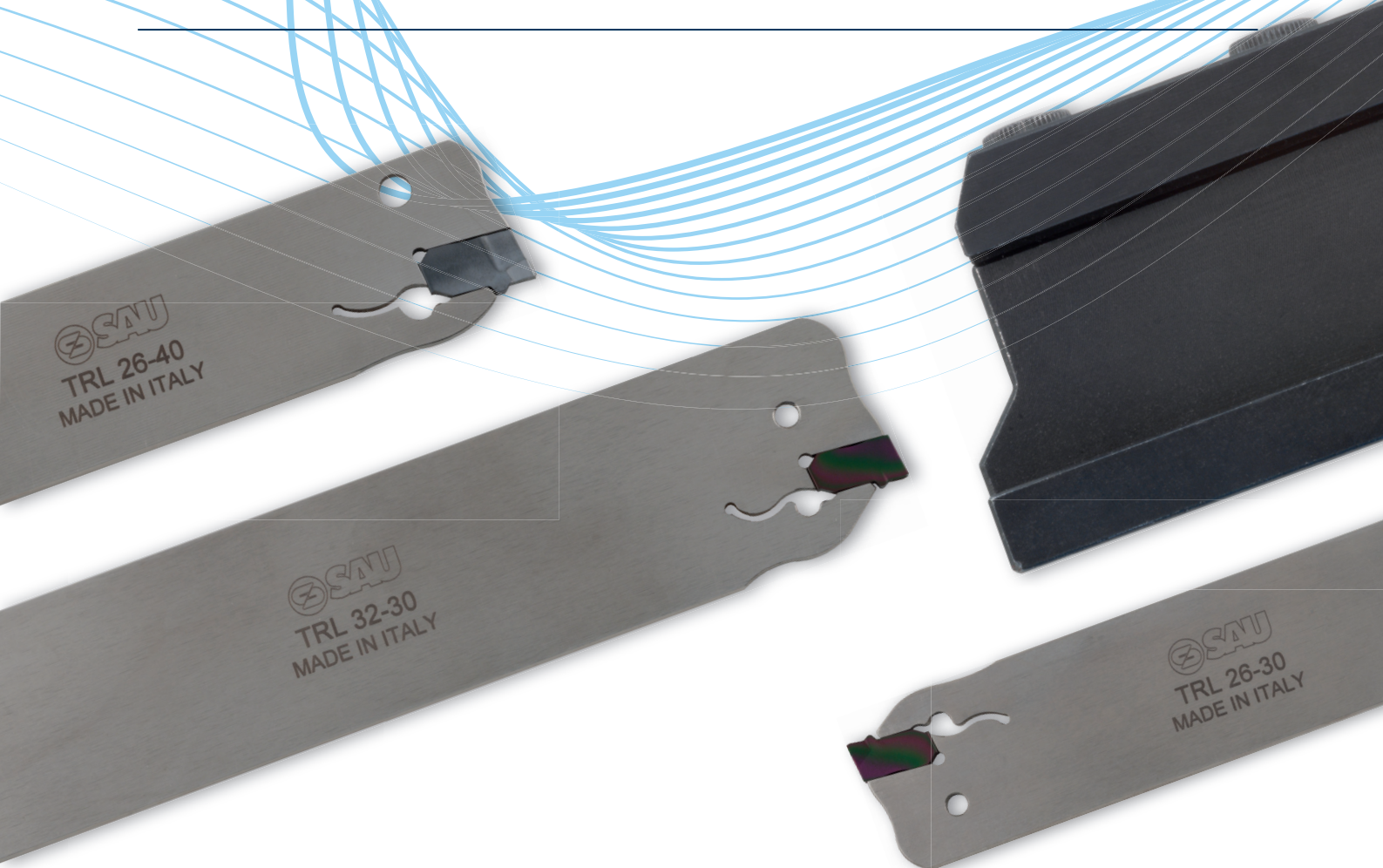
○ APPLICAZIONE POSSIBILE
 POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG
 APPLICATION POSSIBLE

