VORTEX

ST90V

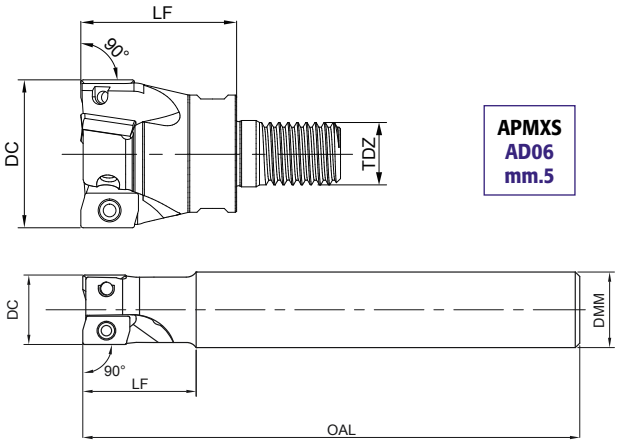
SPALLAMENTO 90° MONOLATERALE

SCHUMANTOOLS®
WORK INSPIRACTION

FRESE PER SPALLAMENTI RETTI ADMX 06
SHOULDER MILLING TOOL

Frese a 90° con attacco cilindrico e filettato per scanalature e contornature, apertura fori dal pieno in interpolazione elicoidale.

90° milling tool with cylindrical and screwed coupling for grooving and contouring, full engagement hole drilling with helical interpolation.



APMXS
AD06
mm.5

Frese per inserti: ADMX 0602...attacco cilindrico/*Milling tools for inserts: ADMX 0602…cilindrical coupling*

CODICE *CODE*	DC	DMM	OAL	LF				Nm			
ST90-V 1010 06 2CLA	10	10	100	15	2	ST VI.BO 2.0X3.0	T06-P	0.5	✓	AD..06..	●
ST90-V 1212 06 2CLA	12	12	120	15	2	ST VI.BO 2.0X3.0	T06-P	0.5	✓	AD..06..	●
ST90-V 1616 06 3CLA	16	16	160	20	3	ST VI.BO 2.0X3.0	T06-P	0.5	✓	AD..06..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Frese per inserti: ADMX 0602...attacco filettato/*Milling tools for inserts: ADMX 0602…screwed coupling*

CODICE *CODE*	DC	TDZ	LF				Nm			
ST90-V 012 06 2 FM06A	12	6	20	2	ST VI.BO 2.0X3.0	T06-P	0.5	✓	AD..06..	●
ST90-V 016 06 3 FM08A	16	8	23	3	ST VI.BO 2.0X3.0	T06-P	0.5	✓	AD..06..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Inserti per frese a spallamento retto ST90V/ *Inserts ST90V for shoulder milling tools*

CODICE *CODE*					
ADMX 060204 MM.08	**DP**	**MS30-3P**		ap max 5 mm	M S	●
ADMX 060204 M.10	**DP**	**PM30-2P**		ap max 5 mm	P M	●
ADMX 060204 M.10	**DP**	**PM40-3P**		ap max 5 mm	P M	●
ADMX 060208 MM.08	**DP**	**MS30-3P**		ap max 5 mm	M S	●
ADMX 060208 M.10	**DP**	**PM30-2P**		ap max 5 mm	P M	●
ADMX 060208 M.10	**DP**	**PM40-3P**		ap max 5 mm	P M	●
ADEX 060204 FA.06	**BO**	**KN10**		ap max 5 mm	N	●
ADEX 060204 FA.07	**BO**	**MS30-3P**		ap max 5 mm	M S	●
ADEX 060210 FA.07	**BO**	**MS30-3P**		ap max 5 mm	M S	○
ADEX 060216 FA.07	**BO**	**MS30-3P**		ap max 5 mm	M S	○

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

INFORMAZIONI TECNICHE ADMX 06/*TECHNICAL INFORMATION ADMX 06*

Nella sigla di ogni inserto ST, dopo la codifica ISO viene indicato l'avanzamento consigliato per tagliente nelle lavorazioni dal pieno (fresa impegnata il 100% del suo diametro).
Esempio .10 = av. mm. 0,10 / giro. Nelle contornature in concordanza si possono aumentare progressivamente gli avanzamenti in rapporto all'impegno laterale percentuale secondo la tabella seguente:

