



## ROHOVÉ FRÉZY




























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## ROHOVÉ FRÉZY – SPRIEVODCA

### FRÉZOVANIE DO ROHU



	SAD07D		SAD11E		SAD16E		SAP10D		SAP16D																		
	90°		90°		90°		90°		90°																		
	APMX (mm)	5.0	APMX (mm)	9.0	APMX (mm)	13.0	APMX (mm)	9.0	APMX (mm)	13.0																	
	DC (mm)	10 – 32	DC (mm)	16 – 125	DC (mm)	25 – 175	DC (mm)	10 – 63	DC (mm)	25 – 160																	
<b>Valcová stopka</b>		DC = 10 – 25 (mm)		DC = 16 – 35 (mm)		DC = 25 – 32 (mm)																					
<b>Weldon stopka</b>				DC = 16 – 32 (mm)		DC = 25 – 40 (mm)		DC = 10 – 25 (mm)		DC = 25 – 40 (mm)																	
<b>Modulárna</b>		DC = 12 – 32 (mm)		DC = 16 – 40 (mm)		DC = 32 – 40 (mm)																					
<b>Nástrčná</b>				DC = 40 – 125 (mm)		DC = 40 – 175 (mm)		DC = 40 – 63 (mm)		DC = 40 – 160 (mm)																	
<b>Strana</b>	📖 413		📖 420		📖 429		📖 438		📖 441																		
<b>ISO</b>	P	M	K	N	S	P	M	K	N	S	H	P	M	K	N	S	H	P	M	K	N	S	P	M	K	N	S
<b>Tvar doštičky</b>																											
<b>Doštičky</b>	AD.X 0702		AD.X 11T3		AD.X 1606		APKT 1003		APT 1604																		
<b>Počet rezných hrán</b>	2		2		2		2		2																		
<b>Plytké frézovanie do rohu</b> 	■		■		■		■		■																		
<b>Špirálová interpolácia</b> 	■		■		■		■		■																		
<b>Frézovanie plytkých drážok</b> 	■		■		■		■		■																		
<b>Odvrtavacie frézovanie</b> 	■		■		■		■		■																		
<b>Postupné zavrtávanie</b> 	■		■		■		■		■																		
<b>Zachádzanie pod uhlom</b> 	■		■		■		■		■																		
<b>Rovinné frézovanie</b> 	▣		▣		▣		▣		▣																		
<b>Frézovanie tvarových plôch (kopírovanie)</b> 	▣		■		■																						

■ Hlavné použitie    ▣ Možné použitie



# ROHOVÉ FRÉZY – SPRIEVODCA



## FRÉZOVANIE DO ROHU















	STN10		STN16 <b>NEW</b>		SLN12		SLN16		SSO050		SSO09	
	90°		90°		90°		90°		90°		90°	
	APMX (mm)	5.0	APMX (mm)	10.0	APMX (mm)	9.0	APMX (mm)	13.0	APMX (mm)	4.5	APMX (mm)	8.0
	DC (mm)	18 – 32	DC (mm)	25 – 175	DC (mm)	25 – 125	DC (mm)	63 – 175	DC (mm)	12 – 40	DC (mm)	20 – 125
		DC = 18 – 35 (mm)		DC = 25 – 35 (mm)		DC = 25 – 32 (mm)				DC = 12 – 25 (mm)		
		DC = 20 – 32 (mm)		DC = 25 – 40 (mm)		DC = 25 – 40 (mm)				DC = 20 – 32 (mm)		DC = 20 – 32 (mm)
		DC = 20 – 32 (mm)		DC = 25 – 40 (mm)		DC = 25 – 40 (mm)						
		DC = 40 – 80 (mm)		DC = 40 – 175 (mm)		DC = 40 – 125 (mm)				DC = 32 – 40 (mm)		DC = 40 – 125 (mm)
	📖 446		📖 450		📖 455		📖 461		📖 466		📖 469	
	<b>P</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>P</b>	<b>M</b>	<b>K</b>	<b>N</b>	<b>P</b>	<b>K</b>	<b>N</b>	<b>H</b>
	TNGX 1004		TNGX 1606		LNG. 1205		LN.U 1607		SOMT 0502		SOMT 09T3	
	6		6		4		4		4		4	
	■		■		■		■		■		■	
	▣		▣		▣		▣		▣		▣	
	■		■		■		■		■		■	
	▣		▣		▣		▣		▣		▣	
	▣				▣							
	▣				▣							
	■		■		▣						▣	
					▣		▣		■			



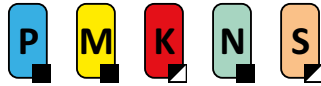
## ROHOVÉ FRÉZY – SPRIEVODCA

### <<< FRÉZOVANIE DO ROHU

	SSD12		FTB27X																
	90°		90°																
	APMX (mm)	10.0	APMX (mm)	18.0															
	DC (mm)	50 – 160	DC (mm)	140 – 260															
<b>Valcová stopka</b>																			
<b>Weldon stopka</b>																			
<b>Modulárna</b>																			
<b>Nástrčná</b>																			
<b>Strana</b>	📖 472		📖 475																
<b>ISO</b>	P	M	K	N	S	P	M	K											
<b>Tvar doštičky</b>																			
<b>Doštičky</b>	SDMT 1205		TBMR 2707																
<b>Počet rezných hrán</b>	4		3																
<b>Plytké frézovanie do rohu</b> 		■		■															
<b>Špirálová interpolácia</b> 																			
<b>Frézovanie plytkých drážok</b> 		■		▣															
<b>Odvrtavacie frézovanie</b> 		■																	
<b>Postupné zavrtávanie</b> 																			
<b>Zachádzanie pod uhlom</b> 																			
<b>Rovinné frézovanie</b> 		▣		▣															
<b>Frézovanie tvarových plôch (kopírovanie)</b> 																			



# SAD07D



PRAMET

S

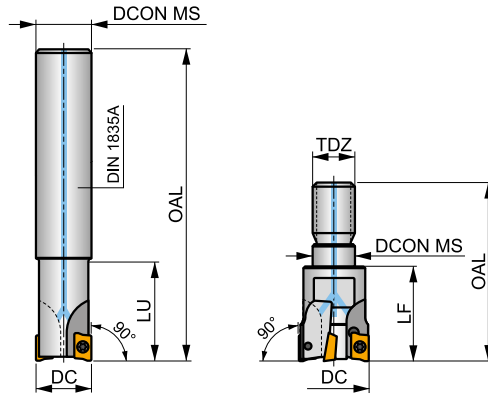
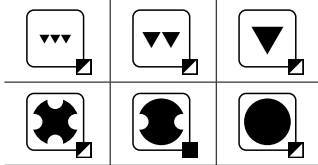
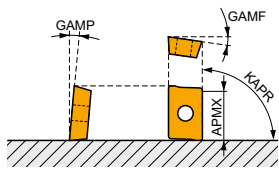


## FORCE AD07 rohová fréza s vnútorným chladením

90° stopková fréza na pozitívne dosičky AD..07 s APMX 5 mm. Vhodná pre čelné, rohové, drážkovacie, špirálové, trochoidné, zanorovacie a odvírtavacie frézovanie. Dostupná v prevedení s valcovou stopkou a modulárne (s nerovnomernou zubovou roztečou), s priermi Ø 10 až Ø 32 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

## FORCE AD

KAPR	90°
APMX	5.0 mm



$h_m$  0.03 – 0.08



Produkt	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)	GAMF	GAMP	max.	kg	GI276	SQ010	
10A2R016A08-SAD07D-C	10	100	8	16	-	-	-12	8	2	-	61600	✓	0.07	GI276	SQ010
10A2R016A10-SAD07D-C	10	80	10	16	-	-	-12	8	2	-	61600	✓	0.07	GI276	SQ010
10A2R018A08-SAD07D-CF	10	100	8	18	-	-	-12	8	2	-	61600	✓	0.07	GI276	SQ010
10A2R018A10-SAD07D-CF	10	80	10	18	-	-	-12	8	2	-	61600	✓	0.07	GI276	SQ010
12A2R018A10-SAD07D-C	12	120	10	18	-	-	-10	8	2	-	56300	✓	0.09	GI276	SQ010
12A2R018A12-SAD07D-C	12	90	12	18	-	-	-10	8	2	-	56300	✓	0.10	GI276	SQ010
12A3R018A12-SAD07D-C	12	90	12	18	-	-	-10	8	3	-	56200	✓	0.10	GI276	SQ010
12A3R020A12-SAD07D-CF	12	90	12	20	-	-	-10	8	3	-	56200	✓	0.10	GI276	SQ010
14A3R018A12-SAD07D-C	14	140	12	18	-	-	-9	8	3	-	52100	✓	0.15	GI276	SQ010
14A3R018A14-SAD07D-C	14	90	14	18	-	-	-9	8	3	-	52100	✓	0.12	GI276	SQ010
14A3R020A12-SAD07D-CF	14	140	12	20	-	-	-9	8	3	-	52100	✓	0.14	GI276	SQ010
14A3R020A14-SAD07D-CF	14	90	14	20	-	-	-9	8	3	-	52100	✓	0.09	GI276	SQ010
16A3R019A14-SAD07D-C	16	160	14	19	-	-	-8	8	3	-	48700	✓	0.21	GI276	SQ011
16A3R019A16-SAD07D-C	16	110	16	19	-	-	-8	8	3	-	48700	✓	0.18	GI276	SQ011
16A4R019A16-SAD07D-C	16	110	16	19	-	-	-8	8	4	-	48700	✓	0.18	GI276	SQ011
18A4R019A16-SAD07D-C	18	180	16	19	-	-	-7.5	8	4	✓	45900	✓	0.28	GI276	SQ011
18A4R019A18-SAD07D-C	18	110	18	19	-	-	-7.5	8	4	✓	45900	✓	0.22	GI276	SQ011
20A4R020A18-SAD07D-C	20	200	18	20	-	-	-7	8	4	✓	43600	✓	0.38	GI276	SQ011
20A4R020A20-SAD07D-C	20	125	20	20	-	-	-7	8	4	✓	43600	✓	0.30	GI276	SQ011
20A5R020A20-SAD07D-C	20	125	20	20	-	-	-7	8	5	✓	43600	✓	0.30	GI276	SQ011
25A5R024A25-SAD07D-C	25	140	25	24	-	-	-6.5	8	5	✓	39000	✓	0.52	GI276	SQ011
25A6R024A25-SAD07D-C	25	140	25	24	-	-	-6.5	8	6	✓	39000	✓	0.52	GI276	SQ011
12A2R020M06-SAD07D-C	12	35	6.5	-	20	M6	-10	8	2	-	-	✓	0.05	GI276	SQ010
14A3R020M08-SAD07D-C	14	38	8.5	-	20	M8	-9	8	3	-	-	✓	0.05	GI276	SQ010
14A3R023M08-SAD07D-CF	14	41	8.5	-	23	M8	-9	8	3	-	-	✓	0.05	GI276	SQ010
16A4R023M08-SAD07D-C	16	41	8.5	-	23	M8	-8	8	4	✓	-	✓	0.06	GI276	SQ011
20A5R030M10-SAD07D-C	20	49	10.5	-	30	M10	-7	8	5	✓	-	✓	0.09	GI276	SQ011



Produkt	DC	OAL	DCONMS	LU	LF	TDZ	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)		(°)	(°)							
<b>25A6R035M12-SAD07D-C</b>	25	57	12.5	-	35	M12	-6.5	8	6	✓	-	✓	0.13	GI276	SQ011
<b>32A8R043M16-SAD07D-C</b>	32	66	17	-	43	M16	-6	8	8	✓	-	✓	0.25	GI276	SQ011

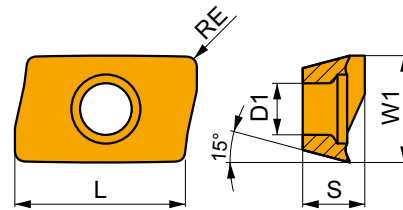
GI276	ADMX 0702..

SQ010	US 62003A-T06P	0.6	M 2	3	Flag T06P
SQ011	US 62004A-T06P	0.6	M 2	4	Flag T06P

## ADMX 07

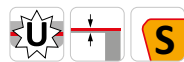
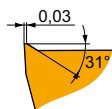


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	4.482	2.20	6.95	2.48



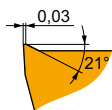
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometria s veľmi ostrým pozitívnym prevedením pre ľahké obrábanie.

ADMX 070202SR-F	<b>M8330</b>	0.2	220	0.07	2.0	130	0.06	2.0	-	-	-	660	0.08	2.0	55	0.05	1.6	-	-	-
	<b>M8340</b>	0.2	200	0.07	2.0	120	0.06	2.0	-	-	-	-	-	-	50	0.05	1.6	-	-	-
ADMX 070204SR-F	<b>M6330</b>	0.4	200	0.07	2.0	140	0.06	2.0	-	-	-	-	-	-	60	0.05	1.6	-	-	-
	<b>M8310</b>	0.4	265	0.07	2.0	135	0.06	2.0	-	-	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	0.4	235	0.07	2.0	140	0.06	2.0	-	-	-	705	0.08	2.0	55	0.05	1.6	-	-	-
	<b>M8340</b>	0.4	215	0.07	2.0	125	0.06	2.0	-	-	-	-	-	-	50	0.05	1.6	-	-	-
ADMX 070208SR-F	<b>M9340</b>	0.4	290	0.07	2.0	170	0.06	2.0	-	-	-	-	-	-	70	0.05	1.6	-	-	-
	<b>M6330</b>	0.8	240	0.07	2.0	170	0.06	2.0	-	-	-	-	-	-	70	0.05	1.6	-	-	-
	<b>M8310</b>	0.8	320	0.07	2.0	160	0.06	2.0	-	-	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	0.8	280	0.07	2.0	165	0.06	2.0	-	-	-	840	0.08	2.0	70	0.05	1.6	-	-	-
	<b>M8340</b>	0.8	255	0.07	2.0	150	0.06	2.0	-	-	-	-	-	-	60	0.05	1.6	-	-	-



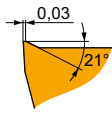
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 070202SR-M	<b>8215</b>	0.2	210	0.09	2.2	125	0.08	2.2	195	0.09	2.2	630	0.11	2.2	50	0.06	1.8	-	-	-
	<b>M8330</b>	0.2	205	0.09	2.2	120	0.08	2.2	190	0.09	2.2	615	0.11	2.2	50	0.06	1.8	-	-	-
	<b>M8340</b>	0.2	185	0.09	2.2	110	0.08	2.2	175	0.09	2.2	-	-	-	45	0.06	1.8	-	-	-



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



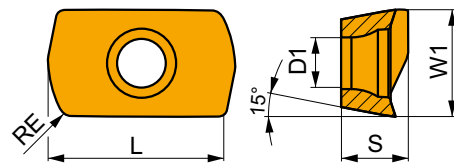
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 070204SR-M	8215	0.4	225	0.09	2.2	135	0.08	2.2	210	0.09	2.2	675	0.11	2.2	55	0.06	1.8	-	-	-
	M6330	0.4	190	0.09	2.2	135	0.08	2.2	-	-	-	-	-	-	55	0.06	1.8	-	-	-
	M8310	0.4	245	0.09	2.2	120	0.08	2.2	230	0.09	2.2	-	-	-	-	-	-	-	-	-
	M8330	0.4	200	0.09	2.2	130	0.08	2.2	205	0.09	2.2	660	0.11	2.2	55	0.06	1.8	-	-	-
	M8340	0.4	220	0.09	2.2	120	0.08	2.2	190	0.09	2.2	-	-	-	50	0.06	1.8	-	-	-
ADMX 070208SR-M	M9340	0.4	265	0.09	2.2	155	0.08	2.2	-	-	-	-	-	65	0.06	1.8	-	-	-	
	8215	0.8	270	0.09	2.2	160	0.08	2.2	255	0.09	2.2	810	0.11	2.2	65	0.06	1.8	-	-	-
	M6330	0.8	225	0.09	2.2	160	0.08	2.2	-	-	-	-	-	65	0.06	1.8	-	-	-	
	M8310	0.8	290	0.09	2.2	145	0.08	2.2	275	0.09	2.2	-	-	-	-	-	-	-	-	
	M8330	0.8	260	0.09	2.2	155	0.08	2.2	245	0.09	2.2	780	0.11	2.2	65	0.06	1.8	-	-	-
ADMX 070212SR-M	M8340	0.8	240	0.09	2.2	140	0.08	2.2	225	0.09	2.2	-	-	-	60	0.06	1.8	-	-	-
	M9340	0.8	315	0.09	2.2	185	0.08	2.2	-	-	-	-	-	75	0.06	1.8	-	-	-	
	M8340	1.2	250	0.09	2.2	150	0.08	2.2	235	0.09	2.2	-	-	-	60	0.06	1.8	-	-	-
ADMX 070216SR-M	M8310	1.6	320	0.09	2.2	160	0.08	2.2	300	0.09	2.2	-	-	-	-	-	-	-	-	
	M8330	1.6	290	0.09	2.2	170	0.08	2.2	275	0.09	2.2	870	0.11	2.2	70	0.06	1.8	-	-	-
	M8340	1.6	265	0.09	2.2	155	0.08	2.2	250	0.09	2.2	-	-	-	65	0.06	1.8	-	-	-
ADMX 070220SR-M	M6330	2.0	260	0.09	2.2	185	0.08	2.2	-	-	-	-	-	75	0.06	1.8	-	-	-	
	M8310	2.0	340	0.09	2.2	170	0.08	2.2	320	0.09	2.2	-	-	-	-	-	-	-	-	
	M8330	2.0	300	0.09	2.2	180	0.08	2.2	285	0.09	2.2	900	0.11	2.2	75	0.06	1.8	-	-	-
	M8340	2.0	275	0.09	2.2	165	0.08	2.2	260	0.09	2.2	-	-	-	65	0.06	1.8	-	-	-

## ADEX 07-HF

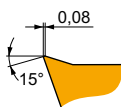


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.439	2.20	6.45	2.48



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



HF geometria s veľmi pozitívnym prevedením pre vysokoposuvové obrábanie.