Velocità di taglio delle qualità di fresatura - Cutting speed of the milling grades
Schnittgeschwindigkeit der frässorten - Vitesse decoupe de la qualité de plaquettes de fraisage

MATERIALE MATERIAL MATERIALIEN MATÉRIAUX	VDI 3323 GR.	HB HRC Rm	F4530	T5735	F4645
P ACCIAI STEELS STAHL ACIER	1	125	120-250	110-190	110-190
	2	180	80-180	110-190	80-150
	3	250	60-150	110-190	70-140
	4	220	80-180	110-190	70-140
	5	300	80-180	110-190	70-140
	6	180	80-180	110-180	70-140
	7-8	250-300	60-150	110-180	70-120
	9	350	60-120	110-180	60-120
	10	200	80-160	70-160	60-100
	11	350	50-120	70-160	60-100
	12	200	50-200	120-200	60-100
	13	330	50-200	120-200	60-180
M ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	14.1	180	50-180	100-200	70-150
	14.2	230-260	50-100	60-110	60-110
K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180	100-200	90-180	
	16	260	90-160	90-180	
	17	160	100-180	100-160	
	18	250	80-160	100-160	
	19	130	100-230	80-150	
	20	230	80-160	80-150	
N LEGHE DI ALLUMINIO ALUMINIUM ALLOYS ALUMINIUM-LEGIERUNGEN ALLIAGES D'ALUMINIUM	21	60			
	22	100			
	23	75			
	24	90			
	25	130			
	26	110			
	27	90			
	28	100			
	29	—			
	30	—			
S LEGHE RESISTENTI AL CALORE HEAT RESISTANT ALLOYS WÄRMEBESTÄNDIGE LEGIERUNGEN ALLIAGES RÉISTANTES À LA CHALEUR	31	200			
	32	280			
	33	250			
	34	350			
	35	320			
	36	400 ²⁾			
	37	1050 ²⁾			
H MATERIALI DURI E TEMPRATI HARD AND HARDENED MATERIAL HARTE UND GEHÄRTETE MATERIALIEN MATERIAUX DURS ET TREMPÉS	38.1	45 ¹⁾			
	38.2	55 ¹⁾			
	39.1	60 ¹⁾			
	39.2	>62 ¹⁾			
	40.1	400			
	40.2	>440			
	41.1	55 ¹⁾			
	41.2	57 ¹⁾			

LAME PER SCANALATURA E TAGLIO “TRL..”

GROOVING AND PARTING BLADES “TRL..”



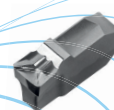
TRLN .G52



.G56



.G57P



F4645

P

M

T5235

P

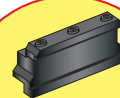
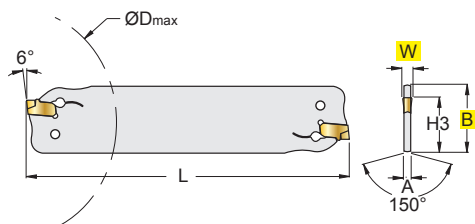
K

T115

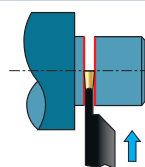
N



26 - 32



Art. SGTBU
Pag. 18



TRLN..



.G52

.G56

.G57P

Prezzo
Listino
Price List

(mm)

 $W \pm 0,1$

B

A

5Dmax

L



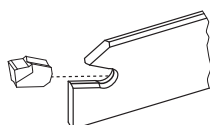
TRL	26-30	102,50	3,0	26	2,4	70	110	21,4	3,0				CH-TRL30-40
TRL	26-40	102,50	4,0	26	3,2	80	110	21,4	4,0				CH-TRL30-40
TRL	32-30	108,70	3,0	32	2,4	100	150	25,0	3,0				CH-TRL30-40
TRL	32-40	108,70	4,0	32	3,2	100	150	25,0	4,0				CH-TRL30-40