The model code for each ST insert includes, after the ISO code, the recommended feed rate per tooth for face milling (100% milling tool diameter is engaged). E.g. .10 – av.mm. 0.10/360°. For concordant side milling it is possible to increase feed rate gradually in relation to percentage side engagement according to the following table:

Calcolo degli avanzamenti per tagliente (in mm. giro), partendo dal codice dell'inserto ST
Calculation of feed rate per tooth point (in mm/360°), given insert ST code

PERCENTUALE DI IMPEGNO DELLA FRESA (AE / Ø %) *PERCENTAGE ENGAGEMENT OF TOOL (AE / Ø %)*	MOLTIPLICARE L'AVANZAMENTO DENTE INDICATO NELLA SIGLA INSERTO DOPO LA CODIFICA ISO PER I SEGUENTI COEFFICENTI/*MULTIPLY TOOTH FEED, INDICATED IN INSERT MODEL CODE AFTER ISO CODE, BY THE FOLLOWING COEFFICIENTS*
100%	1,0
30%	1,3
20%	1,5
10%	2,0
5%	3,0

GRADI/*GRADES*

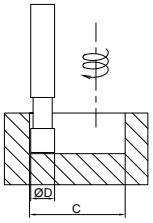
DP PM30-2P	Acciai al carbonio e inox. Riv. PVD/ *Carbon steel and SS. PVD Coating.*
DP PM40-3P	Universale per acciai al carbonio inox e superleghe riv.PVD/ *Universal choice for mild steel, SS and super alloys. PVD coating.*
DP/BO MS30-3P	Prima scelta per inox riv. PVD/ *First choice for SS. PVD coating.*
BO KN10	Lappato per lavorazione di leghe di alluminio e finitura di ghisa/*Lapped for machining of Aluminium alloys finishing of cast iron*

Velocità di taglio in metri minuto/*Cutting speed in metres/minute*

MATERIALE *MATERIAL*	**PM30-2P**	**MS30-3P**	**PM40-3P**	**KN10**
Acciaio non legato/*Non-alloy steel*	270	210	200	
Acciaio basso legato/*Low alloy steel*	220	190	180	
Acciaio medio legato/*Medium-alloy steel*	180	140	130	
Acciaio legato-stampi/*Alloy steel-dies*	130			
Inox/*SS*	80/130	90/190	90/180	
Duplex, leghe titanio, inconel 625 *Duplex steel, titanium alloys, Inconel 625*	60/120	80/100	75	
Ghisa grigia/*Grey cast iron*	200			
Alluminio/*Aluminium*				300/1000

Diametri consigliati per apertura del pieno di fori in interpolazione elicoidale/*Suggested diameters for helicoidal interpolation*

	D *D*	C min *C min*	C max *C max*
ADMX0602…	10	14	19
	12	18	23
	16	26	31

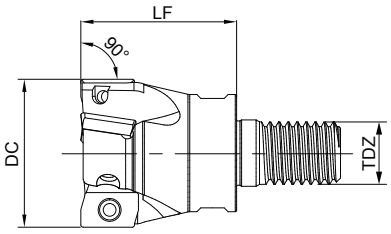


SCHUMANTOOLS®

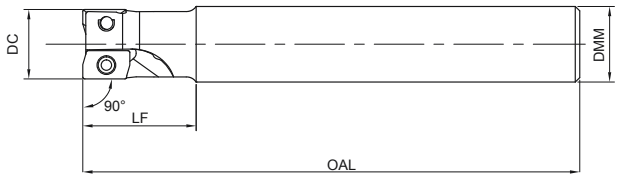
FRESE PER SPALLAMENTI RETTI ADMX 10
SHOULDER MILLING TOOL

Frese a 90° con attacco cilindrico e filettato per scanalature e contornature, apertura fori dal pieno in interpolazione elicoidale.

90° milling tool with cylindrical and screwed coupling for grooving and contouring, full engagement hole drilling with helical interpolation.