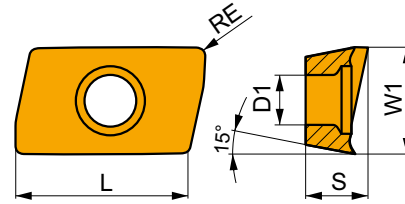
ADEX 070206SR-HF	M6330	0.6	200	0.60	0.3	140	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-
	M8330	0.6	225	0.60	0.3	135	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-
	M8340	0.6	215	0.60	0.3	125	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-



# ADEX 07-FA

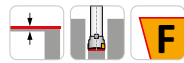
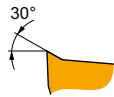


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	4.497	2.20	6.95	2.48



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

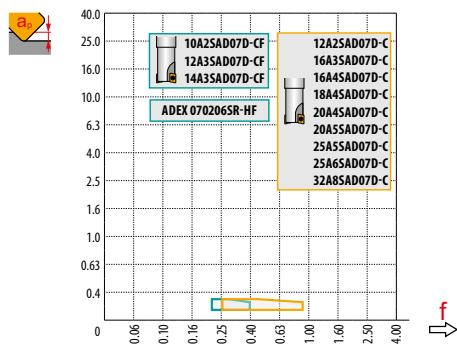
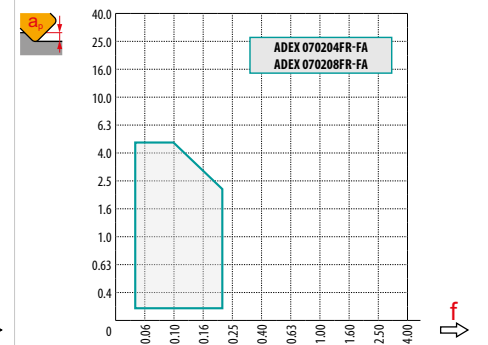
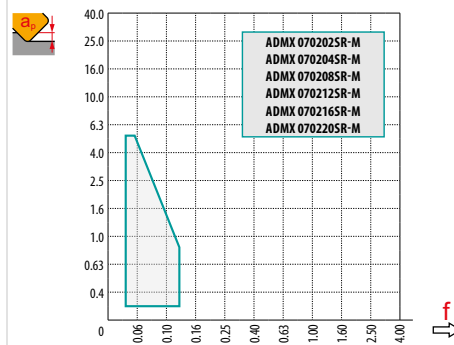
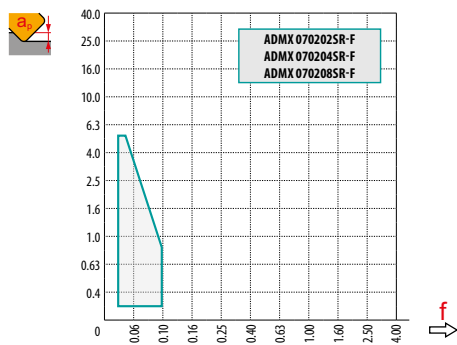
ADEX 070204FR-FA	HF7	0.4	-	-	-	-	-	-	-	■	240	0.18	3.0	-	-	-	-	-	-
	M0315	0.4	-	-	-	-	-	-	-	■	555	0.18	3.0	-	-	-	-	-	-
ADEX 070208FR-FA	HF7	0.8	-	-	-	-	-	-	-	■	285	0.18	3.0	-	-	-	-	-	-





$a_s$ DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 07-F	ADMX 07-M							ADEX 07-HF	ADEX 07-FA		
	0.2	0.4	0.8	0.2	0.4	0.8	1.2	1.6	2.0	0.6	0.4	0.8
	1.38	0.89	0.54	1.38	0.89	0.54	1.07	0.7	0.33	–	0.94	0.55



ADEX 07-HF		0	0.1	0.2	0.3
10		5.6	7.8	8.7	9.4
12		7.6	9.8	10.7	11.4
14		9.6	11.8	12.7	13.4
16		11.6	13.8	14.7	15.4
18		13.6	15.8	16.7	17.4
20		15.6	17.8	18.7	19.4
25		20.6	22.8	23.7	24.4
32	27.6	29.8	30.7	31.4	

HFC		0.1	0.2	0.3
		0.9	0.8	0.6



3.0

	HFC					
	1.0	3.0	5.0	0.1	0.2	0.3
	0.13	0.08	0.05	0.7	0.6	0.4



	HFC			
DC	RPMX	APMX/I	RPMX	APMX/I
10	5.2	5.0/56	3.5	0.3/6
12	3.4	5.0/86	2.2	0.3/9
14	2.5	4.2/100	1.6	0.3/12
16	1.9	3.2/100	1.3	0.3/15
18	1.7	2.8/100	1.1	0.3/17
20	1.5	2.5/100	0.9	0.3/21
25	1.1	1.8/100	0.7	0.3/26
32	0.8	1.2/100	0.5	0.3/36



	HFC							
DC	DMIN	DMAX			DMIN	DMAX		
10	12.0	20.0	0.5	2.8	12	20	0.30	0.30
12	16.0	24.0	0.7	2.2	16	24	0.30	0.30
14	20.0	28.0	0.8	1.9	20	28	0.30	0.30
16	24.0	32.0	0.8	1.6	24	32	0.30	0.30
18	28.0	36.0	0.9	1.6	28	36	0.30	0.30
20	32.0	40.0	0.9	1.6	32	40	0.30	0.30
25	42.0	50.0	1.0	1.5	42	50	0.30	0.30
32	56.0	64.0	1.0	1.4	56	64	0.30	0.30

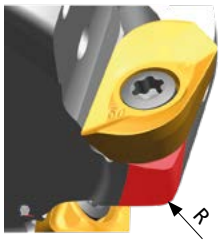


0.5

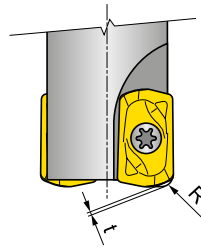
	HFC
	0.3



DC	$\mu\text{m}$	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
14		0.410	0.529	0.748	0.917	1.058	1.296	1.497	1.673	1.833	2.117	2.366
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578



ADMX 07	R
ADMX 070216SR-M	1
ADMX 070220SR-M	1.5
ADEX 070206SR-HF	1



ADEX 07	R	t
ADEX 070206SR-HF	0.8	0.18



# SAD11E



PRAMET

S

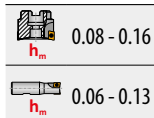
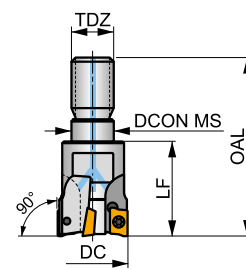
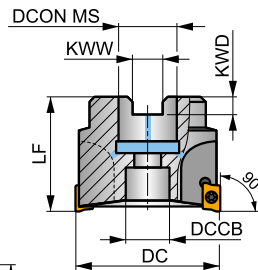
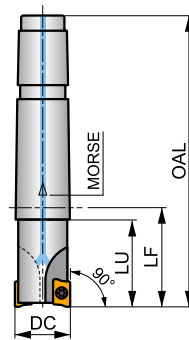
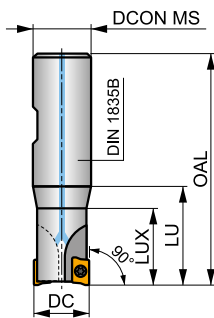
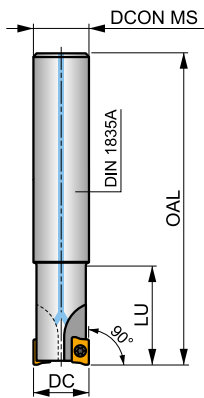
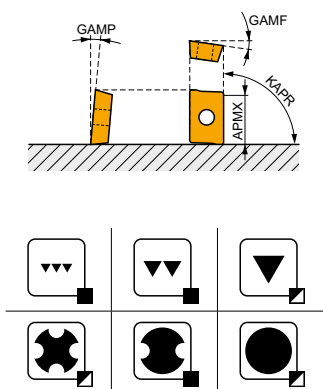


## FORCE AD11 rohová fréza s vnútorným chladením

90° stopkové a nástrčné frézy na pozitívne dosičky AD.. 11 s APMX 9 mm. Vhodné pre čelné, rohové, drážkovacie, špirálové, trochoidné, zanorovacie a odvrávacie frézovanie. Dostupné v prevedení s valcovou, Weldon a Morse stopkou, modulárne a nástrčné (s nerovnomernou zubovou roztečou), s priemermi Ø 16 až Ø 125 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

## FORCE AD

KAPR	90°
APMX	9.0 mm



Produkt	DC	OAL	DCON MS	DCCB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP	max.	kg	GI169	SQ025		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(°)	(°)							
16A2R024A14-SAD11E-C	16	160	14	-	24	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.21	GI169 SQ025 -
16A2R024A16-SAD11E-C	16	135	16	-	24	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.19	GI169 SQ025 -
16A2R050A16-SAD11E-C	16	135	16	-	50	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.20	GI169 SQ025 -
18A2R029A20-SAD11E-C	18	150	20	-	29	-	-	-	-	-	-	-12	4.5	2	-	28400	✓	0.35	GI169 SQ025 -
20A2R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.33	GI169 SQ020 -
20A2R070A20-SAD11E-C	20	150	20	-	70	-	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.32	GI169 SQ020 -
20A3R029A18-SAD11E-C	20	200	18	-	29	-	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.38	GI169 SQ025 -
20A3R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.33	GI169 SQ025 -
22A3R029A20-SAD11E-C	22	200	20	-	29	-	-	-	-	-	-	-11.5	5	3	-	25600	✓	0.49	GI169 SQ025 -
25A3R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.42	GI169 SQ020 -
25A3R080A25-SAD11E-C	25	170	25	-	80	-	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.55	GI169 SQ020 -
25A4R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.42	GI169 SQ025 -
25A4R040A25-SAD11E-C	25	250	25	-	40	-	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.86	GI169 SQ025 -
30A3R080A32-SAD11E-C	30	200	32	-	80	-	-	-	-	-	-	-9.3	7	3	-	22000	✓	1.02	GI169 SQ020 -
32A3R090A32-SAD11E-C	32	195	32	-	90	-	-	-	-	-	-	-9	5	3	-	21300	✓	1.01	GI169 SQ020 -
32A5R034A32-SAD11E-C	32	195	32	-	34	-	-	-	-	-	-	-9	8	5	-	21300	✓	1.03	GI169 SQ025 -
35A5R025A32-SAD11E-C	35	200	32	-	25	-	-	-	-	-	-	-9	8	5	-	20300	✓	1.16	GI169 SQ020 -
16A2R027B16-SAD11E-C	16	75	16	-	-	27	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.09	GI169 SQ025 -
20A2R032B20-SAD11E-C	20	82	20	-	-	32	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.13	GI169 SQ020 -
20A3R032B20-SAD11E-C	20	82	20	-	-	32	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.13	GI169 SQ025 -
25A3R042B25-SAD11E-C	25	98	25	-	-	42	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.29	GI169 SQ020 -
25A4R042B25-SAD11E-C	25	98	25	-	-	42	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.31	GI169 SQ025 -
32A4R042B32-SAD11E-C	32	102	32	-	-	42	-	-	-	-	-	-9	8	4	-	21300	✓	0.27	GI169 SQ020 -
32A5R042B32-SAD11E-C	32	102	32	-	-	42	-	-	-	-	-	-9	8	5	-	21300	✓	0.52	GI169 SQ025 -
16A2R030E02-SAD11E-C	16	94	-	-	25	-	30	-	2	-	-	-12.8	4	2	-	30100	✓	0.15	GI169 SQ025 -
20A3R035E03-SAD11E-C	20	116	-	-	30	-	35	-	3	-	-	-11.5	5	3	-	27000	✓	0.28	GI169 SQ025 -
25A4R043E03-SAD11E-C	25	124	-	-	38	-	43	-	3	-	-	-10.2	5	4	-	24100	✓	0.32	GI169 SQ025 -



Produkt	DC	OAL	D CON MS	D CB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			(mm)	(mm)	(°)	(°)									
16A2R024M08-SAD11E-C	16	38	8.5	-	-	-	24	M8	-	-	-	-12.8	4	2	-	-	✓	0.04	GI169	SQ025	-	-
20A2R026M10-SAD11E-C	20	45	11	-	-	-	26	M10	-	-	-	-11.5	5	2	-	-	✓	0.09	GI169	SQ020	-	-
20A3R026M10-SAD11E-C	20	45	10.5	-	-	-	26	M10	-	-	-	-11.5	5	3	-	-	✓	0.06	GI169	SQ025	-	-
25A3R033M12-SAD11E-C	25	55	12.5	-	-	-	33	M12	-	-	-	-10.2	5	3	-	-	✓	0.15	GI169	SQ020	-	-
25A4R033M12-SAD11E-C	25	55	12.5	-	-	-	33	M12	-	-	-	-10.2	5	4	-	-	✓	0.09	GI169	SQ025	-	-
32A4R043M16-SAD11E-C	32	66	17	-	-	-	43	M16	-	-	-	-9	8	4	-	-	✓	0.21	GI169	SQ020	-	-
32A5R043M16-SAD11E-C	32	66	17	-	-	-	43	M16	-	-	-	-9	8	5	-	-	✓	0.19	GI169	SQ025	-	-
40A4R043M16-SAD11E-C	40	66	17	-	-	-	43	M16	-	-	-	-8.1	11	4	-	-	✓	0.27	GI169	SQ020	-	-
40A6R043M16-SAD11E-C	40	66	17	-	-	-	43	M16	-	-	-	-8.1	11	6	-	-	✓	0.21	GI169	SQ020	-	-
40A04R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	4	✓	19100	✓	0.16	GI169	SQ022	-	-
40A05R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	5	✓	19000	✓	0.32	GI169	SQ022	-	-
40A06R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	6	✓	19100	✓	0.16	GI169	SQ022	-	-
50A05R-S90AD11E-C	50	-	22	18	-	-	40	-	-	10.4	6.3	-7.2	12	5	✓	17000	✓	0.31	GI169	SQ023	-	-
50A07R-S90AD11E-C	50	-	22	18	-	-	40	-	-	10.4	6.3	-7.2	12	7	✓	17000	✓	0.45	GI169	SQ023	-	-
63A06R-S90AD11E-C	63	-	22	18	-	-	40	-	-	10.4	6.3	-6.5	12	6	✓	15200	✓	0.54	GI169	SQ023	-	-
63A09R-S90AD11E-C	63	-	22	18	-	-	40	-	-	10.4	6.3	-6.5	12	9	✓	15200	✓	0.63	GI169	SQ023	-	-
80A10R-S90AD11E-C	80	-	27	38	-	-	50	-	-	12.4	7	-6	12	10	✓	13500	✓	1.05	GI169	SQ021	AC001	-
100A11R-S90AD11E-C	100	-	32	45	-	-	50	-	-	14.4	8	-5.5	12	11	✓	12100	✓	1.89	GI169	SQ021	AC002	-
125A12R-S90AD11E-C	125	-	40	56	-	-	63	-	-	16.4	9	-5.2	12	12	✓	10800	✓	2.97	GI169	SQ021	AC003	-

GI169	ADMX 11T3..	ADEX 11T3..

SQ020	US 62506-T07P	1.2	M 2.5	6	-	-	Flag T07P	-
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	-
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	-	-	Flag T07P	-

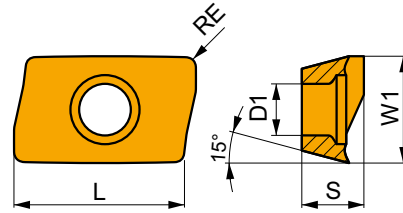
AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40



# ADMX 11

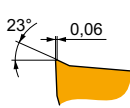
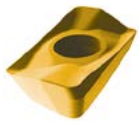


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.530	2.90	11.00	3.97



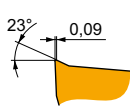
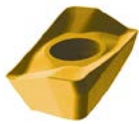
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometria s veľmi ostrým pozitívnym prevedením pre ľahké obrábanie.