CH-TRI 30-40

CH-TRL30-40

CH-TRL30-40

CH-TRL30-40



 DISPONIBILITÀ INSERTI
 INSERTS STOCK
 WENDEPLATTEN-LIEFERBEREITSCHAFT
 DISPONIBILITÉ PLAQUETTES

 PANORAMICA E IMPIEGO QUALITÀ INSERTI
 OVERVIEW AND INSERT GRADE APPLICATION
 ÜBERSICHT UND PLATTENSORTENANWENDUNG
 PANORAMIQUE ET EMPLOI QUALITÉ PLAQUETTES

 VELOCITÀ DI TAGLIO Vc
 Vc. CUTTING SPEED
 Vc. SCHNITTGESCHWINDIGKEIT
 Vc. VITESSE DE COUPE



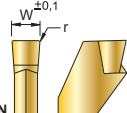
PAG. 18



PAG. 18-19



PAG. 20

SCELTA VELOCE - QUICK PICK																		HT		HW	HC							
COD.	Prez. List. Price List €	P			M			K			N			S			H			CERMET	T115 T116 NEW	F4645	T5235			W	r	a°
	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R										
TRLN 3.00-0.20N .G52	11,40	●	●	●																					3,0*	0,2	0°	
	11,40	○	●	●				○	●	●																		
TRLN 4.00-0.30N .G52	12,40	○	●	●				○	●	●															4,0*	0,3	0°	
	12,40	○	●	●				○	●	●																		
TRLN 3.00-0.30N .G56	11,40	○	●	●				○	●	●															3,0*	0,3	0°	
	11,40	○	●	●				○	●	●																		
TRLN 4.00-0.40N .G56	12,40	○	●	●				○	●	●															4,0*	0,4	0°	
	12,40	○	●	●				○	●	●																		
TRLN 3.00-0.30N .G57P	14,00										●	●	○								●				3,0*	0,3	0°	
	14,00										●	●	○								●							
TRLN 4.00-0.40N .G57P	14,00										●	●	○								●				4,0*	0,4	0°	
	14,80										●	●	○								●							



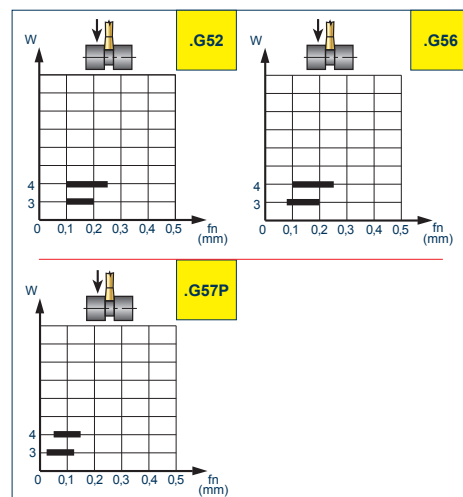
GRADO T115 AD ESAURIMENTO
T115 GRADE AS LONG AS STOCKS LAST
T115 SORTE SOLANGE VORRAT REICHT
DEGRE T115 JUSQU'A L'EPUISEMENT

 GRADO T115 AD ESAURIMENTO
 T115 GRADE AS LONG AS STOCKS LAST
 T115 SORTE SOLANGE VORRAT REICHT
 DEGRE T115 JUSQU'A L'EPUISEMENT

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

MATERIALI - MATERIALS		VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	Vc m/min				
				T115	T116	F4645	T5235	
P	ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300			130	150	
	ACCIAIO POCO LEGATO - LOW ALLOY STEEL	6-9	180-350			120	140	
	ACCIAIO ALTO LEGATO - ALLOY STEEL	10-11	200-325			90	130	
	INOX MARTENS. - STAINLESS STEEL MART	12-13	200-240			90	115	
M	INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230					
K	GHISA GRIGIA - GREY CAST IRON	15-16	180-260				130	
	GHISA SFEROIDALE - SPHEROIDAL GRAPHITE	17-18	160-250				120	
	GHISA MALLEABILE - MALLEABLE CAST IRON	19-20	130-230				130	
N	ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130	600	600			
	RAME E SUE LEGHE - COPPER	26-28	90-110	400	400			
	NON METALLICI - PLASTICS	29-30	/	450	450			
S	LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320					
	TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ⁽¹⁾					
H	ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ⁽²⁾					