APMXS
AD10
mm.9



Frese per inserti: ADMX 1003...attacco cilindrico/*Milling tools for inserts: ADMX 1003...cilindrical coupling*

CODICE *CODE*	DC	DMM	OAL	LF				Nm			
ST90-V 1516 10 2CLA	16	15	170	25	2	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 1616 10 2CLA	16	16	170	25	2	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 2020 10 2CLA	20	20	170	30	2	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 1920 10 3CLA	20	19	170	30	3	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 2020 10 3CLA	20	20	170	30	3	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 2525 10 3CLA	25	25	200	30	3	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Frese per inserti: ADMX 1003...attacco filettato/*Milling tools for inserts: ADMX 1003. . .screwed coupling*

CODICE *CODE*	DC	TDZ	LF				Nm			
ST90-V 016 10 2 FM08A	16	12,7	23	2	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 020 10 3 FM10A	20	17,7	30	3	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 025 10 4 FM12A	25	20,7	35	4	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 032 10 4 FM16A	32	28,7	40	4	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●
ST90-V 035 10 5 FM16A	35	30,7	45	5	ST VI.BO 2.5X5.0	T08-P	1.2	✓	AD..10..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Inserti per frese a spallamento retto ST90V/ *Inserts ST90V for shoulder milling tools*

CODICE *CODE*						
ADGX 100308 MF.10	**BO**	**PM30-2P**		ap max 9 mm	P M	○
ADMX 100308 MM.09	**DP**	**MS30-3P**		ap max 9 mm	M S	●
ADMX 100308 M.12	**DP**	**PM30-2P**		ap max 9 mm	P M	●
ADMX 100308 M.12	**DP**	**PK15-3C**		ap max 9 mm	P K	●
ADEX 100308 FA.07	**BO**	**KN10**		ap max 9 mm	N	●
ADEX 100308 FA.08	**BO**	**MS30-3P**		ap max 9 mm	M S	●
ADEX 100310 FA.08	**BO**	**MS30-3P**		ap max 9 mm	M S	○
ADEX 100312 FA.08	**BO**	**MS30-3P**		ap max 9 mm	M S	○
ADEX 100316 FA.08	**BO**	**MS30-3P**		ap max 9 mm	M S	○
ADEX 100320 FA.08	**BO**	**MS30-3P**		ap max 9 mm	M S	○

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

INFORMAZIONI TECNICHE ADMX 06/*TECHNICAL INFORMATION ADMX 06*

Nella sigla di ogni inserto ST, dopo la codifica ISO viene indicato l'avanzamento consigliato per tagliente nelle lavorazioni dal pieno (fresa impegnata il 100% del suo diametro).
Esempio .10 = av. mm. 0,10 / giro. Nelle contornature in concordanza si possono aumentare progressivamente gli avanzamenti in rapporto all'impegno laterale percentuale secondo la tabella seguente:

The model code for each ST insert includes, after the ISO code, the recommended feed rate per tooth for face milling (100% milling tool diameter is engaged). E.g. .10 – av.mm. 0.10/360°. For concordant side milling it is possible to increase feed rate gradually in relation to percentage side engagement according to the following table:

Calcolo degli avanzamenti per tagliente (in mm. giro), partendo dal codice dell'inserto ST
Calculation of feed rate per tooth point (in mm/360°), given insert ST code

PERCENTUALE DI IMPEGNO DELLA FRESA (AE / Ø %) *PERCENTAGE ENGAGEMENT OF TOOL (AE / Ø %)*	MOLTIPLICARE L'AVANZAMENTO DENTE INDICATO NELLA SIGLA INSERTO DOPO LA CODIFICA ISO PER I SEGUENTI COEFFICENTI/*MULTIPLY TOOTH FEED, INDICATED IN INSERT MODEL CODE AFTER ISO CODE, BY THE FOLLOWING COEFFICIENTS*
100%	1,0
30%	1,3
20%	1,5
10%	2,0
5%	3,0

GRADI/*GRADES*

DP PK15-3C Acciai al carbonio ad alte Vc. In condizioni stabili , ghise grigie e sferoidali Riv. CVD.
Carbon steel with high Vc. Cast iron and ductile iron on stable conditions. CVD coating.