ADMX 11T304SR-F	<b>8215</b>	0.4	█	245	0.10	2.0	✓	145	0.09	2.0	✗	230	0.10	2.0	✓	735	0.12	2.0	✓	60	0.08	1.6	-	-	-
	<b>M8310</b>	0.4	█	270	0.10	2.0	✓	135	0.09	2.0	✗	255	0.10	2.0	-	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	0.4	█	240	0.10	2.0	✓	140	0.09	2.0	✗	225	0.10	2.0	✓	720	0.12	2.0	✓	60	0.08	1.6	-	-	-
	<b>M8340</b>	0.4	█	220	0.10	2.0	✓	130	0.09	2.0	✗	205	0.10	2.0	-	-	-	✓	55	0.08	1.6	-	-	-	
	<b>M9340</b>	0.4	█	285	0.10	2.0	✓	170	0.09	2.0	-	-	-	-	-	-	-	✓	70	0.08	1.6	-	-	-	
ADMX 11T308SR-F	<b>8215</b>	0.8	█	290	0.10	2.0	✓	170	0.09	2.0	✗	275	0.10	2.0	✓	870	0.12	2.0	✓	70	0.08	1.6	-	-	-
	<b>M8330</b>	0.8	█	285	0.10	2.0	✓	170	0.09	2.0	✗	270	0.10	2.0	✓	855	0.12	2.0	✓	70	0.08	1.6	-	-	-
	<b>M8340</b>	0.8	█	260	0.10	2.0	✓	155	0.09	2.0	✗	245	0.10	2.0	-	-	-	✓	65	0.08	1.6	-	-	-	
	<b>M9340</b>	0.8	█	340	0.10	2.0	✓	200	0.09	2.0	-	-	-	-	-	-	-	✓	85	0.08	1.6	-	-	-	



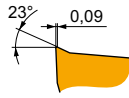
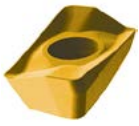
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 11T302SR-M	<b>M8330</b>	0.2	█	190	0.15	4.0	█	110	0.14	4.0	█	180	0.15	4.0	-	-	-	✓	45	0.12	3.2	-	-	-
	<b>M8340</b>	0.2	█	170	0.15	4.0	█	100	0.14	4.0	✓	160	0.15	4.0	-	-	-	✓	40	0.12	3.2	-	-	-
ADMX 11T304SR-M	<b>8215</b>	0.4	█	205	0.15	4.0	✓	120	0.14	4.0	█	190	0.15	4.0	-	-	-	✓	50	0.12	3.2	-	-	-
	<b>M8310</b>	0.4	█	220	0.15	4.0	✓	110	0.14	4.0	█	205	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	0.4	█	205	0.15	4.0	█	120	0.14	4.0	█	190	0.15	4.0	-	-	-	✓	50	0.12	3.2	-	-	-
	<b>M8340</b>	0.4	█	185	0.15	4.0	█	110	0.14	4.0	✓	175	0.15	4.0	-	-	-	✓	45	0.12	3.2	-	-	-
	<b>M9325</b>	0.4	█	255	0.15	4.0	-	-	-	-	█	240	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M9340</b>	0.4	█	235	0.15	4.0	█	140	0.14	4.0	-	-	-	-	-	-	-	✓	55	0.12	3.2	-	-	-
ADMX 11T308SR-M	<b>8215</b>	0.8	█	245	0.15	4.0	✓	145	0.14	4.0	█	230	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-
	<b>M5315</b>	0.8	✓	335	0.15	4.0	-	-	-	-	█	315	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M8310</b>	0.8	█	265	0.15	4.0	✓	135	0.14	4.0	█	250	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	0.8	█	245	0.15	4.0	█	145	0.14	4.0	█	230	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-
	<b>M8340</b>	0.8	█	220	0.15	4.0	█	130	0.14	4.0	✓	205	0.15	4.0	-	-	-	✓	55	0.12	3.2	-	-	-
	<b>M9315</b>	0.8	█	330	0.15	4.0	-	-	-	-	█	310	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M9325</b>	0.8	█	305	0.15	4.0	-	-	-	-	█	285	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M9340</b>	0.8	█	275	0.15	4.0	█	165	0.14	4.0	-	-	-	-	-	-	-	✓	65	0.12	3.2	-	-	-
ADMX 11T310SR-M	<b>M8330</b>	1.0	█	255	0.15	4.0	█	150	0.14	4.0	█	240	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-
	<b>M8340</b>	1.0	█	230	0.15	4.0	█	135	0.14	4.0	✓	215	0.15	4.0	-	-	-	✓	55	0.12	3.2	-	-	-
ADMX 11T312SR-M	<b>8215</b>	1.2	█	255	0.15	4.0	✓	150	0.14	4.0	█	240	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-
	<b>M8330</b>	1.2	█	255	0.15	4.0	█	150	0.14	4.0	█	240	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-
	<b>M8340</b>	1.2	█	230	0.15	4.0	█	135	0.14	4.0	✓	215	0.15	4.0	-	-	-	✓	55	0.12	3.2	-	-	-
ADMX 11T316SR-M	<b>8215</b>	1.6	█	270	0.15	4.0	✓	160	0.14	4.0	█	255	0.15	4.0	-	-	-	✓	65	0.12	3.2	-	-	-
	<b>M6330</b>	1.6	█	230	0.15	4.0	█	165	0.14	4.0	-	-	-	-	-	-	✓	65	0.12	3.2	-	-	-	
	<b>M8310</b>	1.6	█	295	0.15	4.0	✓	150	0.14	4.0	█	280	0.15	4.0	-	-	-	-	-	-	-	-	-	-
	<b>M8330</b>	1.6	█	270	0.15	4.0	█	160	0.14	4.0	█	255	0.15	4.0	-	-	-	✓	65	0.12	3.2	-	-	-
	<b>M8340</b>	1.6	█	240	0.15	4.0	█	140	0.14	4.0	✓	225	0.15	4.0	-	-	-	✓	60	0.12	3.2	-	-	-



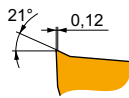
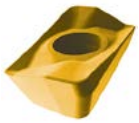
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



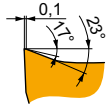
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 11T320SR-M	M6330	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8330	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	–	70	0.12	3.2	–	–	–
	M8340	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T325SR-M	M6330	2.5	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8340	2.5	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T330SR-M	M6330	3.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8330	3.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	–	70	0.12	3.2	–	–	–
	M8340	3.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	–	60	0.12	3.2	–	–	–



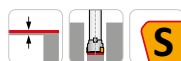
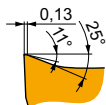
R geometria s pozitívnym prevedením pre obrábanie v menej stabilných podmienkach.

ADMX 11T308PR-R	8215	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.15	1.0
	M5315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0
	M8310	0.8	250	0.18	4.0	125	0.16	4.0	235	0.18	4.0	–	–	–	–	–	–	50	0.15	1.0
	M8330	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.15	1.0
	M8340	0.8	210	0.18	4.0	125	0.16	4.0	195	0.18	4.0	–	–	–	50	0.16	3.2	–	–	–
	M9315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0
ADMX 11T316PR-R	M9325	0.8	290	0.18	4.0	–	–	–	275	0.18	4.0	–	–	–	–	–	–	55	0.15	1.0
	8215	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.15	1.0
	M8330	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.15	1.0
	M9325	1.6	320	0.18	4.0	–	–	–	300	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0



MF geometria s veľmi pozitívnym prevedením pre ľahké až dokončovacie obrábanie.

ADMX 11T304SR-MF	M6330	0.4	215	0.08	2.5	150	0.07	2.5	–	–	–	–	–	–	60	0.06	2.0	–	–	–
	M8340	0.4	220	0.08	2.5	130	0.07	2.5	–	–	–	–	–	–	55	0.06	2.0	–	–	–
ADMX 11T308SR-MF	M6330	0.8	255	0.08	2.5	180	0.07	2.5	–	–	–	–	–	–	75	0.06	2.0	–	–	–
	M8340	0.8	265	0.08	2.5	155	0.07	2.5	–	–	–	–	–	65	0.06	2.0	–	–	–	
	M9340	0.8	360	0.08	2.5	215	0.07	2.5	–	–	–	–	–	90	0.06	2.0	–	–	–	



MM geometria s veľmi pozitívnym prevedením pre ľahké až stredné obrábanie.

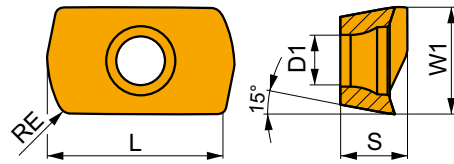
ADMX 11T304SR-MM	M6330	0.4	185	0.14	2.5	130	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
	M8340	0.4	195	0.14	2.5	115	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
	M9340	0.4	250	0.14	2.5	150	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–
ADMX 11T308SR-MM	M6330	0.8	225	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.11	2.0	–	–	–
	M8340	0.8	235	0.14	2.5	140	0.13	2.5	–	–	–	–	–	55	0.11	2.0	–	–	–	
	M8345	0.8	190	0.14	2.5	110	0.13	2.5	–	–	–	–	–	45	0.11	2.0	–	–	–	
ADMX 11T312SR-MM	M9340	0.8	300	0.14	2.5	180	0.13	2.5	–	–	–	–	–	75	0.11	2.0	–	–	–	
	M6330	1.2	235	0.14	2.5	165	0.13	2.5	–	–	–	–	–	70	0.11	2.0	–	–	–	
	M8340	1.2	245	0.14	2.5	145	0.13	2.5	–	–	–	–	–	60	0.11	2.0	–	–	–	
	M9340	1.2	315	0.14	2.5	185	0.13	2.5	–	–	–	–	–	75	0.11	2.0	–	–	–	



# ADEX 11-HF

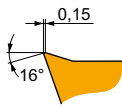


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.450	2.90	10.67	3.82



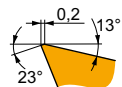
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



HF geometria s veľmi pozitívnym prevedením pre vysokoposuvové obrábanie.

ADEX 11T308SR-HF	vc	f	ap	P			M			K			N			S			H		
				vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
8215	0.8	0.68	0.4	215	0.68	0.4	125	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	
M6330	0.8	0.68	0.4	185	0.68	0.4	130	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	
M8310	0.8	0.68	0.4	220	0.68	0.4	110	0.52	0.4	-	-	-	-	-	-	-	-	-	-	-	
M8330	0.8	0.68	0.4	215	0.68	0.4	125	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	
M8340	0.8	0.68	0.4	200	0.68	0.4	120	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	
M9340	0.8	0.68	0.4	220	0.68	0.4	130	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	



HF2 geometria s pozitívnym prevedením pre vysokoposuvové obrábanie.

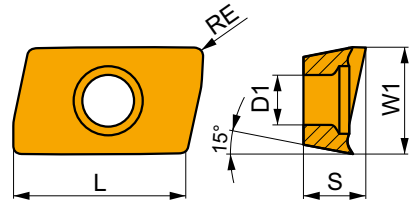
ADEX 11T308SR-HF2	vc	f	ap	P			M			K			N			S			H		
				vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
M8310	0.8	0.68	0.4	220	0.68	0.4	110	0.61	0.4	205	0.68	0.4	-	-	-	-	-	40	0.15	1.0	
M8330	0.8	0.68	0.4	215	0.68	0.4	125	0.61	0.4	200	0.68	0.4	-	-	-	50	0.48	0.3	40	0.15	1.0
M8340	0.8	0.68	0.4	200	0.68	0.4	120	0.61	0.4	190	0.68	0.4	-	-	-	50	0.48	0.3	-	-	-
M9325	0.8	0.68	0.4	250	0.68	0.4	-	-	-	235	0.68	0.4	-	-	-	-	-	50	0.15	1.0	
M9340	0.8	0.68	0.4	220	0.68	0.4	130	0.61	0.4	-	-	-	-	-	55	0.48	0.3	-	-	-	





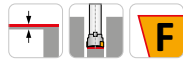
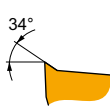
# ADEX 11-FA

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.450	2.90	9.70	3.91



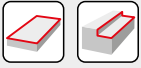
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

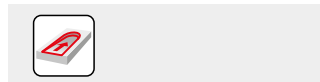
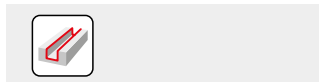
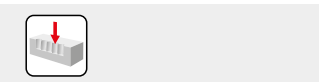
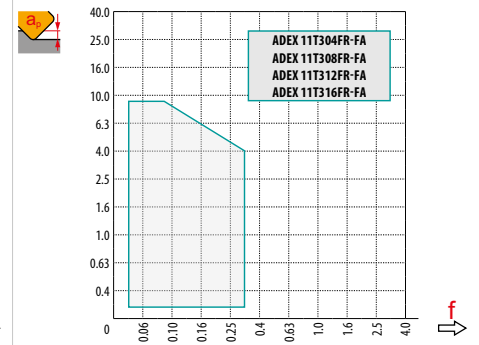
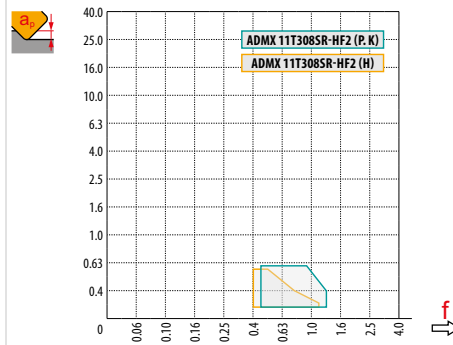
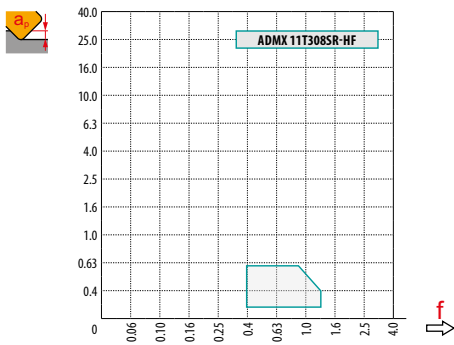
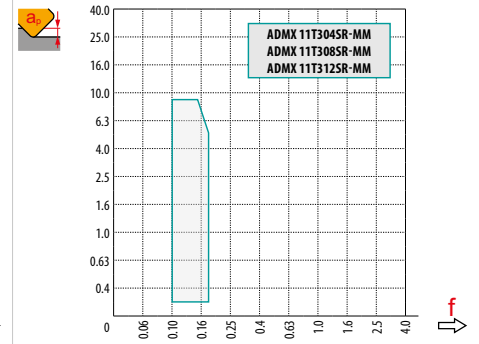
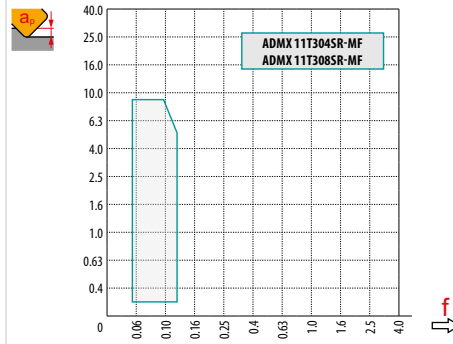
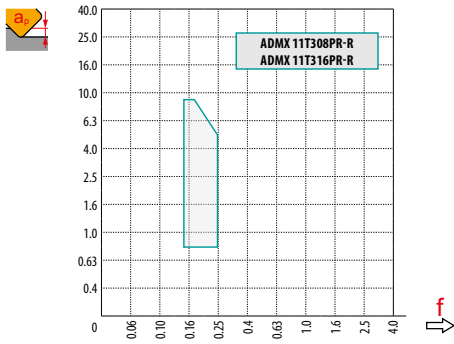
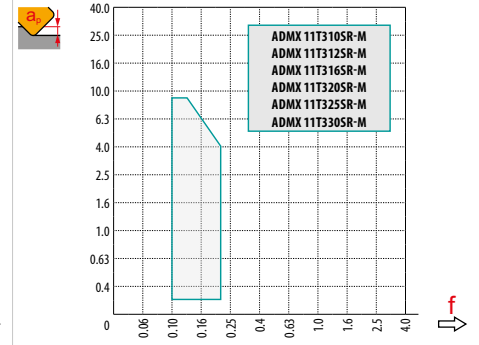
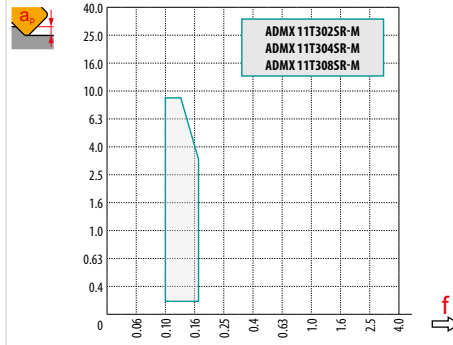
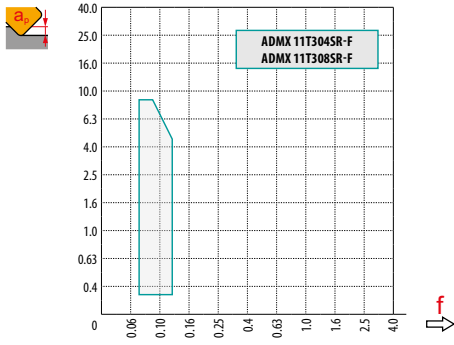
ADEX 11T304FR-FA	HF7	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
	M0315	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308FR-FA	HF7	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
	M0315	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T312FR-FA	HF7	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	M0315	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T316FR-FA	HF7	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



$a_e$ DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

BS	ADMX 11-F		ADMX 11-M								ADMX 11-R		ADMX 11-MF		
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48