 = SCANALATURA - GROOVING

Vc = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED

n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS

fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION

Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED

W = mm LARGHEZZA TAGLIANTE - CUTTING EDGE WIDTH

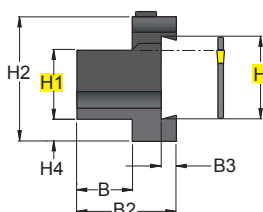
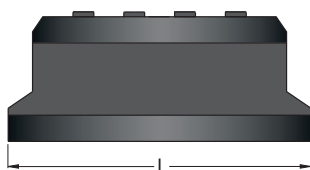
$$n = \frac{Vc \cdot 1000}{\varnothing D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

$$Vf = fn \cdot n = \text{mm/min}$$

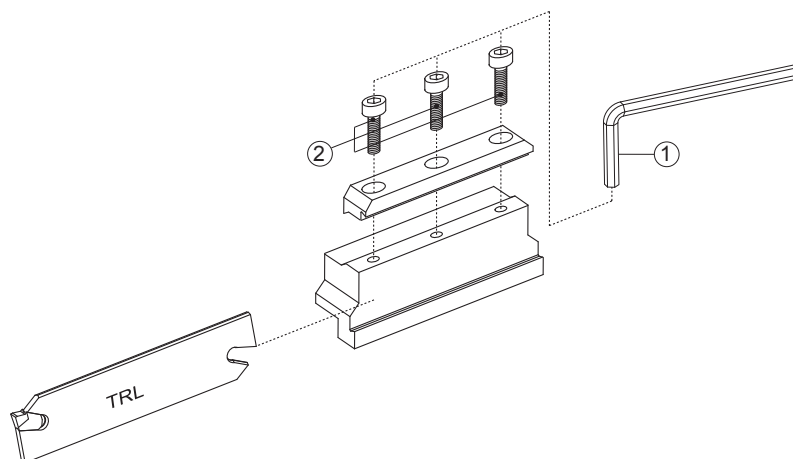
 DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES /  NEW
 APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION
 EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

 A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE /  NEW
 APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION
 MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

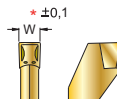
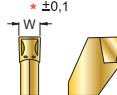
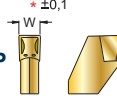
SGTBU



ART.	Prezzo Listino Price List €	H1 (mm)	H (mm)	L (mm)	B (mm)	B2 (mm)	B3 (mm)	H2 (mm)	H4 (mm)		① 	② 
SGTBU 20-5	176,00	20	26	86	21	38	4	43	9	TRL 26 - ...	5005	VBL06
SGTBU 25-5	183,00	25	26	110	23	42	4	45	5			
SGTBU 20-6	176,00	20	32	100	19	38	5,3	50	13	TRL 32 - ...	5005	VBL06
SGTBU 25-6	183,00	25	32	110	23	42	5,3	50	8			
SGTBU 32-6	230,00	32	32	110	28	44	5,3	50	2,5			





TRLN..								HW		HC																		
								NON RIVESTITI CEMENTED CARBIDE GRADES		RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS																		
ART.		COD.	W	r	l	T	a°	T115	T116																			
F O M R  .G52  F O M R  .G56  F O M R  .G57P 	TRLN 3.00-0.20N .G52	3,0*	0,2	–	–	0°																						
	TRLN 4.00-0.30N .G52	4,0*	0,3	–	–	0°																						
	TRLN 3.00-0.30N .G56	3,0*	0,3	–	–	0°																						
	TRLN 4.00-0.40N .G56	4,0*	0,4	–	–	0°																						
	TRLN 3.00-0.30N .G57P	3,0*	0,3	–	–	0°	■	■																				
	TRLN 4.00-0.40N .G57P	4,0*	0,4	–	–	0°	■	■																				
	 GRADO T115 AD ESAURIMENTO  T115 GRADE AS LONG AS STOCKS LAST  T115 SORTE SOLANGE VORRAT REICHT  DEGRE T115 JUSQU'A L'EPUISEMENT																											
	MATERIALE - MATERIAL - MATERIALIEN - MATÉRIAUX							T115	T116																			
P	ACCIAIO - STEEL - STAHL - ACIER																											
M	ACCIAIO INOX - STAINLESS STEEL - ROSTFREIER STAHL - ACIER INOXYDABLE																											
K	GHISA - CAST IRON - GRAUGUSS - FONTE GRISE																											
N	LEGHE DI ALLUMINIO - ALUMINIUM ALLOYS - ALUMINIUM-LEGIERUNGEN - ALLIAGES D'ALUMINIUM							●	●																			
S	LEGHE RESISTENTI AL CALORE - HEAT RESISTANT ALLOYS - WÄRMEBESTÄNDIGE LEGIERUNGEN - ALLIAGES RÉSIDANTES À LA CHALEUR																											
H	MATERIALI DURI E TEMPRATI - HARD AND HARDENED MATERIAL - HARTE UND GEHÄRTETE MATERIALIEN - MATERIAUX DURS ET TREMPÉS																											