DP PM30-2P Acciai al carbonio e inox. Riv. PVD/ *Carbon steel and SS. PVD Coating.*

DP PM40-3P Universale per acciai al carbonio inox e superleghe riv.PVD/ *Universal choice for mild steel, SS and super alloys. PVD coating.*

DP/BO MS30-3P Prima scelta per inox riv. PVD/ *First choice for SS. PVD coating.*

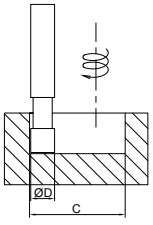
BO KN10 Lappato per lavorazione di leghe di alluminio e finitura di ghisa/*Lapped for machining of Aluminium alloys finishing of cast iron*

Velocità di taglio in metri minuto/*Cutting speed in metres/minute*

MATERIALE *MATERIAL*	**PK15-3C**	**PM30-2P**	**MS30-3P**	**PM40-3P**	**KN10**
Acciaio non legato/*Non-alloy steel*	320	270	210	200	
Acciaio basso legato/*Low alloy steel*	250	220	190	180	
Acciaio medio legato/*Medium-alloy steel*	200	180	140	130	
Acciaio legato-stampi/*Alloy steel-dies*	160	130			
Inox/*SS*	200	80/130	90/190	90/180	
Duplex, leghe titanio, inconel 625 *Duplex steel, titanium alloys, Inconel 625*		60/120	80/100	75	
Ghisa grigia/*Grey cast iron*	250	200			
Alluminio/*Aluminium*					300/1000

Diametri consigliati per apertura del pieno di fori in interpolazione elicoidale/*Suggested diameters for helicoidal interpolation*

	D *D*	C min *C min*	C max *C max*
ADMX1003…	16	21	30
	20	29	38
	25	39	48



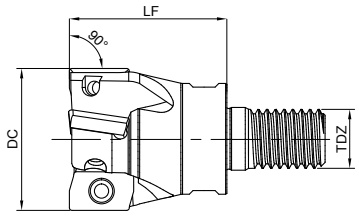
SCHUMANTOOLS®

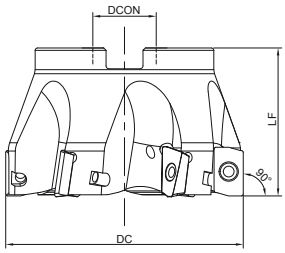
FRESE PER SPALLAMENTI RETTI ADMX 13

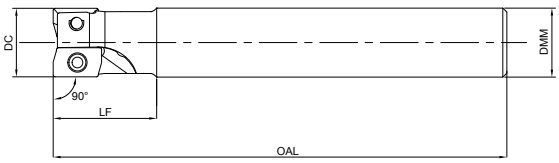
SHOULDER MILLING TOOL

Frese a 90° per scanalature e contornature.
Diametri da mm 20 a mm 100 con attacco cilindrico, filettato e a manicotto.

90° milling tool for grooving and contouring.
Diameters from 20 mm to 100 mm with sleeve, screwed and cylindrical coupling.







APMXS AD13 mm.12

Frese per inserti: ADMX 1304... attacco cilindrico lungo/*Milling tools for inserts: ADMX 1304... long cylindrical coupling*

CODICE *CODE*	DC	DMM	OAL	LF				Nm			
ST90-V 2020 13 2CLA	20	20	150	30	2	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 2525 13 2CLA	25	25	170	30	2	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 2425 13 3CLA	25	24	170	30	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 2525 13 3CLA	25	25	170	30	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 3232 13 3CLA	32	32	200	35	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Frese per inserti: ADMX 1304...attacco filettato/*Milling tools for inserts: ADMX 1304. . .screwed coupling*

CODICE *CODE*	DC	TDZ	LF				Nm			
ST90-V 020 13 2 FM10A	20	17,7	30	2	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 025 13 3 FM12A	25	20,7	35	3	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 032 13 3 FM16A	32	28,7	40	3	3	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 035 13 4 FM16A	35	30,7	45	4	4	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Frese per inserti: ADMX 1304... attacco a manicotto/*Milling tools for inserts: ADMX 1304... sleeve coupling*

CODICE *CODE*	DC	DCON	LF				Nm			
ST90-V 040 13 4MA	40	16	40	4	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 050 13 5MA	50	22	40	5	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 063 13 6MA	63	22	40	6	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●
ST90-V 080 13 7MA	80	27	50	7	ST VI.BO 3.5X10	T15-P	3.5	✓	AD..13..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Inserti per frese a spallamento retto ST90V/ *Inserts ST90V for shoulder milling tools*