BS	ADMX 11-MM				ADEX 11-HF	ADEX 11-HF2	ADEX 11-FA			
RE	0.4	0.8	1.2	1.6	0.8	0.8	0.4	0.8	1.2	1.6
BS	1.89	1.48	1.08	0.61	0.17	0.17	1.77	1.39	1.0	0.62



max  
4.5

	1.0	5.0	9.0
	0.20	0.13	0.10

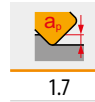
DC	HFC				
	RPMX	APMX/l	RPMX	RPMX	APMX/l
16	13.5	9.0/40	4.1	5.7	0.6/8
18	10.0	9.0/53	2.8	4.5	0.6/12
20	9.0	9.0/59	2.3	4.3	0.6/15
25	6.0	9.0/87	1.3	6.7	0.6/26
32	5.3	9.0/99	0.7	4.3	0.6/49
40	3.8	6.5/100	0.3	2.9	0.6/100
50	2.8	4.7/100	0.1	2.1	0.6/100
63	1.8	3.0/100	-	-	-
80	1.6	2.6/100	-	-	-

\* HFC frézovanie

\*\* Konvenčné frézovanie



DC	HFC							
	DMIN	DMAX	SMAX DMIN	SMAX DMAX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	27.0	32.0	8.3	9.0	21.0	32.0	0.6	0.6
18	32.0	36.0	7.5	9.0	29.0	36.0	0.6	0.6
20	35.0	40.0	7.5	9.0	29.0	40.0	0.6	0.6
25	45.0	50.0	6.5	7.5	39.0	50.0	0.6	0.6
32	59.0	64.0	4.0	4.5	53.0	64.0	0.6	0.6
40	75.0	80.0	1.5	2.0	68.5	80.0	0.6	0.6
50	-	-	-	-	88.5	100.0	0.6	0.6



DC	$\mu\text{m}$	3	5	10	15	20	30	40	50	60	80	100
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

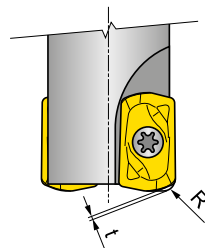
RE	$\mu\text{m}$	3	5	10	15	20	30	40	50	60	80	100
1.0		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

**i**



ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8
ADEX 11T308SR-HF	1.4
ADEX 11T308SR-HF2	1.4

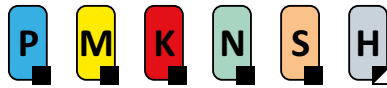
**i**



ADEX 11	R	t
ADEX 11T308SR-HF	1.42	0.35
ADEX 11T308SR-HF2	1.34	0.38



# SAD16E



PRAMET

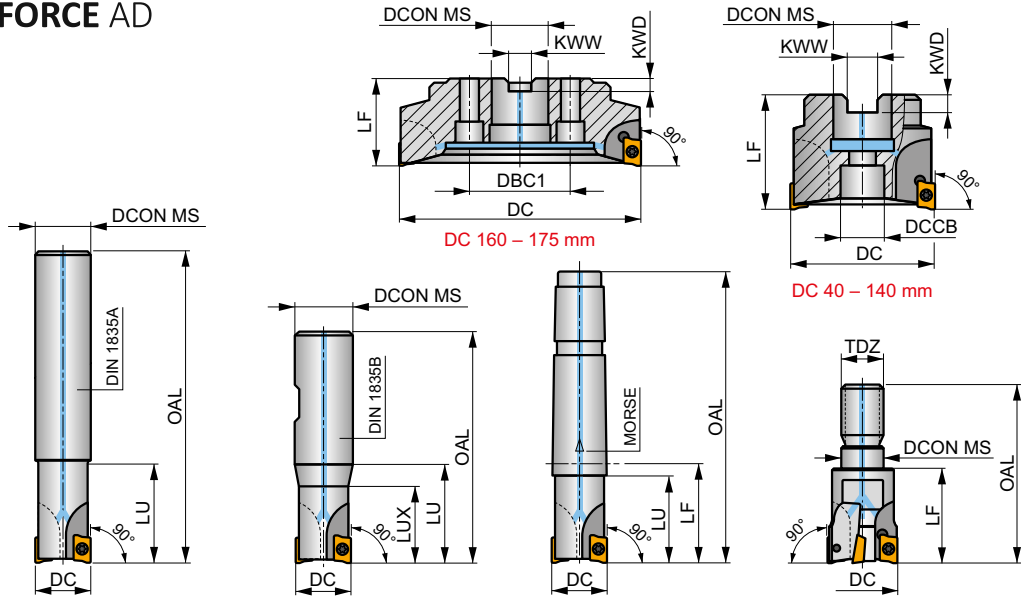
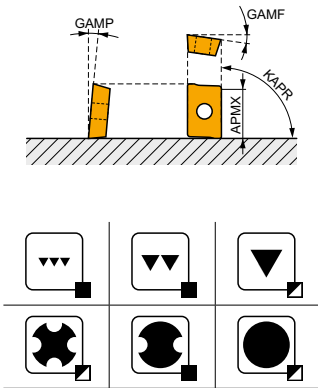


## FORCE AD16 rohová fréza s vnútorným chladením

90° stopkové a nástrčné frézy na pozitívne doštičky AD..16 s APMX 13 mm. Vhodné pre čelné, rohové, drážkovacie, špirálové, trochoidné, zanorovacie a odvrťavacie frézovanie. Dostupné v prevedení s valcovou, Weldon a Morse stopkou, modulárne a nástrčné (s nerovnomernou zubovou roztečou), s priermi Ø 25 až Ø 175 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

### FORCE AD

KAPR	90°
APMX	13.0 mm



	0.08 – 0.22
	0.06 – 0.18



Produkt	DC	OAL	DCON MS	DCCB	DBC1	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			(mm)	(mm)	(°)	(°)			kg	max.			
25A2R033A25-SAD16E-C	25	165	25	-	-	33	-	-	-	-	-	-	-13	5	2	-	18700	✓	0.52	GI165 SQ030	-
25A2R038A25-SAD16E-C	25	200	25	-	-	38	-	-	-	-	-	-	-13	5	2	-	18700	✓	0.71	GI165 SQ030	-
32A3R033A32-SAD16E-C	32	195	32	-	-	33	-	-	-	-	-	-	-12	7	3	-	16500	✓	1.03	GI165 SQ030	-
32A3R048A32-SAD16E-C	32	250	32	-	-	48	-	-	-	-	-	-	-12	7	3	-	16500	✓	1.37	GI165 SQ030	-
25A2R042B25-SAD16E-C	25	98	25	-	-	42	-	-	-	-	-	-	-13	5	2	-	18700	✓	0.29	GI165 SQ030	-
32A3R040B32-SAD16E-C	32	100	32	-	-	40	-	-	-	-	-	-	-12	7	3	-	16500	✓	0.50	GI165 SQ030	-
40A3R050B32-SAD16E-C	40	110	32	-	-	50	-	-	-	-	-	-	-8.2	10.5	3	-	14800	✓	0.59	GI165 SQ030	-
40A4R050B32-SAD16E-C	40	110	32	-	-	50	-	-	-	-	-	-	-8.2	10.5	4	-	14800	✓	0.65	GI165 SQ030	-
25A2R043E03-SAD16E-C	25	98	-	-	-	38	-	43	3	-	-	-	-13	5	2	-	18600	✓	0.31	GI165 SQ030	-
32A3R043E03-SAD16E-C	32	100	-	-	-	38	-	43	3	-	-	-	-12	7	3	-	16500	✓	0.33	GI165 SQ030	-
40A3R054E04-SAD16E-C	40	110	-	-	-	48	-	54	4	-	-	-	-8.2	10.5	3	-	14700	✓	0.74	GI165 SQ030	-
40A4R054E04-SAD16E-C	40	110	-	-	-	48	-	54	4	-	-	-	-8.2	10.5	4	-	14700	✓	0.70	GI165 SQ030	-
32A3R043M16-SAD16E-C	32	66	17	-	-	-	-	43	M16	-	-	-	-12	7	3	-	-	✓	0.20	GI165 SQ030	-
40A4R043M16-SAD16E-C	40	66	17	-	-	-	-	43	M16	-	-	-	-8.2	10.5	4	-	-	✓	0.27	GI165 SQ030	-
40A04R-S90AD16E-C	40	-	16	14	-	-	-	40	-	-	8.4	5.6	-8.2	10.5	4	-	14700	✓	0.21	GI165 SQ032	-
50A03R-S90AD16E-C	50	-	22	18	-	-	-	40	-	-	10.4	6.3	-7	11	3	-	13200	✓	0.43	GI165 SQ033	-
50A05R-S90AD16E-C	50	-	22	18	-	-	-	40	-	-	10.4	6.3	-7	11	5	✓	13200	✓	0.59	GI165 SQ033	-
63A04R-S90AD16E-C	63	-	22	18	-	-	-	40	-	-	10.4	6.3	-6	12	4	✓	11800	✓	0.62	GI165 SQ033	-
63A06R-S90AD16E-C	63	-	22	18	-	-	-	40	-	-	10.4	6.3	-6	12	6	✓	11800	✓	0.46	GI165 SQ033	-
80A05R-S90AD16E-C	80	-	27	38	-	-	-	50	-	-	12.4	7	-5	12	5	✓	10400	✓	1.01	GI165 SQ031 AC001	-
80A07R-S90AD16E-C	80	-	27	38	-	-	-	50	-	-	12.4	7	-5	13	7	✓	10400	✓	0.97	GI165 SQ031 AC001	-
100A06R-S90AD16E-C	100	-	32	45	-	-	-	50	-	-	14.4	8	-4	12	6	✓	9300	✓	1.89	GI165 SQ031 AC002	-
100A08R-S90AD16E-C	100	-	32	45	-	-	-	50	-	-	14.4	8	-4	12	8	✓	9300	✓	1.69	GI165 SQ031 AC002	-
125A09R-S90AD16E-C	125	-	40	56	-	-	-	63	-	-	16.4	9	-3.8	12	9	✓	8400	✓	3.46	GI165 SQ031 AC003	-
140A08R-S90AD16E-C	140	-	40	56	-	-	-	63	-	-	16.4	9	-3.8	12	8	✓	7900	✓	4.06	GI165 SQ031	-
160C10R-S90AD16E-C	160	-	40	-	66.7	-	-	63	-	-	16.4	9.2	-3.8	10	10	✓	7300	✓	6.04	GI165 SQ036	-
175C10R-S90AD16E-C	175	-	40	-	66.7	-	-	63	-	-	16.4	9.2	-3.8	12	10	✓	7000	✓	7.00	GI165 SQ036	-



GI165	ADMX 1606..	ADEX 1606..

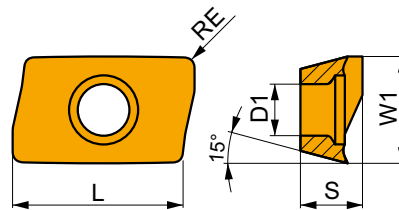
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P	–	–	–	–
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–	–	–	–
SQ032	US 4008-T15P	3.5	M 4	8	D-T08P/T15P	FG-15	–	HS 0830C	–	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C	–	–	–
SQ036	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

## ADMX 16

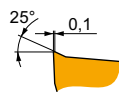
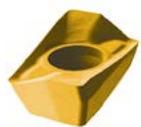


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.25



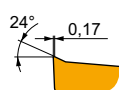
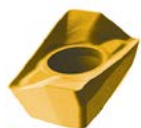
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometria s veľmi pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 160608SR-F	8215	0.8	265	0.15	2.0	155	0.14	2.0	250	0.15	2.0	795	0.18	2.0	65	0.11	1.6	–	–	–
	M8310	0.8	285	0.15	2.0	145	0.14	2.0	270	0.15	2.0	–	–	–	–	–	–	–	–	–
	M8330	0.8	260	0.15	2.0	155	0.14	2.0	245	0.15	2.0	780	0.18	2.0	65	0.11	1.6	–	–	–
	M8340	0.8	235	0.15	2.0	140	0.14	2.0	220	0.15	2.0	–	–	–	55	0.11	1.6	–	–	–
	M9340	0.8	300	0.15	2.0	180	0.14	2.0	–	–	–	–	–	–	75	0.11	1.6	–	–	–



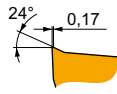
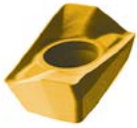
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 160604SR-M	8215	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
	M8330	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
	M8340	0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	–	–	–	40	0.13	4.0	–	–	–



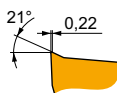
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



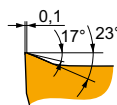
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 160608SR-M	8215	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-	
	M5315	0.8	305	0.18	5.0	-	-	-	285	0.18	5.0	-	-	-	-	-	-	-	-	-	
	M8310	0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	-	-	-	-	-	-	-	-	-	
	M8330	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-	
	M8340	0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	-	-	-	50	0.13	4.0	-	-	-	
	M9315	0.8	305	0.18	5.0	-	-	-	285	0.18	5.0	-	-	-	-	-	-	-	-	-	-
	M9325	0.8	280	0.18	5.0	-	-	-	265	0.18	5.0	-	-	-	-	-	-	-	-	-	-
	M9340	0.8	255	0.18	5.0	150	0.16	5.0	-	-	-	-	-	-	60	0.13	4.0	-	-	-	
	ADMX 160616SR-M	8215	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
M8310		1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	-	-	-	-	-	-	-	-	-	
M8330		1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	
M8340		1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-	
M9325		1.6	310	0.18	5.0	-	-	-	290	0.18	5.0	-	-	-	-	-	-	-	-	-	
ADMX 160620SR-M	M6330	2.0	225	0.18	5.0	155	0.16	5.0	-	-	-	-	-	-	65	0.13	4.0	-	-	-	
	M8330	2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-	
	M8340	2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	
ADMX 160630SR-M	M8330	3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-	
	M8340	3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	
ADMX 160632SR-M	M6330	3.2	225	0.18	5.0	155	0.16	5.0	-	-	-	-	-	-	65	0.13	4.0	-	-	-	
	M8330	3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-	
	M8340	3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	
	M9325	3.2	325	0.18	5.0	-	-	-	305	0.18	5.0	-	-	-	-	-	-	-	-	-	
ADMX 160640SR-M	M6330	4.0	225	0.18	5.0	155	0.16	5.0	-	-	-	-	-	-	65	0.13	4.0	-	-	-	
	M8330	4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-	
	M8340	4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	
ADMX 160650SR-M	M8330	5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-	
	M8340	5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-	



R geometria s pozitívnym prevedením pre stredne až menej stabilné podmienky obrábania.

ADMX 160608PR-R	8215	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.15	1.0
	M5315	0.8	260	0.25	6.0	-	-	-	245	0.25	6.0	-	-	-	-	-	-	50	0.15	1.0
	M8310	0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	-	-	-	-	-	-	40	0.15	1.0
	M8330	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.15	1.0
	M8340	0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	-	-	-	45	0.20	4.8	-	-	-
	M9315	0.8	265	0.25	6.0	-	-	-	250	0.25	6.0	-	-	-	-	-	-	50	0.15	1.0
	M9325	0.8	250	0.25	6.0	-	-	-	235	0.25	6.0	-	-	-	-	-	-	50	0.15	1.0
ADMX 160616PR-R	M5315	1.6	290	0.25	6.0	-	-	-	275	0.25	6.0	-	-	-	-	-	-	55	0.15	1.0
	M8330	1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	-	-	-	55	0.20	4.8	45	0.15	1.0
	M8340	1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	-	-	-	50	0.20	4.8	-	-	-
	M9315	1.6	295	0.25	6.0	-	-	-	280	0.25	6.0	-	-	-	-	-	-	55	0.15	1.0
	M9325	1.6	275	0.25	6.0	-	-	-	260	0.25	6.0	-	-	-	-	-	-	55	0.15	1.0



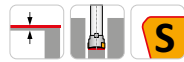
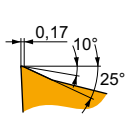
MF geometria s veľmi pozitívnym prevedením pre dokončovacie obrábanie.

ADMX 160608SR-MF	M6330	0.8	215	0.08	4.0	150	0.07	4.0	-	-	-	-	-	-	60	0.06	3.2	-	-	-
	M8340	0.8	225	0.08	4.0	135	0.07	4.0	-	-	-	-	-	-	55	0.06	3.2	-	-	-
	M9340	0.8	305	0.08	4.0	180	0.07	4.0	-	-	-	-	-	-	75	0.06	3.2	-	-	-



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



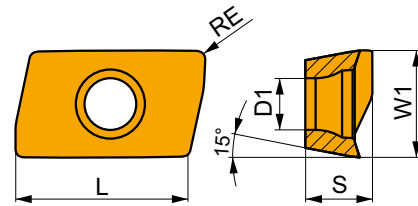
MM geometria s veľmi pozitívnym prevedením pre ľahké až stredné obrábanie.