■ DISPONIBILI - IN STOCK - LIEFERBAR - DISPONIBLES / ■ NEW

● APPLICAZIONE CONSIGLIATA-RECOMMENDED APPLICATION-
EMPFOHLENER EINSATZ - APPLICATION CONSEILLÉE

□ A RICHIESTA - ON REQUEST - AUF ANFRAGE - SUR DEMANDE / □ NEW

○ APPLICAZIONE POSSIBILE - POSSIBLE APPLICATION -
MÖGLICHE ANWENDUNG - APPLICATION POSSIBLE

Panoramica qualità - General view - Qualitätsübersicht - Vue d'ensemble qualité

DIN ISO 513	P ACCIAI STEELS STAHL ACIERS						M ACCIAI INOSSIDABILI STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE				K GHISE CAST IRON GRAUGUSS FONTE GRISE					N NON FERROSI NICHTEISENMA PAS FERREUX				S NON FERROSI NICHTEISENMA PAS FERREUX				
	01	10	20	30	40	50	10	20	30	40	01	10	20	30	40	10	20	30	40	10	20	30	40	
HW																								
HC																								
	TENACITÀ - TOUGHNESS - ZÄHIGKEIT - TÉNACITÉ																							
	RESISTENZA ALL'USURA - RESISTANCE TO WEAR - VERSCHLEISSFESTIGKEIT - RÉSISTANCE À L'USURE																							
	AVANZAMENTO - FEED - VORSCHUB - AVANCE																							
	VELOCITÀ - SPEED - GESCHWINDIGKEIT - VITESSE																							
HT	CERMET						HW				HC													
	METALLO DURO NON RICOPERTO UNCOATED CARBIDE UNBESCHICHTETES HARTMETALL MÉTAL DUR PAS RECOUVERT																			METALLO DURO RICOPERTO COATED CARBIDE BESCHICHTETES HARTMETALL MÉTAL DUR RECOUVERT				

Impiego delle qualità - Application of the grade - Einsatz der verschiedenen sorten - Utilisation de les qualités