CODICE *CODE*							
ADGX	**130408 MF.12**	**BO PM30-2P**			ap max 12 mm	P M	○
ADMX	**130408 MM.13**	**DP MS30-3P**			ap max 12 mm	M S	●
ADMX	**130408 M.16**	**DP PM30-2P**			ap max 12 mm	P M	●
ADMX	**130408 M.16**	**DP PK15-3C**			ap max 12 mm	P K	●
ADMX	**130412 MM.13**	**DP MS30-3P**			ap max 12 mm	M S	●
ADMX	**130412 M.16**	**DP PM30-2P**			ap max 12 mm	P M	●
ADMX	**130412 M.16**	**DP PK15-3C**			ap max 12 mm	P K	●
ADEX	**130404 FA.10**	**BO KN10**			ap max 12 mm	N	●
ADEX	**130408 FA.10**	**BO KN10**			ap max 12 mm	N	●
ADEX	**130404 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	●
ADEX	**130408 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	●
ADHX	**130408 M.15**	**KB S40C**	Rutenio		ap max 12 mm	S M	●
ADEX	**130410 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	○
ADEX	**130412 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	○
ADEX	**130416 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	○
ADEX	**130420 FA.11**	**BO MS30-3P**			ap max 12 mm	M S	○

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

INFORMAZIONI TECNICHE ADMX 13/*TECHNICAL INFORMATION ADMX 13*

Nella sigla di ogni inserto ST, dopo la codifica ISO viene indicato l'avanzamento consigliato per tagliente nelle lavorazioni dal pieno (fresa impegnata il 100% del suo diametro). Esempio .16 = av. mm. 0,16/ giro. Nelle contornature in concordanza si possono aumentare progressivamente gli avanzamenti in rapporto all'impegno laterale percentuale secondo la tabella seguente:

The model code for each ST insert includes, after the ISO code, the recommended feed rate per tooth for face milling (100% milling tool diameter is engaged). E.g. .16 – av.mm. 0.16/360°. For concordant side milling it is possible to increase feed rate gradually in relation to percentage side engagement according to the following table:

GRADI/*GRADES*

DP PK15-3C	Acciai al carbonio ad alte Vc. In condizioni stabili , ghise grigie e sferoidali Riv. CVD. *Carbon steel with high Vc. Cast iron and ductile iron on stable conditions. CVD coating.*
DP PM30-2P	Acciai al carbonio e inox. Riv. PVD/ *Carbon steel and SS. PVD Coating.*
DP PM40-3P	Universale per acciai al carbonio inox e superleghe riv.PVD/ *Universal choice for mild steel, SS and super alloys. PVD coating.*
DP/BO MS30-3P	Prima scelta per inox riv. PVD/ *First choice for SS. PVD coating.*
BO KN10	Lappato per lavorazione di leghe di alluminio e finitura di ghisa/*Lapped for machining of Aluminium alloys finishing of cast iron*
KB S40C	Ottimo grado per inconel, leghe di titanio, duplex e superleghe e inox con refrigerante e senza. *Excellent grade for Inconel, titanium alloys, duplex steel, super alloys and stainless steel with and without coolant.*

Calcolo degli avanzamenti per tagliente (in mm. giro), partendo dal codice dell'inserto ST
Calculation of feed rate per tooth point (in mm/360°), given insert ST code

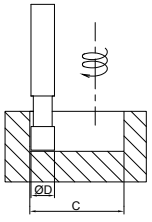
PERCENTUALE DI IMPEGNO DELLA FRESA (AE / Ø %) *PERCENTAGE ENGAGEMENT OF TOOL (AE / Ø %)*	MOLTIPLICARE L'AVANZAMENTO DENTE INDICATO NELLA SIGLA INSERTO DOPO LA CODIFICA ISO PER I SEGUENTI COEFFICENTI/*MULTIPLY TOOTH FEED, INDICATED IN INSERT MODEL CODE AFTER ISO CODE, BY THE FOLLOWING COEFFICIENTS*
100%	1,0
30%	1,3
20%	1,5
10%	2,0
5%	3,0