ADMX 160604SR-MM	M6330	0.4	145	0.18	4.0	105	0.16	4.0	—	—	—	—	—	—	40	0.14	3.2	—	—	—
	M8340	0.4	160	0.18	4.0	95	0.16	4.0	—	—	—	—	—	—	40	0.14	3.2	—	—	—
ADMX 160608SR-MM	M6330	0.8	175	0.18	4.0	125	0.16	4.0	—	—	—	—	—	—	50	0.14	3.2	—	—	—
	M8340	0.8	190	0.18	4.0	110	0.16	4.0	—	—	—	—	—	—	45	0.14	3.2	—	—	—
	M8345	0.8	150	0.18	4.0	90	0.16	4.0	—	—	—	—	—	—	35	0.14	3.2	—	—	—
ADMX 160616SR-MM	M9340	0.8	235	0.18	4.0	140	0.16	4.0	—	—	—	—	—	—	55	0.14	3.2	—	—	—
	M6330	1.6	195	0.18	4.0	140	0.16	4.0	—	—	—	—	—	—	55	0.14	3.2	—	—	—
	M8340	1.6	210	0.18	4.0	125	0.16	4.0	—	—	—	—	—	—	50	0.14	3.2	—	—	—
	M8345	1.6	165	0.18	4.0	95	0.16	4.0	—	—	—	—	—	—	40	0.14	3.2	—	—	—
	M9340	1.6	260	0.18	4.0	155	0.16	4.0	—	—	—	—	—	—	65	0.14	3.2	—	—	—

## ADEX 16

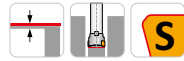
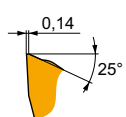


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



FM geometria s veľmi pozitívnym prevedením pre stredné obrábanie.

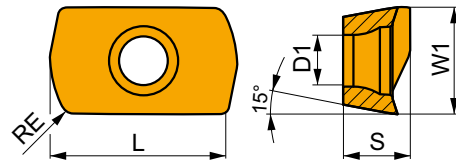
ADEX 160608SR-FM	8215	0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	—	—	—	65	0.11	1.6	—	—	—
	M8330	0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	—	—	—	60	0.11	1.6	—	—	—
	M8340	0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	—	—	—	55	0.11	1.6	—	—	—





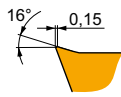
# ADEX 16-HF

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	5.88



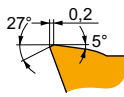
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



HF geometria s veľmi pozitívnym prevedením pre vysokoposuvové obrábanie.

ADEX 160612SR-HF		1.2	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
<b>8215</b>		1.2	195	1.00	0.6	115	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-	
<b>M8310</b>		1.2	205	1.00	0.6	100	0.77	0.6	-	-	-	-	-	-	-	-	-	-	-	
<b>M8330</b>		1.2	200	1.00	0.6	120	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-	
<b>M8340</b>		1.2	185	1.00	0.6	110	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-	
<b>M9340</b>		1.2	195	1.00	0.6	115	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-	



HF2 geometria s pozitívnym prevedením pre vysokoposuvové obrábanie.

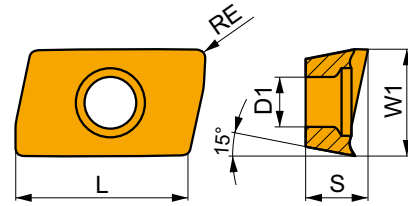
ADEX 160612SR-HF2		1.2	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
<b>M8310</b>		1.2	225	0.70	0.6	110	0.63	0.6	210	0.70	0.6	-	-	-	-	-	-	45	0.15	1.0
<b>M8330</b>		1.2	215	0.70	0.6	125	0.63	0.6	200	0.70	0.6	-	-	-	50	0.63	0.5	40	0.15	1.0
<b>M8340</b>		1.2	205	0.70	0.6	120	0.63	0.6	190	0.70	0.6	-	-	-	50	0.63	0.5	-	-	-
<b>M9325</b>		1.2	245	0.70	0.6	-	-	-	230	0.70	0.6	-	-	-	-	-	-	45	0.15	1.0
<b>M9340</b>		1.2	215	0.70	0.6	125	0.63	0.6	-	-	-	-	-	-	50	0.63	0.5	-	-	-



# ADEX 16-FA

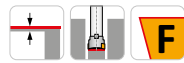
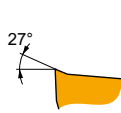


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.17



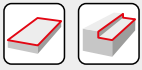
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

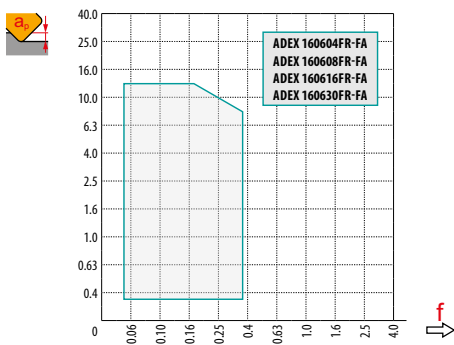
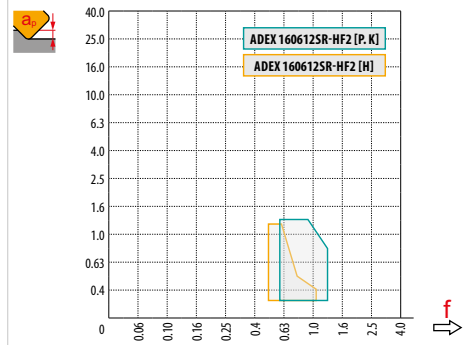
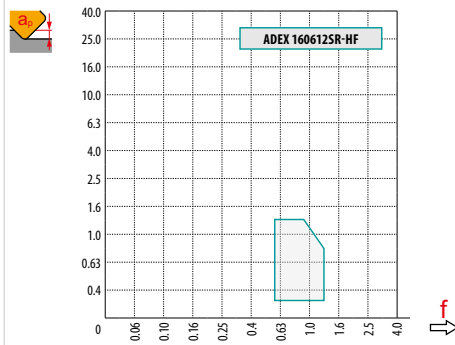
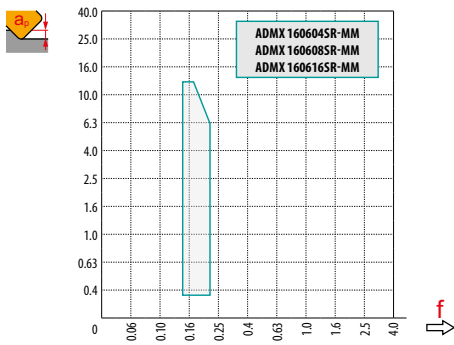
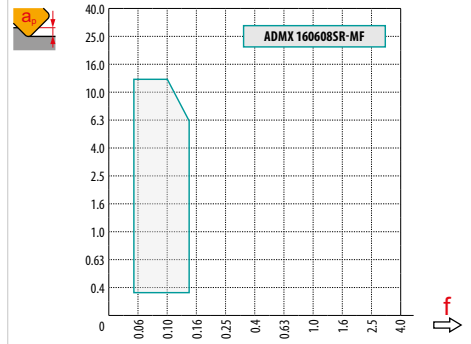
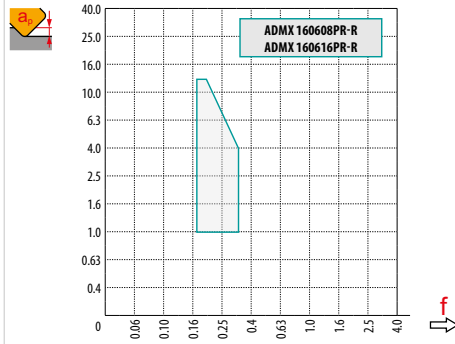
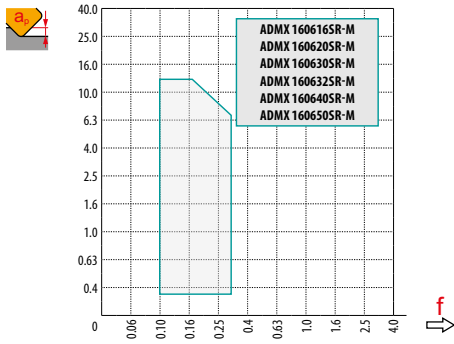
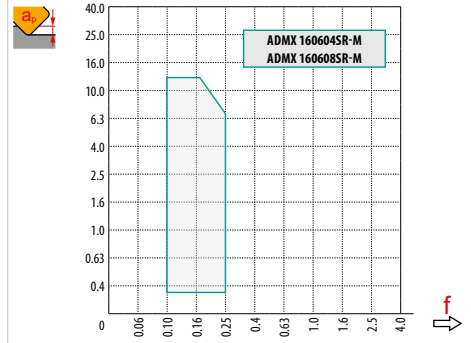
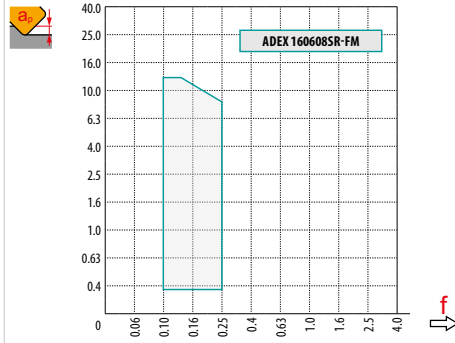
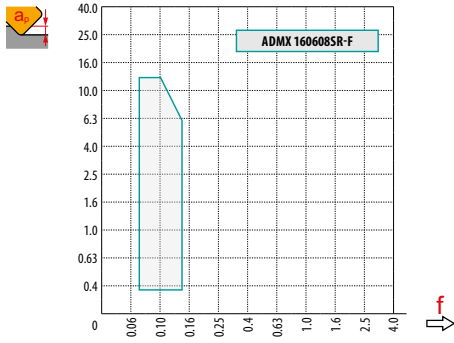
ADEX 160604FR-FA	HF7	0.4	–	–	–	–	–	–	–	–	■	195	0.28	6.0	–	–	–	–	–	–
	M0315	0.4	–	–	–	–	–	–	–	–	■	480	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA	HF7	0.8	–	–	–	–	–	–	–	–	■	240	0.28	6.0	–	–	–	–	–	–
	M0315	0.8	–	–	–	–	–	–	–	–	■	570	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA	HF7	1.6	–	–	–	–	–	–	–	–	■	255	0.28	6.0	–	–	–	–	–	–
	M0315	1.6	–	–	–	–	–	–	–	–	■	630	0.28	6.0	–	–	–	–	–	–
ADEX 160630FR-FA	HF7	3.0	–	–	–	–	–	–	–	–	■	270	0.28	6.0	–	–	–	–	–	–



$a_s$ DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

	ADMX 16-MF	ADMX 16-MM			ADEX 16-HF	ADEX 16-HF2	ADEX 16-FA			
	0.8	0.4	0.8	1.6	1.2	1.2	0.4	0.8	1.6	3.0
	2.99	3.39	2.99	1.62	0.52	0.52	2.84	2.44	1.65	0.69



max  
7.5



	1.0	6.0	13.0
	0.28	0.19	0.10



DC	HFC				
	RPMX	APMX/I	RPMX	RPMX	APMX/I
25	12.5	13.0/60	4.0	8.0	1.3/19
32	7.5	13.0/100	2.0	7.5	1.3/38
40	5.0	8.6/100	1.2	4.5	1.3/65
50	3.5	6.0/100	0.8	3.0	1.3/100
63	2.5	4.2/100	0.5	2.0	0.8/100
80	2.0	3.3/100	0.4	1.5	0.6/100

\* HFC frézovanie

\*\* Konvenčné frézovanie



2.5

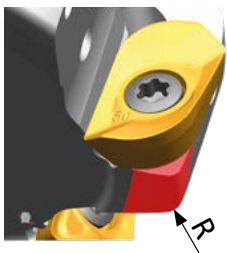
DC					HFC			
	DMIN	DMAX	SMAX DMIN	SMAX DMAX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	42.0	50.0	10.0	12.5	42.0	50.0	1.3	1.3
32	55.0	64.0	6.5	9.0	55.0	64.0	1.3	1.3
40	72.0	80.0	5.0	8.0	72.0	80.0	1.3	1.3
50	92.0	100.0	4.5	6.0	92.0	100.0	1.3	1.3
63	118.0	126.0	4.0	5.0	118.0	126.0	1.3	1.3
80	136.0	160.0	1.5	2.0	136.0	160.0	1.3	1.3



DC	$\mu\text{m}$	3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

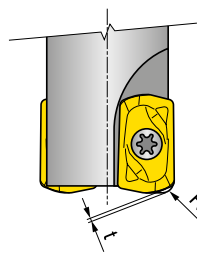
RE	$\mu\text{m}$	3	5	10	15	20	30	40	50	60	80	100
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
3.2		0.277	0.358	0.506	0.620	0.716	0.876	1.012	1.131	1.239	1.431	1.600
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

**i**



ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5
ADEX 160612SR-HF	3.0
ADEX 160612SR-HF2	3.0

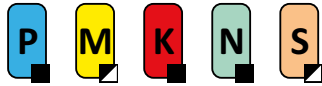
**i**



ADEX 16	R	t
ADEX 160612SR-HF	2.59	0.56
ADEX 160612SR-HF2	2.48	0.57



# SAP10D



PRAMET

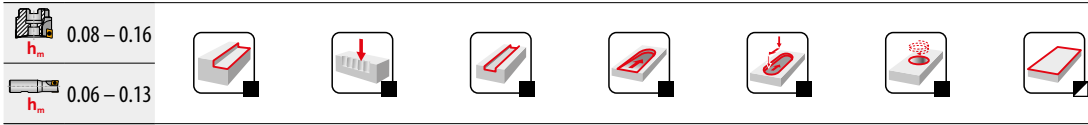
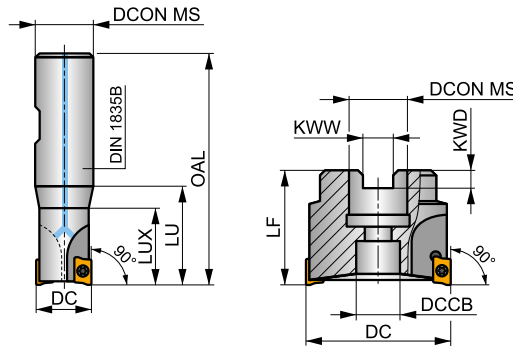
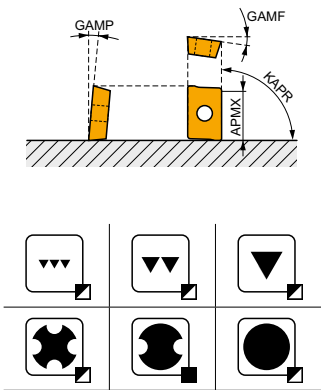
S



## Rohová fréza pre doštičky APKT 10 s vnútorným chladením

90° stopkové a nástrčné frézy na pozitívne doštičky APKT 10 s APMX 9 mm. Vhodné pre čelné, rohové, drážkovacie, špirálové, trochoidné, zanorovacie a odvrťavacie frézovanie. Dostupné v prevedení s Weldon stopkou a nástrčné (s nerovnomernou zubovou roztečou), s priermi Ø 10 až Ø 63 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	90°
APMX	9.0 mm



Produkt	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	��	��	max.	kg	GI081	SQ215
10A1R020B16-SAP10D-C	10	78	16	-	30	20	-	-	-	12	2	1	-	39000	✓	0.09	GI081 SQ215
12A1R027B16-SAP10D-C	12	75	16	-	27	-	-	-	-	12	2	1	-	35600	✓	0.10	GI081 SQ210
14A1R027B16-SAP10D-C	14	75	16	-	27	-	-	-	-	12	2	1	-	32900	✓	0.13	GI081 SQ210
16A2R032B16-SAP10D-C	16	80	16	-	32	-	-	-	-	12	4	2	-	30800	✓	0.12	GI081 SQ210
18A2R032B20-SAP10D-C	18	82	20	-	32	-	-	-	-	12	4	2	-	29100	✓	0.15	GI081 SQ210
20A3R032B20-SAP10D-C	20	82	20	-	32	-	-	-	-	12	4	3	-	27600	✓	0.15	GI081 SQ210
25A3R042B25-SAP10D-C	25	98	25	-	42	-	-	-	-	12	4	3	-	24700	✓	0.36	GI081 SQ210
40A6R-S90AP10D	40	40	16	14	40	-	-	8.4	5.6	8	3	6	✓	19500	-	0.23	GI081 SQ211
50A7R-S90AP10D	50	40	22	18	40	-	-	10.4	6.3	8	3	7	✓	17400	-	0.41	GI081 SQ211
63A9R-S90AP10D	63	50	22	18	40	-	-	10.4	6.3	8	3	9	✓	15500	-	0.57	GI081 SQ211

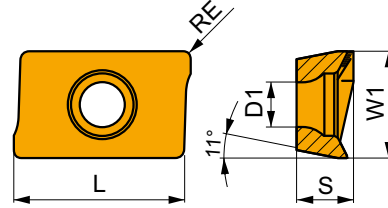
GI081	APKT 1003..
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	Nm					
SQ210	US 2506-T07P	1.2	M 2.5	6.3	-	Flag T07P
SQ211	US 2506-T07P	1.2	M 2.5	6.3	D-T07P/T09P	FG-15
SQ215	US 2505-T07P	1.2	M 2.5	5.2	-	Flag T07P



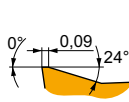
## APKT 10

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1003	6.700	2.88	11.00	3.50



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

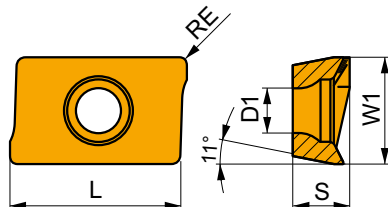


M geometria s veľmi pozitívnym prevedením pre ľahké až stredné obrábanie.