SHG	DIN	ISO	MATERIALE - MATERIAL MATÉRIEL - MATÉRIEL						QUICK PICK		 
			P	M	K	N	S	H			
			ACCI STEELS STAHL ACIER	ACCIAI INOX STAINLESS STEELS ROSTFREIER STAHL ACIER INOXYDABLE	GHISA CAST IRON GRAUGUSS FONTE GRISE	MAT NON FERROSI NON FERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	MAT DIFFICILI DIFFICULT MATERIAL SCHWERIGE MATERIALIEN MAT. DIFCILES	MATERIALI DURI HARD MATERIALS HARTE MATERIALIEN MATÉRIEL DURS			
									Tenacità + Toughness -	 	INDICAZIONI - USO
T115	HW	N10-25				●				 	- QUALITÀ MICROGRANO CON ALTA RESISTENZA ALL'USURA E AGLI SHOCK TERMICI - INDICATO PER MEDIO-BASSE VELOCITÀ DI TAGLIO E ALTI AVANZAMENTI - MICROGRAIN GRADE WITH HIGH RESISTANCE TO WEAR AND TO THERMAL SHOCK - SUITABLE FOR MEDIUM-LOW CUTTING SPEEDS AND HIGH FEED
T116 NEW	HW	N10-25				●				 	- STRUTTURA OMOGENEA A GRANO FINE - GRANDE STABILITÀ DEL TAGLIANTE - GRANDE RESISTENZA ALL'USURA E ALLA EUSCORSIONE TERMICA - HOMOGENEOUS FINE-GRAIN STRUCTURE - HIGH CUTTING-EDGE STABILITY - HIGH WEAR AND THERMAL SHOCK RESISTANCE
F4645	HC PVD	P30-45	●								- ELEVATA TENACITÀ. - BUON CONTROLLO DELL'USURA E OTTIMO NELL'IMPIEGO DI LAVORAZIONI IN CONDIZIONI DIFFICILI. - CONSIDERABLE TOUGHNESS. - GOOD WEAR CONTROL AND EXCELLENT PERFORMANCE UNDER DIFFICULT MACHINING CONDITIONS
T5235	HC CVD	P20-45 K20-40	●		●						- ALTA RESISTENZA ALL'USURA, ALL'OSSIDAZIONE E BUONA TENACITÀ. - PERFORMANTE ANCHE AD ALTE VELOCITÀ DI TAGLIO - HIGH RESISTANCE TO WEAR, OXIDATION AND GOOD TOUGHNESS - EXCELLENT PERFORMANCE ALSO WITH HIGH CUTTING SPEED

● APPLICAZIONE CONSIGLIATA
RECOMMENDED APPLICATION
EMPFOHLENER EINSATZ
APPLICATION CONSEILLÉE

○ APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
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● APPLICAZIONE CONSIGLIATA
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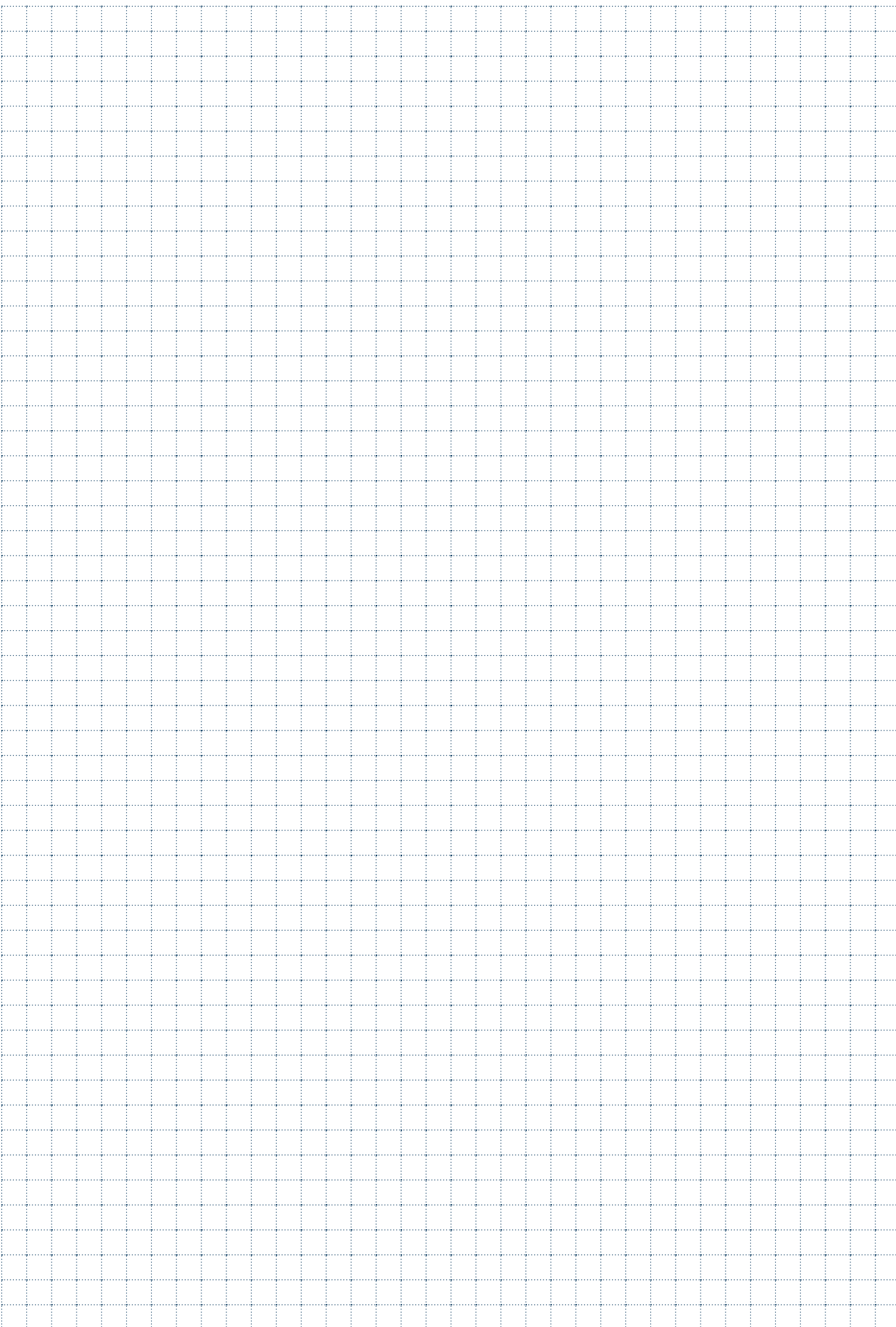
○ APPLICAZIONE POSSIBILE
POSSIBLE APPLICATION
MÖGLICHE ANWENDUNG
APPLICATION POSSIBLE