Velocità di taglio in metri minuto/*Cutting speed in metres/minute*

MATERIALE *MATERIAL*	**PK15-3C**	**PM30-2P**	**MS30-3P**	**KN10**	**KB S40C**
Acciaio non legato/*Non-alloy steel*	320	270	210		220
Acciaio basso legato/*Low alloy steel*	250	220	190		200
Acciaio medio legato/*Medium-alloy steel*	200	180	140		150
Acciaio legato-stampi/*Alloy steel-dies*	160	130	90		
Inox/*SS*	200	120/240	90/190		120/240
Duplex, leghe titanio, inconel 625 *Duplex steel, titanium alloys, Inconel 625*		60/120	50/100		80
Ghisa grigia/*Grey cast iron*	250	200			
Alluminio/*Aluminium*				300/1000	

Diametri consigliati per apertura del pieno di fori in interpolazione elicoidale/*Suggested diameters for helicoidal interpolation*

	D *D*	C min *C min*	C max *C max*
ADMX13004…	20	28	37
	25	38	47
	32	52	61
	35	58	68

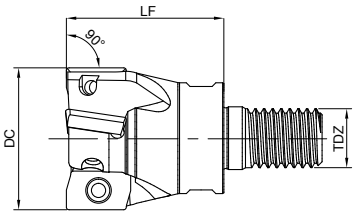


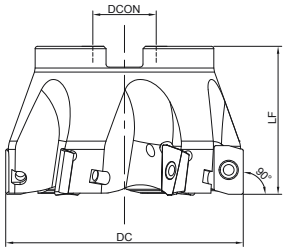
SCHUMANTOOLS®

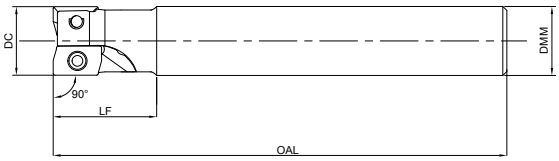
FRESE PER SPALLAMENTI RETTI ADMX 17
SHOULDER MILLING TOOL

Frese a 90° per scanalature e contornature.
Diametri da mm 20 a mm 100 con attacco cilindrico, filettato e a manicotto.

90° milling tool for grooving and contouring.
Diameters from 20 mm to 100 mm with sleeve, screwed and cylindrical coupling.







APMXS AD17 mm.16

Frese per inserti: ADMX 1706... attacco a manicotto/*Milling tools for inserts: ADMX 1706... sleeve coupling*

CODICE *CODE*	DC	DCON	LF				Nm			
ST90-V 040 17 4MA	40	16	40	4	ST VI.BO 4.0X8.0	T15-P	3.5	✓	AD..17..	●
ST90-V 050 17 5MA	50	22	40	5	ST VI.BO 4.0X8.0	T15-P	3.5	✓	AD..17..	●
ST90-V 063 17 5MA	63	22	40	5	ST VI.BO 4.0X8.0	T15-P	3.5	✓	AD..17..	●
ST90-V 080 17 6MA	80	27	50	6	ST VI.BO 4.0X8.0	T15-P	3.5	✓	AD..17..	●
ST90-V 100 17 7MA	100	32	50	7	ST VI.BO 4.0X8.0	T15-P	3.5	✓	AD..17..	●

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

Inserti per frese a spallamento retto ST90V/ *Inserts ST90V for shoulder milling tools*

CODICE *CODE*							
ADMX 170608 MM.18 DP MS30-3P			ap max 16 mm	M	S		●
ADMX 170608 M.22 DP PM30-2P			ap max 16 mm	P	M		●
ADMX 170608 M.22 DP PK15-3C			ap max 16 mm	P	K		●
ADMX 170612 MM.18 DP MS30-3P			ap max 16 mm	M	S		●
ADMX 170612 M.22 DP PM30-2P			ap max 16 mm	P	M		●
ADMX 170612 M.22 DP PK15-3C			ap max 16 mm	P	K		●
ADEX 170608 FA.15 BO KN10			ap max 16 mm	N			●
ADEX 170612 FA.15 BO KN10			ap max 16 mm	N			●
ADEX 170608 FA.17 BO MS30-3P			ap max 16 mm	M	S		●
ADEX 170612 FA.17 BO MS30-3P			ap max 16 mm	M	S		●
ADHX 170612 M.22 KB S40C	Rutenio		ap max 16 mm	S	M		○
ADEX 170616 FA.17 BO MS30-3P			ap max 16 mm	M	S		○
ADEX 170620 FA.17 BO MS30-3P			ap max 16 mm	M	S		○