APKT 1003PDER-M	8215	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	-	-	-	70	0.11	3.2	-	-	-	
	M8330	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	-	-	-	70	0.11	3.2	-	-	-	
	M8340	0.5	255	0.12	4.0	150	0.11	4.0	240	0.12	4.0	-	-	-	60	0.11	3.2	-	-	-	
	M9315	0.5	400	0.12	4.0	-	-	-	380	0.12	4.0	-	-	-	-	-	-	-	-	-	-
	M9325	0.5	360	0.12	4.0	-	-	-	340	0.12	4.0	-	-	-	-	-	-	-	-	-	-
	M9340	0.5	335	0.12	4.0	200	0.11	4.0	-	-	-	-	-	-	80	0.11	3.2	-	-	-	

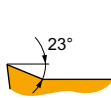
## APKT 10-FA

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1003	6.700	2.88	11.00	3.50



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



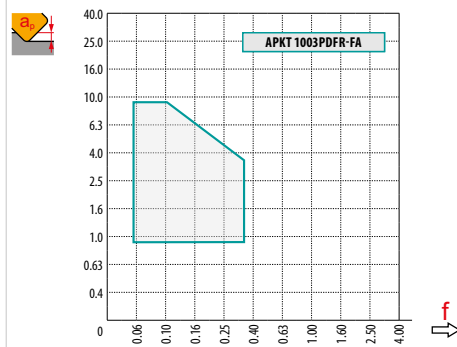
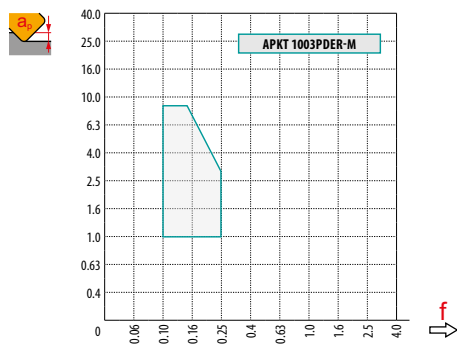
FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

APKT 1003PDFR-FA	HF7	0.5	-	-	-	-	-	-	300	0.18	5.0	-	-	-	-	-	-	-	-	-
------------------	-----	-----	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---	---



$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 10-M	APKT 10-FA
	0.5	0.5
	0.84	0.84



	4.5

	1.0	3.0	5.0
	0.20	0.13	0.10

DC	RPMX	APMX/I
10	7.3	9.0/72
12	6.2	9.0/84
14	5.3	9.0/99
16	2.4	4.0/100
18	2.3	3.9/100
20	2.2	3.7/100
25	2.2	3.7/100
32	1.6	2.6/100

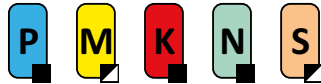
DC	DMIN	DMAX		
10	11.0	20.0	0.4	3.8
12	13.0	24.0	0.3	3.9
14	17.5	28.0	1.0	3.9
16	20.5	32.0	0.6	2.0
18	23.8	36.0	0.7	2.2
20	27.2	40.0	0.9	2.4
25	37.9	50.0	1.6	3.0
32	50.9	64.0	1.7	2.8

	0.3





# SAP16D



PRAMET

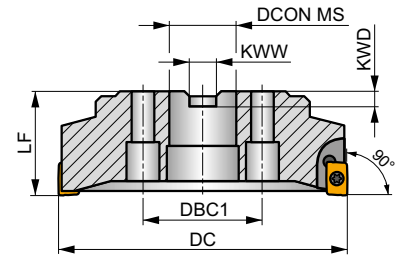
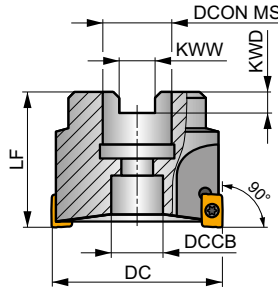
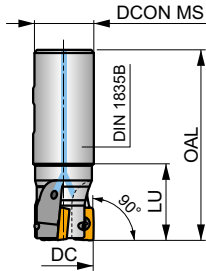
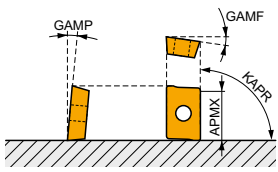
S



## Rohová fréza pre doštičky APKT 16 s vnútorným chladením

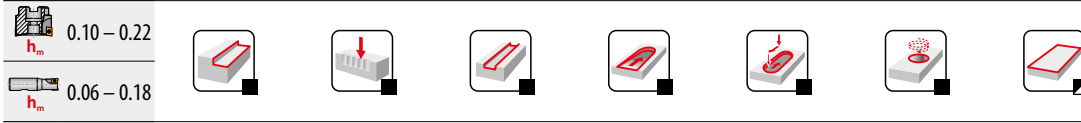
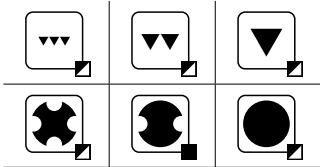
90° stopkové a nástrčné frézy na pozitívne doštičky APKT 16 s APMX 13 mm. Vhodné pre čelné, rohové, drážkovacie, špirálové, trochoidné, zanorovacie a odvrťavacie frézovanie. Dostupné v prevedení s Weldon stopkou a nástrčné (s nerovnomernou zubovou roztečou), s priemerom  $\varnothing$  25 až  $\varnothing$  160 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	90°
APMX	13.0 mm



DC 40 – 125 mm

DC 160 mm



Produkt	DC	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
25A2R042B25-SAP16D-C	25	98	25	-	-	42	-	-	-	0	6	2	-	16800	✓	0.31	GI080	SQ030	-
32A3R040B32-SAP16D-C	32	100	32	-	-	50	-	-	-	0	8	3	-	14800	✓	0.51	GI080	SQ220	-
40A3R050B32-SAP16D-C	40	110	32	-	-	50	-	-	-	0	8	3	-	13200	✓	0.65	GI080	SQ220	-
40A4R050B32-SAP16D-C	40	110	32	-	-	50	-	-	-	0	8	4	-	13200	✓	0.67	GI080	SQ220	-
40A4R-S90AP16D	40	40	16	11	-	-	40	8.4	5.6	0	6	4	✓	13200	-	0.23	GI080	SQ031	-
50A5R-S90AP16D	50	40	22	18	-	-	40	10.4	6.3	0	6	5	✓	11800	-	0.33	GI080	SQ031	-
63A6R-S90AP16D	63	40	22	18	-	-	40	10.4	6.3	0	6	6	✓	10600	-	0.50	GI080	SQ031	-
80B5R-S90AP16D	80	50	27	38	-	-	50	12.4	7	0	6	5	✓	9400	-	0.97	GI080	SQ031	AC001
80B7R-S90AP16D	80	50	27	38	-	-	50	12.4	7	0	6	7	✓	9400	-	1.07	GI080	SQ031	AC001
100B6R-S90AP16D	100	50	32	45	-	-	50	14.4	8	0	6	6	✓	8400	-	1.60	GI080	SQ031	AC002
100B8R-S90AP16D	100	50	32	45	-	-	50	14.4	8	0	6	8	✓	8400	-	1.50	GI080	SQ031	AC002
125B9R-S90AP16D	125	63	40	56	-	-	63	16.4	9	0	6	9	✓	7500	-	2.80	GI080	SQ031	AC003
160C10R-S90AP16D	160	63	40	-	66.7	-	63	16.4	9	0	6	10	✓	6600	-	5.12	GI080	SQ031	-

GI080	APKT 1604..	APET 1604..

SQ030	US 4008-T15P	3.5	M 4	8	-	-	Flag T15P
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	-
SQ220	US 4011-T15P	3.5	M 4	10.6	-	-	Flag T15P

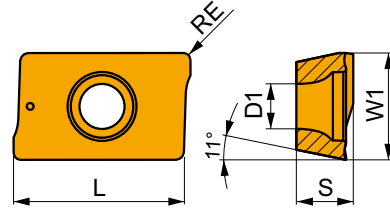


AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

## APKT 16

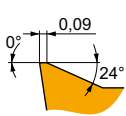


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.440	4.60	17.00	5.67



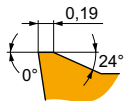
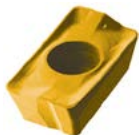
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



GM geometria s veľmi pozitívnym prevedením pre ľahké až stredné obrábanie.

APKT 1604PDR-GM	M8330	0.8	235	0.20	8.0	140	0.18	8.0	220	0.20	8.0	—	—	—	55	0.16	6.4	—	—	—
	M8340	0.8	210	0.20	8.0	125	0.18	8.0	195	0.20	8.0	—	—	—	50	0.16	6.4	—	—	—
	M9315	0.8	310	0.20	8.0	—	—	—	290	0.20	8.0	—	—	—	—	—	—	—	—	—
	M9325	0.8	285	0.20	8.0	—	—	—	270	0.20	8.0	—	—	—	—	—	—	—	—	—
	M9340	0.8	260	0.20	8.0	155	0.18	8.0	—	—	—	—	—	—	65	0.16	6.4	—	—	—



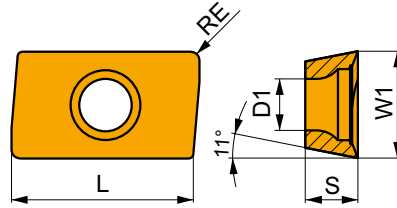
HM geometria s veľmi pozitívnym prevedením pre stredné obrábanie a menej stabilné podmienky.

APKT 160404-HM	M8340	0.4	160	0.30	6.0	95	0.27	6.0	150	0.30	6.0	—	—	—	40	0.24	4.8	—	—	—
APKT 160416-HM	M8340	1.6	210	0.30	6.0	125	0.27	6.0	195	0.30	6.0	—	—	—	50	0.24	4.8	—	—	—
APKT 160431-HM	M8340	3.1	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
APKT 1604PDR-HM	8215	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
	M5315	0.8	270	0.30	6.0	—	—	—	255	0.30	6.0	—	—	—	—	—	—	—	—	—
	M8330	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
	M8340	0.8	200	0.30	6.0	120	0.27	6.0	190	0.30	6.0	—	—	—	50	0.24	4.8	—	—	—
	M9315	0.8	275	0.30	6.0	—	—	—	260	0.30	6.0	—	—	—	—	—	—	—	—	—
M9325	0.8	260	0.30	6.0	—	—	—	245	0.30	6.0	—	—	—	—	—	—	—	—	—	—



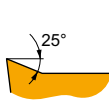
# APET 16-FA

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.600	4.50	17.00	4.76



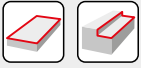
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



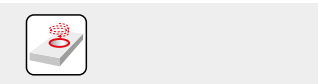
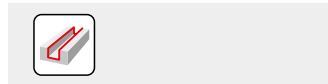
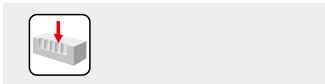
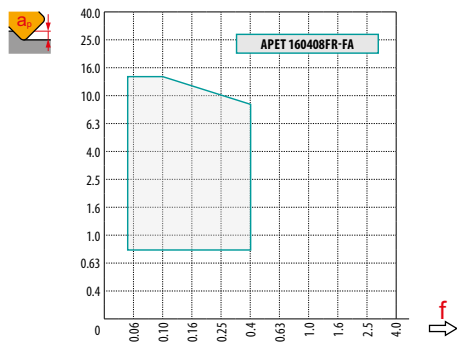
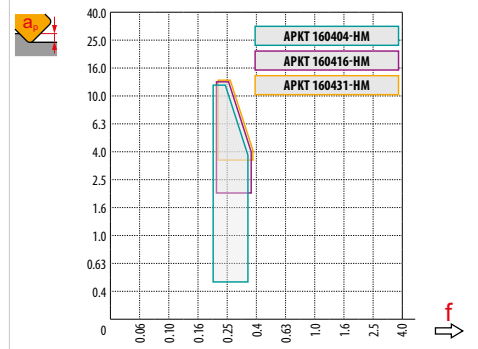
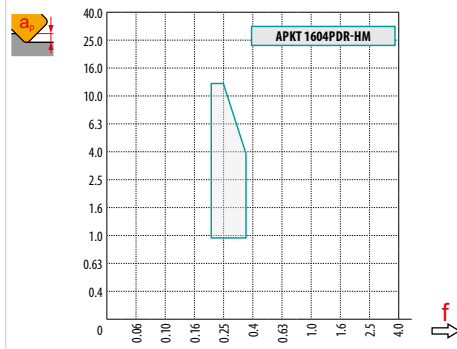
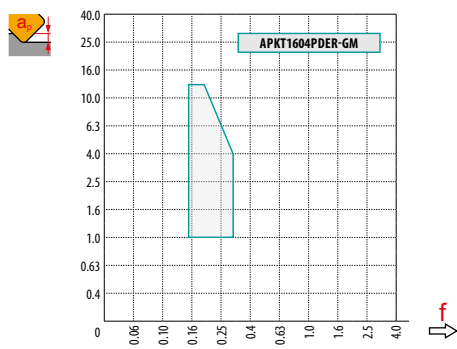
FA geometria s veľmi pozitívnym prevedením pre jemné dokončovanie až stredné obrábanie.

APET 160408FR-FA	HF7	0.8	-	-	-	-	-	-	-	-	255	0.24	8.0	-	-	-	-	-	-
------------------	-----	-----	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---



$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 16-GM	APKT 16-HM				APET 16-FA
	0.8	0.8	0.4	1.6	3.1	0.8
	1.39	1.48	1.87	0.64	1.30	1.59



	7.4
--	-----

	1.0	6.0	13.0
	0.28	0.19	0.13

	DMIN	DMAX		
25	34.7	50.0	1.2	3.1
32	48.5	64.0	0.9	1.7
40	63.5	80.0	1.3	2.2
50	83.5	100.0	0.9	1.4
63	110.0	126.0	1.0	1.4
80	144.0	160.0	1.1	1.3

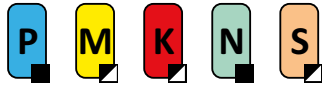


	RPMX	APMX/I
<b>25</b>	2.3	3.9/100
<b>32</b>	1.0	1.6/100
<b>40</b>	1.0	1.6/100
<b>50</b>	0.5	0.7/100
<b>63</b>	0.4	0.5/100
<b>80</b>	0.3	0.4/100

**0.2**



# STN10



PRAMET

S

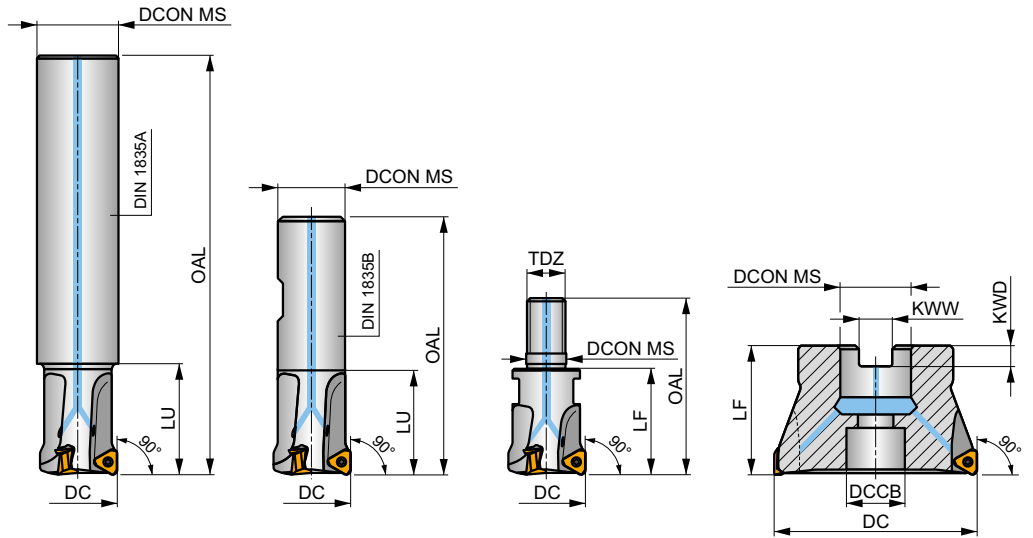
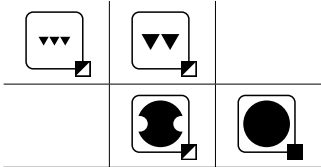
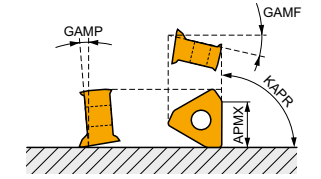


## ECON TN10 rohová fréza s vnútorným chladením

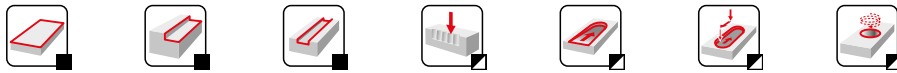
90° stopkové a nástrčné frézy na obojstranné dosičky TNGX 10 so šiestimi reznými hranami a APMX 5 mm. Vhodné pre široký rozsah aplikácií. Dostupné v prevedení s valcovou a Weldon stopkou, modulárne a nástrčné, s priermi Ø 18 až Ø 80 mm, s alebo bez nerovnomernej zubovej rozteče. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