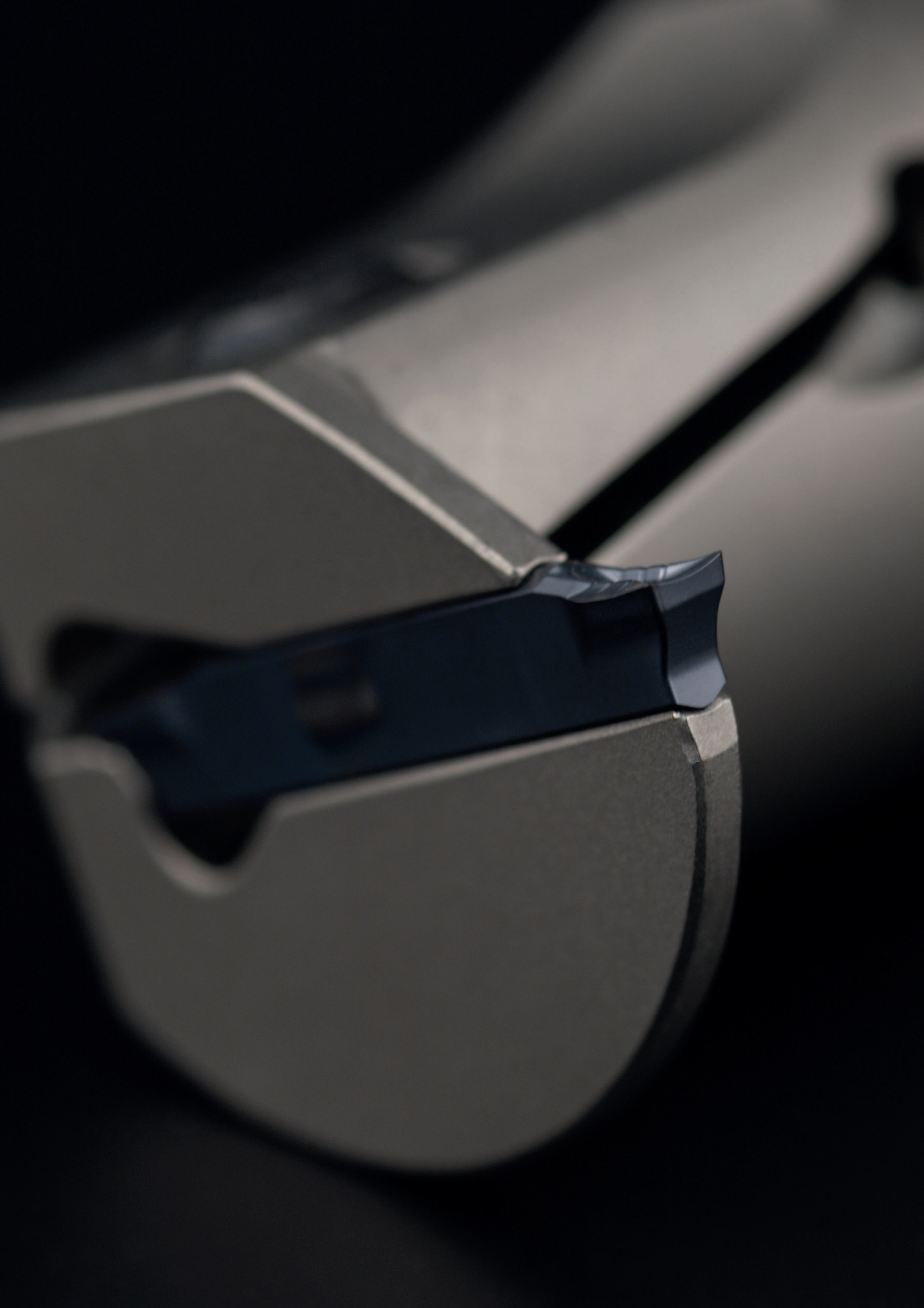
Velocità di taglio delle qualità di fresatura - Cutting speed of the milling grades
Schnittgeschwindigkeit der fräsorten - Vitesse decoupe de la qualité de plaquettes de fraisage