● Stock Italia/*Warehouse in Italy* ○ Stock Estero/*Warehouse abroad*

INFORMAZIONI TECNICHE ADMX 17/*TECHNICAL INFORMATION ADMX 17*

Nella sigla di ogni inserto ST, dopo la codifica ISO viene indicato l'avanzamento consigliato per tagliente nelle lavorazioni dal pieno (fresa impegnata il 100% del suo diametro). Esempio .16 = av. mm. 0,16/ giro. Nelle contornature in concordanza si possono aumentare progressivamente gli avanzamenti in rapporto all'impegno laterale percentuale secondo la tabella seguente:

The model code for each ST insert includes, after the ISO code, the recommended feed rate per tooth for face milling (100% milling tool diameter is engaged). E.g. .16 – av.mm. 0.16/360°. For concordant side milling it is possible to increase feed rate gradually in relation to percentage side engagement according to the following table:

GRADI/*GRADES*

DP PK15-3C	Acciai al carbonio ad alte Vc. In condizioni stabili , ghise grigie e sferoidali Riv. CVD. *Carbon steel with high Vc. Cast iron and ductile iron on stable conditions. CVD coating.*
DP PM30-2P	Acciai al carbonio e inox. Riv. PVD/ *Carbon steel and SS. PVD Coating.*
DP PM40-3P	Universale per acciai al carbonio inox e superleghe riv.PVD/ *Universal choice for mild steel, SS and super alloys. PVD coating.*
DP/BO MS30-3P	Prima scelta per inox riv. PVD/ *First choice for SS. PVD coating.*
BO KN10	Lappato per lavorazione di leghe di alluminio e finitura di ghisa/*Lapped for machining of Aluminium alloys finishing of cast iron*
KB S40C	Ottimo grado per inconel, leghe di titanio, duplex e superleghe e inox con refrigerante e senza. *Excellent grade for Inconel, titanium alloys, duplex steel, super alloys and stainless steel with and without coolant.*

Calcolo degli avanzamenti per tagliente (in mm. giro), partendo dal codice dell'inserto ST
Calculation of feed rate per tooth point (in mm/360°), given insert ST code

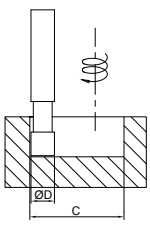
PERCENTUALE DI IMPEGNO DELLA FRESA (AE / Ø %) *PERCENTAGE ENGAGEMENT OF TOOL (AE / Ø %)*	MOLTIPLICARE L'AVANZAMENTO DENTE INDICATO NELLA SIGLA INSERTO DOPO LA CODIFICA ISO PER I SEGUENTI COEFFICENTI/*MULTIPLY TOOTH FEED, INDICATED IN INSERT MODEL CODE AFTER ISO CODE, BY THE FOLLOWING COEFFICIENTS*
100%	1,0
30%	1,3
20%	1,5
10%	2,0
5%	3,0

Velocità di taglio in metri minuto/*Cutting speed in metres/minute*

MATERIALE *MATERIAL*	PK15-3C	PM30-2P	MS30-3P	KN10	KB S40C
Acciaio non legato/*Non-alloy steel*	320	270	210		220
Acciaio basso legato/*Low alloy steel*	250	220	190		200
Acciaio medio legato/*Medium-alloy steel*	200	180	140		150
Acciaio legato-stampi/*Alloy steel-dies*	160	130	90		
Inox/*SS*	200	120/240	90/190		120/240
Duplex, leghe titanio, inconel 625 *Duplex steel, titanium alloys, Inconel 625*		60/120	50/100		80
Ghisa grigia/*Grey cast iron*	250	200			
Alluminio/*Aluminium*				300/1000	

Diametri consigliati per apertura del pieno di fori in interpolazione elicoidale/*Suggested diameters for helicoidal interpolation*

	D *D*	C min *C min*	C max *C max*
ADMX1706…	40	64	77
	50	85	97
	63	109	123
	80	144	157
	100	184	197



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Contatti