## ECON TN

KAPR	90°
APMX	5.0 mm



	0.03 – 0.08
	0.03 – 0.06



Produkt	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg	G1292	SQ300	-	
																	(mm)
18A2R050A20-STN10-C	18	180	20	-	50	-	-	-	-	-17.1	-11	2	-	29100	✓	0.40	GI292 SQ300 -
20A2R029A20-STN10-C	20	150	20	-	29	-	-	-	-	-16.5	-11	2	-	27600	✓	0.35	GI292 SQ300 -
20A3R029A20-STN10-C	20	150	20	-	29	-	-	-	-	-16.5	-11	3	-	27600	✓	0.34	GI292 SQ300 -
22A3R050A25-STN10-C	22	180	25	-	50	-	-	-	-	-16.5	-11	3	-	26300	✓	0.59	GI292 SQ300 -
25A3R034A25-STN10-C	25	170	25	-	34	-	-	-	-	-16	-11	3	-	24700	✓	0.58	GI292 SQ300 -
25A4R034A25-STN10-C	25	170	25	-	34	-	-	-	-	-16	-11	4	✓	24700	✓	0.59	GI292 SQ300 -
30A4R050A32-STN10-C	30	200	32	-	50	-	-	-	-	-16	-11	4	✓	22500	✓	1.07	GI292 SQ300 -
32A4R037A32-STN10-C	32	195	32	-	37	-	-	-	-	-16	-11	4	✓	21800	✓	1.09	GI292 SQ300 -
32A5R037A32-STN10-C	32	195	32	-	37	-	-	-	-	-16	-11	5	✓	21800	✓	1.09	GI292 SQ300 -
35A5R080A32-STN10-C	35	200	32	-	80	-	-	-	-	-16	-11	5	✓	20800	✓	0.08	GI292 SQ300 -
20A2R032B20-STN10-C	20	90	20	-	32	-	-	-	-	-16.5	-11	2	-	27600	✓	0.20	GI292 SQ300 -
20A3R032B20-STN10-C	20	90	20	-	32	-	-	-	-	-16.5	-11	3	-	27600	✓	0.20	GI292 SQ300 -
25A3R042B25-STN10-C	25	100	25	-	42	-	-	-	-	-16	-11	3	-	24700	✓	0.31	GI292 SQ300 -
25A4R042B25-STN10-C	25	100	25	-	42	-	-	-	-	-16	-11	4	✓	24700	✓	0.31	GI292 SQ300 -
32A4R042B32-STN10-C	32	110	32	-	42	-	-	-	-	-16	-11	4	✓	21800	✓	0.57	GI292 SQ300 -
32A5R042B32-STN10-C	32	110	32	-	42	-	-	-	-	-16	-11	5	✓	21800	✓	0.56	GI292 SQ300 -
20A2R026M10-STN10-C	20	45	10.5	-	-	26	M10	-	-	-16.5	-11	2	-	-	✓	0.07	GI292 SQ300 -
20A3R026M10-STN10-C	20	45	10.5	-	-	26	M10	-	-	-16.5	-11	3	-	-	✓	0.07	GI292 SQ300 -
25A3R033M12-STN10-C	25	55	12.5	-	-	33	M12	-	-	-16	-11	3	-	-	✓	0.10	GI292 SQ300 -
25A4R033M12-STN10-C	25	55	12.5	-	-	33	M12	-	-	-16	-11	4	✓	-	✓	0.11	GI292 SQ300 -
32A4R043M16-STN10-C	32	66	17	-	-	43	M16	-	-	-16	-11	4	✓	-	✓	0.22	GI292 SQ300 -
32A5R043M16-STN10-C	32	66	17	-	-	43	M16	-	-	-16	-11	5	✓	-	✓	0.22	GI292 SQ300 -
40A04R-S90TN10-C	40	-	16	14	-	40	-	8.4	5.6	-15	-11	4	✓	19500	✓	0.35	GI292 SQ302 -
40A06R-S90TN10-C	40	-	16	14	-	40	-	8.4	5.6	-15	-11	6	✓	19500	✓	0.34	GI292 SQ302 -
50A05R-S90TN10-C	50	-	22	18	-	40	-	10.4	6.3	-15	-11	5	✓	17400	✓	0.49	GI292 SQ303 -
50A07R-S90TN10-C	50	-	22	18	-	40	-	10.4	6.3	-15	-11	7	✓	17400	✓	0.50	GI292 SQ303 -
63A06R-S90TN10-C	63	-	22	18	-	40	-	10.4	6.3	-15	-11	6	✓	15500	✓	0.63	GI292 SQ303 -



Produkt	DC	OAL	D CON MS	DCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.			kg	Icons			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
<b>63A09R-S90TN10-C</b>	63	-	22	18	-	40	-	10.4	6.3	-15	-11	9	✓	15500	✓	0.64	GI292	SQ303	-
	<b>80A10R-S90TN10-C</b>	80	-	27	38	-	50	-	12.4	7	-15	-11	10	✓	13800	✓	1.11	GI292	SQ301

GI292	TNGX 1004..																					

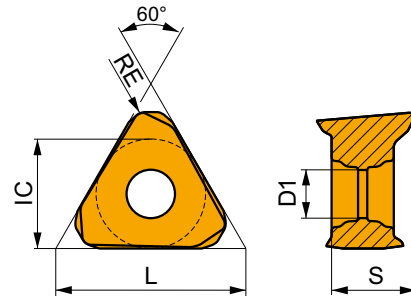
SQ300	US 52506-T07P	0.8	M 2.5	6	-	-	-	-	-	Flag T07P	-
SQ301	US 52506-T07P	0.8	M 2.5	6	-	D-T07P/T09P	FG-15	-	-	-	-
SQ302	US 52506-T07P	0.8	M 2.5	6	-	D-T07P/T09P	FG-15	-	-	-	HS 0830C
SQ303	US 52506-T07P	0.8	M 2.5	6	-	D-T07P/T09P	FG-15	-	-	-	HS 1030C

AC001	KS 1230		K.FMH27

## TNGX 10

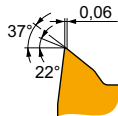


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1004	6.000	2.80	10.39	4.69



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)





F geometria s veľmi pozitívnym prevedením pre ľahké obrábanie.

TNGX 100402SR-F	M8330	0.2	205	0.09	2.0	120	0.08	2.0	190	0.09	2.0	-	-	-	-	-	-	-	-	-
	M8340	0.2	190	0.09	2.0	110	0.08	2.0	180	0.09	2.0	-	-	-	-	-	-	-	-	-
TNGX 100404SR-F	8215	0.4	225	0.09	2.0	135	0.08	2.0	210	0.09	2.0	-	-	-	-	-	-	-	-	-
	M6330	0.4	190	0.09	2.0	135	0.08	2.0	-	-	-	-	-	-	-	-	-	-	-	-
	M8330	0.4	220	0.09	2.0	130	0.08	2.0	205	0.09	2.0	-	-	-	-	-	-	-	-	-
	M8340	0.4	200	0.09	2.0	120	0.08	2.0	190	0.09	2.0	-	-	-	-	-	-	-	-	-
TNGX 100408SR-F	M9340	0.4	270	0.09	2.0	160	0.08	2.0	-	-	-	-	-	-	-	-	-	-	-	-
	8215	0.8	270	0.09	2.0	160	0.08	2.0	255	0.09	2.0	-	-	-	-	-	-	-	-	-
	M6330	0.8	225	0.09	2.0	160	0.08	2.0	-	-	-	-	-	-	-	-	-	-	-	-
	M8330	0.8	260	0.09	2.0	155	0.08	2.0	245	0.09	2.0	-	-	-	-	-	-	-	-	-
	M8340	0.8	240	0.09	2.0	140	0.08	2.0	225	0.09	2.0	-	-	-	-	-	-	-	-	-
M9340	0.8	320	0.09	2.0	190	0.08	2.0	-	-	-	-	-	-	-	-	-	-	-	-	-



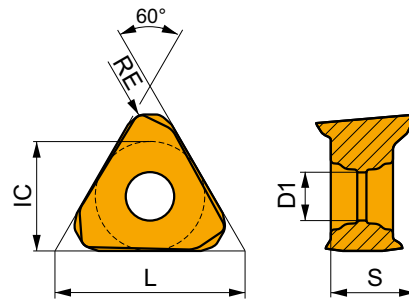
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H																						
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)																				
	0.4	0.10	31° 13°		M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.																																		
					<b>8215</b>	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	-	-	-	50	0.09	1.6	-	-	-																
					<b>M6330</b>	175	0.13	2.0	125	0.12	2.0	-	-	-	-	-	-	50	0.09	1.6	-	-	-																
					<b>M8330</b>	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	-	-	-	50	0.09	1.6	-	-	-																
					<b>M8340</b>	185	0.13	2.0	110	0.12	2.0	175	0.13	2.0	-	-	-	45	0.09	1.6	-	-	-																
					<b>M8345</b>	150	0.13	2.0	90	0.12	2.0	-	-	-	-	-	-	35	0.09	1.6	-	-	-																
<b>TNGX 100408SR-M</b>	0.4	0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-																			
																					<b>8215</b>	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-
																					<b>M6330</b>	210	0.13	2.0	150	0.12	2.0	-	-	-	-	-	-	60	0.09	1.6	-	-	-
																					<b>M8310</b>	270	0.13	2.0	135	0.12	2.0	255	0.13	2.0	-	-	-	-	-	-	-	-	-
																					<b>M8330</b>	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-
																					<b>M8340</b>	220	0.13	2.0	130	0.12	2.0	205	0.13	2.0	-	-	-	55	0.09	1.6	-	-	-
<b>TNGX 100412SR-M</b>	1.2	255	0.13	2.0	150	0.12	2.0	240	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-																				
																				<b>M8330</b>	255	0.13	2.0	150	0.12	2.0	240	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-	
<b>TNGX 100416SR-M</b>	1.6	300	0.13	2.0	150	0.12	2.0	285	0.13	2.0	-	-	-	-	-	-	-	-	-																				
																				<b>M8340</b>	230	0.13	2.0	135	0.12	2.0	215	0.13	2.0	-	-	-	55	0.09	1.6	-	-	-	
<b>TNGX 100416SR-M</b>	1.6	270	0.13	2.0	160	0.12	2.0	255	0.13	2.0	-	-	-	65	0.09	1.6	-	-	-																				
																				<b>M8330</b>	270	0.13	2.0	160	0.12	2.0	255	0.13	2.0	-	-	-	65	0.09	1.6	-	-	-	
																				<b>M8340</b>	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	-	-	-	60	0.09	1.6	-	-	-	


## TNGX 10-FA

PRAMET

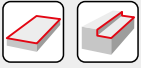
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1004	6.000	2.80	10.39	4.69



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

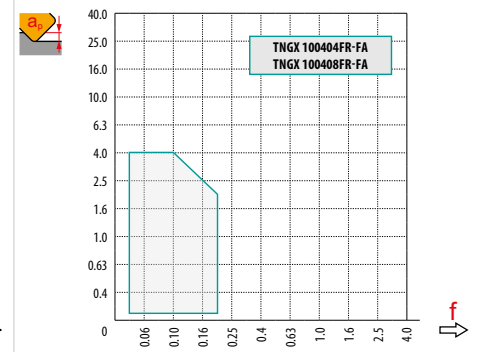
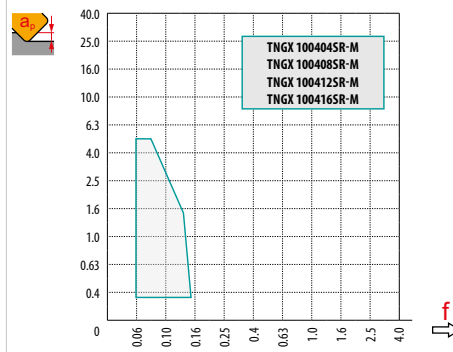
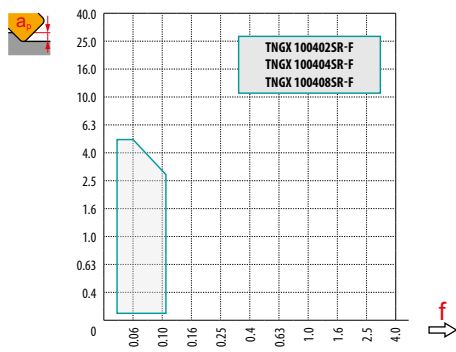
Produkt	RE (mm)	P			M			K			N			S			H				
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)		
	0.4	37°		FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.																	
				<b>HF7</b>	-	-	-	-	-	-	-	-	-	345	0.10	1.5	-	-	-	-	-
<b>TNGX 100408FR-FA</b>	0.8	345	0.10	1.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
																				<b>HF7</b>	-
<b>TNGX 100408FR-FA</b>	0.8	780	0.10	1.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
																				<b>M0315</b>	-
<b>TNGX 100408FR-FA</b>	0.8	780	0.10	1.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
																				<b>M0315</b>	-





$a_s$ DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 10-F	TNGX 10-M	TNGX 10-FA
	0.2	0.4	0.8
	1.53	1.34	0.92



		1.5
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	$a_s$	1.0	3.0	5.0
	$f$	0.10	0.08	0.04

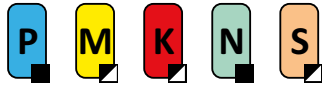
	$a_s$	0.2
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DC	RPMX	APMX/I
18	1.80	3.05/100
20	1.60	2.70/100
22	1.20	2.00/100
25	1.00	1.70/100
30	0.90	1.45/100
32	0.80	1.30/100
35	0.65	1.0/100
40	0.60	0.90/100
50	0.50	0.70/100
63	0.40	0.50/100
80	0.25	0.30/100

DC	DMIN	DMAX		
18	33	36	1.2	1.2
20	37	40	1.2	1.2
22	41	44	1.0	1.0
25	47	50	1.0	1.0
30	57	60	1.0	1.0
32	61	64	1.0	1.0
35	67	70	0.9	0.9
40	77	80	0.9	0.9
50	97	100	0.9	0.9
63	123	126	0.9	0.9
80	157	160	0.9	0.9

**NEW**

**STN16**



**PRAMET**

**S**

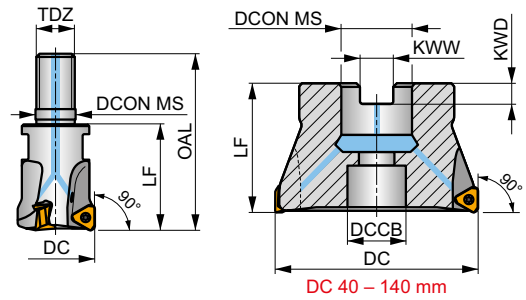
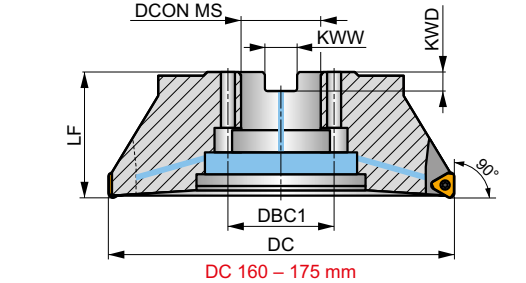
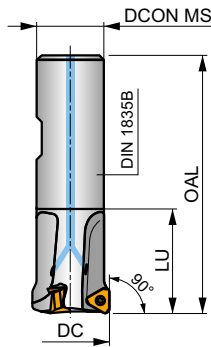
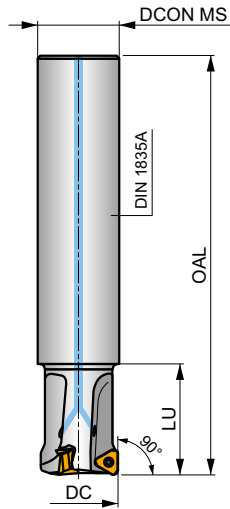
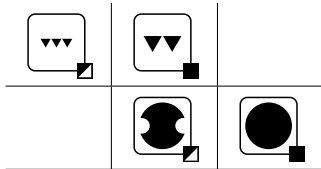
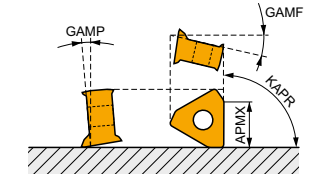


**ECON TN16 rohová fréza s vnútorným chladením**

90° stopkové a nástrčné frézy na obojstranné dosičky TNGX 16 so šiestimi reznými hranami a APMX 10 mm. Vhodné pre široký rozsah aplikácií. Dostupné v prevedení s valcovou a Weldon stopkou, modulárne a nástrčné (s nerovnomernou zubovou roztečou), s priemerom Ø 25 až Ø 175 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