MATERIALE MATERIAL MATERIALIEN MATÉRIAUX	VDI 3323 GR.	HB HRC Rm	T115 T116
N MATNON FERROSI NONFERROUS MAT. NICHT-EISENMATERIALIEN MAT. FERREUX	21	60	100-800
	22	100	80-800
	23	75	80-500
	24	90	
	25	130	
	26	110	80-300
	27	90	200-600
	28	100	150-400
	29		80-500
	30		100-250

MATERIALE MATERIAL MATERIALIEN MATERIAUX	VDI 3323 GR.	HB HRC Rm	F4645
P ACCIAL STEELS STAHL ACIER	1	125	110-190
	2	180	80-150
	3	250	70-140
	4	220	70-140
	5	300	70-140
	6	180	70-140
	7-8	250-300	70-120
	9	350	60-120
	10	200	60-100
	11	350	60-100
	12	200	60-100
	13	330	60-180

MATERIALE MATERIAL MATÉRIAUX	VDI 3323 GR.	HB HRC Rm	T5235
P ACCI STEELS STAHL ACIER	1	125	130-250
	2	180	110-190
	3	250	70-170
	4	220	120-200
	5	300	110-180
	6	180	120-200
	7-8	250-300	110-180
	9	350	70-150
	10	200	90-170
	11	350	70-160
	12	200	120-200
	13	330	60-100
	K GHISA CAST IRON GRAUGUSS FONTE GRISE	15	180
16		260	80-150
17		160	100-160
18		250	70-140
19		130	100-200
20		230	80-150





Made In Italy



**FILIALE DI MODENA
MODENA SUBSIDIARY**

Via Mozart, 47
41122 Modena (MO) Italy
Tel. 0039 059 280706
Fax. 0039 059 280109
saumodena@sautool.it
www.sautool.it

**FILIALE DI TORINO
TORINO SUBSIDIARY**

Strada Vicinale della Cebrosa 86-A
10156 Torino (TO) Italy
Tel. 0039 011 8960193
Fax. 0039 011 8960193
sautorino@sautool.it
www.sautool.it



SAU S.p.A.

Via dei Raseni, 6/B
41040 Polinago (MO) Italy
Tel. 0039 0536 47510
Fax. 0039 0536 47275
infosau@sautool.it
www.sautool.it