**ECON TN**

KAPR	90°
APMX	10.0 mm



	0.03 – 0.15
	0.03 – 0.13



Produkt	DC	OAL	DCON MS	DCCB	DBC1	LU	LF	TDZ	KWW	KWD	GAMP	GAMP	max.			kg	G	C
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	min	max	min			
25A2R034A25-STN16-C	25	170	25	-	-	34	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.54	G1340 C0382
32A2R034A32-STN16-C	32	195	32	-	-	34	-	-	-	-	-16	-9.5	2	-	17500	✓	1.05	G1340 C0382
25A2R080A25-STN16-C	25	170	25	-	-	80	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.48	G1340 C0382
32A2R080A32-STN16-C	32	195	32	-	-	80	-	-	-	-	-16	-9.5	2	-	17500	✓	0.96	G1340 C0382
32A3R034A32-STN16-C	32	195	32	-	-	34	-	-	-	-	-16	-9.5	3	-	17500	✓	1.04	G1340 C0382
35A3R034A32-STN16-C	35	195	32	-	-	34	-	-	-	-	-16	-9.5	3	-	17000	✓	1.07	G1340 C0382
25A2R042B25-STN16-C	25	55	25	-	-	42	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.30	G1340 C0382
32A3R042B32-STN16-C	32	110	32	-	-	42	-	-	-	-	-16	-9.5	3	-	17500	✓	0.52	G1340 C0382
40A4R050B32-STN16-C	40	120	32	-	-	50	-	-	-	-	-16	-9.5	4	-	16000	✓	0.67	G1340 C0382
25A2R033M12-STN16-C	25	55	12.5	-	-	-	33	M12	-	-	-18.5	-9.5	2	-	20000	✓	0.08	G1340 C0382
32A2R043M16-STN16-C	32	66	17	-	-	-	43	M16	-	-	-16	-9.5	2	-	17500	✓	0.18	G1340 C0382
32A3R043M16-STN16-C	32	66	17	-	-	-	43	M16	-	-	-16	-9.5	3	-	17500	✓	0.17	G1340 C0382
40A3R043M16-STN16-C	40	66	17	-	-	-	43	M16	-	-	-16	-9.5	3	-	16000	✓	0.20	G1340 C0382
40A4R043M16-STN16-C	40	66	17	-	-	-	43	M16	-	-	-16	-9.5	4	-	16000	✓	0.21	G1340 C0382
40A03R-S90TN16-C	40	40	16	12.4	-	-	40	-	8.4	5.6	-16	-9.5	3	-	16000	✓	0.20	G1340 C0384
40A04R-S90TN16-C	40	40	16	12.4	-	-	40	-	8.4	5.6	-16	-9.5	4	-	16000	✓	0.20	G1340 C0384
50A04R-S90TN16-C	50	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	4	✓	14000	✓	0.34	G1340 C0386
50A05R-S90TN16-C	50	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	5	✓	14000	✓	0.32	G1340 C0386
63A04R-S90TN16-C	63	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	4	✓	12500	✓	0.47	G1340 C0386
63A06R-S90TN16-C	63	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	6	✓	12500	✓	0.48	G1340 C0386
80A05R-S90TN16-C	80	50	27	22.1	-	-	50	-	12.4	7	-16	-9.5	5	✓	11000	✓	1.02	G1340 C0388
80A07R-S90TN16-C	80	50	27	22.1	-	-	50	-	12.4	7	-16	-9.5	7	✓	11000	✓	1.05	G1340 C0388
100A06R-S90TN16-C	100	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	6	✓	10000	✓	1.79	G1340 C0390
100A08R-S90TN16-C	100	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	8	✓	10000	✓	1.66	G1340 C0390
115A06R-S90TN16-C	115	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	6	✓	9500	✓	2.04	G1340 C0390
125A07R-S90TN16-C	125	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	7	✓	9000	✓	3.05	G1340 C0390
125A09R-S90TN16-C	125	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	9	✓	9000	✓	3.14	G1340 C0390



Produkt	DC	OAL	DCONMS	DCCB	DBC1	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.		kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
140A08R-S90TN16-C	140	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	8	✓	8500	✓	3.69	GI340 C0390
160C10R-S90TN16-C	160	63	40	-	66.7	-	63	-	16.4	9.2	-16	-9.5	10	✓	8000	✓	5.16	GI340 C0394
175C10R-S90TN16-C	175	63	40	-	66.7	-	63	-	16.4	9.2	-16	-9.5	10	✓	7500	✓	5.99	GI340 C0394

	TNGX1606..
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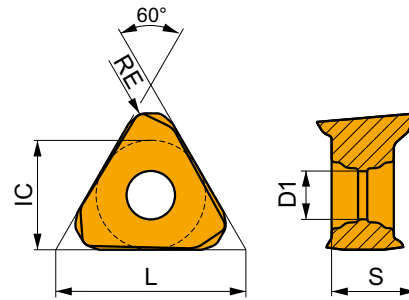
C0382	US 44010-T15P	3.5	M 4	10	-	-	Flag T15P	-	-	-
C0384	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 90835	-	-
C0386	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1030C	-	-
C0388	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1230C	-	-
C0390	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	-	-	-
C0394	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1240C	HSD 0825C	CAC 160C

**NEW**

## TNGX 16

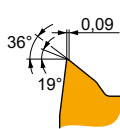
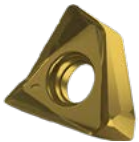
**PRAMET**

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.525	4.40	16.50	6.58



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



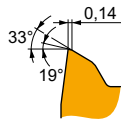
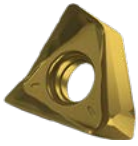
F geometria s veľmi pozitívnym prevedením pre ľahké obrábanie.

TNGX 160604SR-F	M8330	0.4	■ 205	0.10	3.0	■ 120	0.09	3.0	■ 190	0.10	3.0	-	-	-	-	-	-	-	-
	M8340	0.4	■ 190	0.10	3.0	■ 110	0.09	3.0	■ 180	0.10	3.0	-	-	-	-	-	-	-	-
TNGX 160608SR-F	8215	0.8	■ 250	0.10	3.0	■ 150	0.09	3.0	■ 235	0.10	3.0	-	-	-	-	-	-	-	-
	M6330	0.8	■ 215	0.10	3.0	■ 150	0.09	3.0	-	-	-	-	-	-	-	-	-	-	-
	M8310	0.8	■ 280	0.10	3.0	■ 140	0.09	3.0	■ 265	0.10	3.0	-	-	-	-	-	-	-	-
	M8330	0.8	■ 245	0.10	3.0	■ 145	0.09	3.0	■ 230	0.10	3.0	-	-	-	-	-	-	-	-
	M8340	0.8	■ 225	0.10	3.0	■ 135	0.09	3.0	■ 210	0.10	3.0	-	-	-	-	-	-	-	-



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

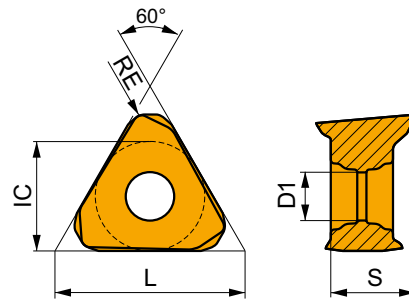
TNGX 160604SR-M	8215	0.4	190	0.15	3.0	110	0.14	3.0	180	0.15	3.0	-	-	-	45	0.11	2.4	-	-	-
	M6330	0.4	165	0.15	3.0	115	0.14	3.0	-	-	-	-	-	-	45	0.11	2.4	-	-	-
	M8310	0.4	205	0.15	3.0	100	0.14	3.0	190	0.15	3.0	-	-	-	-	-	-	-	-	-
	M8330	0.4	190	0.15	3.0	110	0.14	3.0	180	0.15	3.0	-	-	-	45	0.11	2.4	-	-	-
	M8340	0.4	170	0.15	3.0	100	0.14	3.0	160	0.15	3.0	-	-	-	40	0.11	2.4	-	-	-
TNGX 160608SR-M	8215	0.8	230	0.15	3.0	135	0.14	3.0	215	0.15	3.0	-	-	-	55	0.11	2.4	-	-	-
	M6330	0.8	195	0.15	3.0	135	0.14	3.0	-	-	-	-	-	55	0.11	2.4	-	-	-	
	M8310	0.8	245	0.15	3.0	120	0.14	3.0	230	0.15	3.0	-	-	-	-	-	-	-	-	
	M8330	0.8	225	0.15	3.0	135	0.14	3.0	210	0.15	3.0	-	-	-	55	0.11	2.4	-	-	-
	M8340	0.8	205	0.15	3.0	120	0.14	3.0	190	0.15	3.0	-	-	-	50	0.11	2.4	-	-	-
	M8345	0.8	160	0.15	3.0	95	0.14	3.0	-	-	-	-	-	40	0.11	2.4	-	-	-	
	M9325	0.8	285	0.15	3.0	-	-	-	270	0.15	3.0	-	-	-	-	-	-	-	-	-
M9340	0.8	260	0.15	3.0	155	0.14	3.0	-	-	-	-	-	65	0.11	2.4	-	-	-		
TNGX 160612SR-M	M8330	1.2	235	0.15	3.0	140	0.14	3.0	220	0.15	3.0	-	-	-	55	0.11	2.4	-	-	-
	M8340	1.2	215	0.15	3.0	125	0.14	3.0	200	0.15	3.0	-	-	-	50	0.11	2.4	-	-	-
TNGX 160616SR-M	M8310	1.6	275	0.15	3.0	140	0.14	3.0	260	0.15	3.0	-	-	-	-	-	-	-	-	-
	M8330	1.6	250	0.15	3.0	150	0.14	3.0	235	0.15	3.0	-	-	-	60	0.11	2.4	-	-	-
	M8340	1.6	225	0.15	3.0	135	0.14	3.0	210	0.15	3.0	-	-	-	55	0.11	2.4	-	-	-

**NEW**

## TNGX 16-FA

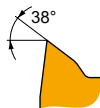
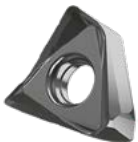
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



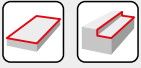
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



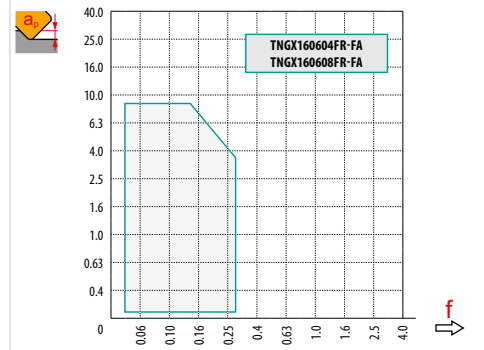
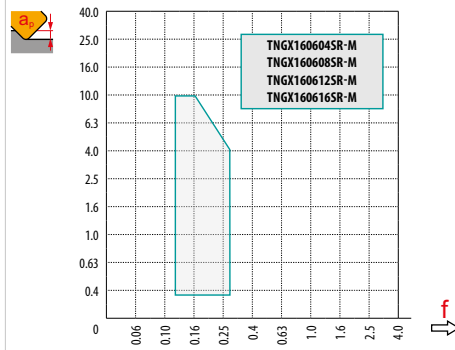
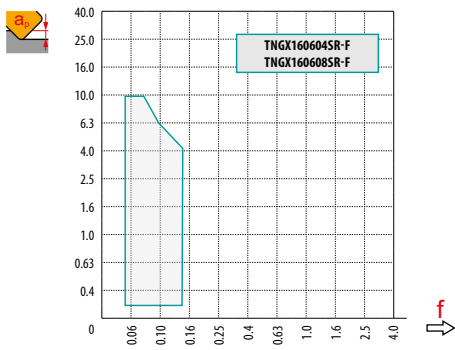
FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

TNGX 160604FR-FA	HF7	0.4	-	-	-	-	-	-	-	-	-	255	0.14	2.0	-	-	-	-	-	-
	M0315	0.4	-	-	-	-	-	-	-	-	-	585	0.14	2.0	-	-	-	-	-	-
TNGX 160608FR-FA	HF7	0.8	-	-	-	-	-	-	-	-	-	300	0.14	2.0	-	-	-	-	-	-
	M0315	0.8	-	-	-	-	-	-	-	-	-	690	0.14	2.0	-	-	-	-	-	-



$a_s$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 16-F	TNGX 16-M				TNGX 16-FA		
	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
	2.10	1.9	2.10	1.90	1.73	1.14	2.10	1.90

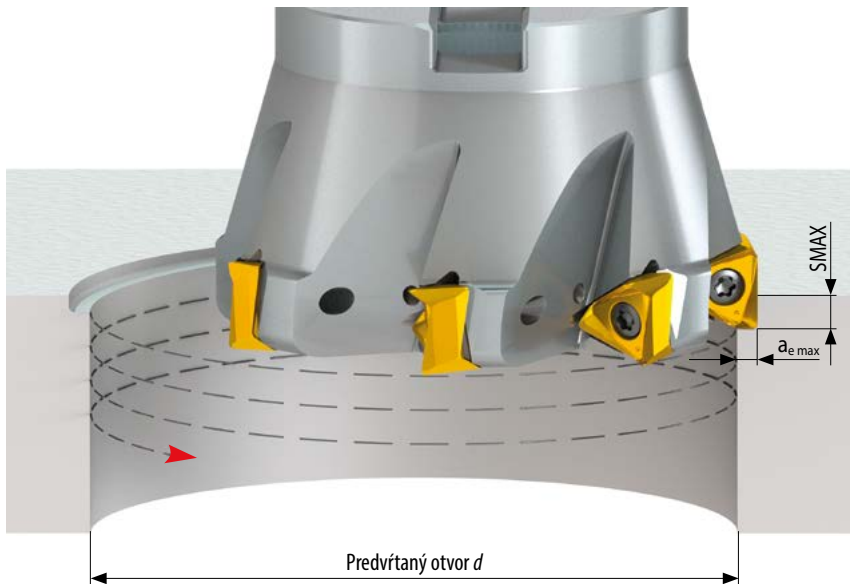


	<b>3.0</b>	<b>4.5</b>	<b>6.0</b>
	0.18	0.14	0.10



DC		$d_{min} = DC^*$			$d = 1.25 DC$			$d = 1.5 DC$			$d = 1.75 DC$			$d \geq 2 DC$	
		SMAX	$a_{e max}$		SMAX	$a_{e max}$		SMAX	$a_{e max}$		SMAX	$a_{e max}$		SMAX	$a_{e max}$
25	25	0.14	1.3	31	0.22	2.2	38	0.33	3.0	44	0.60	4.0	50	0.70	5.0
32	32	0.16	1.5	40	0.33	2.8	48	0.44	4.0	56	0.70	5.0	64	0.90	6.5
40	40	0.22	2.0	50	0.38	3.5	60	0.55	5.0	70	0.90	6.5	80	1.15	8.0
50	50	0.27	2.5	63	0.50	4.5	75	0.70	6.5	88	1.00	8.0	100	1.40	10.0
63	63	0.33	3.2	80	0.60	5.5	95	0.90	8.0	110	1.45	10.0	125	1.80	12.5
80	80	0.55	4.0	100	1.00	7.0	120	1.45	10.0	140	2.15	13.0	160	2.60	16.0
100	100	0.70	5.0	125	1.20	9.0	150	1.80	12.5	175	2.70	16.5	200	3.30	20.0
115	115	0.85	6.0	145	1.50	10.0	175	1.90	14.5	200	2.80	19.0	230	3.80	23.0
125	125	0.90	6.5	155	1.60	11.0	190	2.30	15.5	220	3.10	20.0	250	4.10	25.0
140	140	1.00	7.0	175	1.80	12.5	210	2.60	17.5	245	3.70	23.0	280	4.60	28.0
160	160	1.20	8.0	200	2.00	14.0	240	2.90	20.0	280	4.30	26.0	320	5.30	32.0
175	175	1.30	8.8	220	2.20	15.5	265	3.20	22.0	305	4.70	29.0	350	5.80	35.0

\* Skontrolujte zníženie rýchlosti posuvu, keď je priemer otvoru medzi  $d_{min}$  – 1.5 DC.





# SLN12



PRAMET

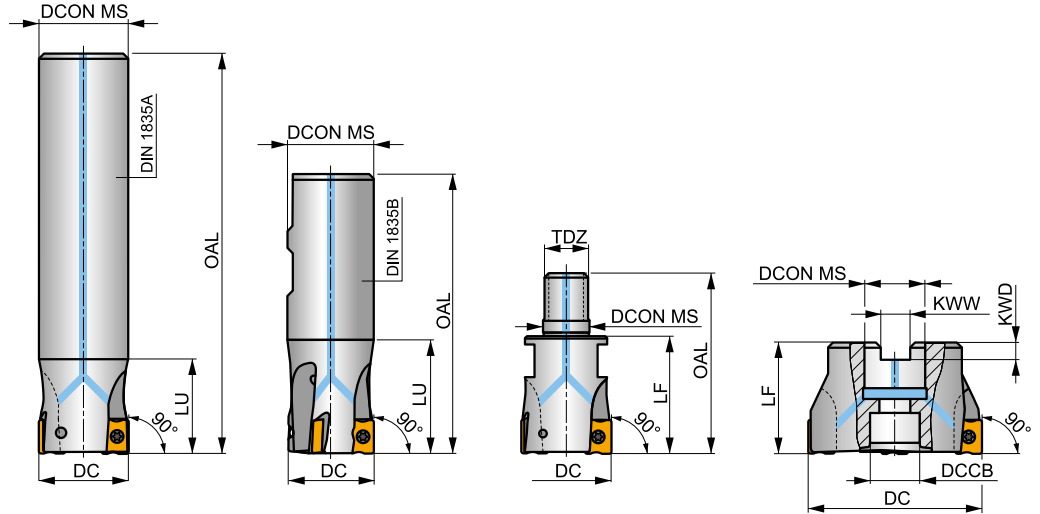
S



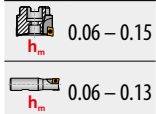
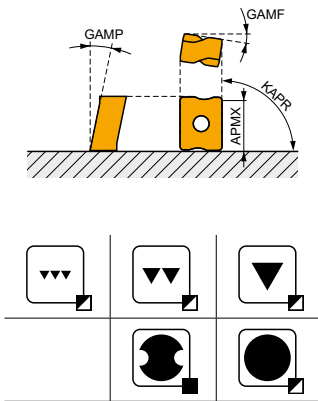
## ECON LN12 rohová fréza s vnútorným chladením

90° stopkové a nástrčné frézy na obojstranné dosičky LN.. 12 s APMX 9 mm. Vhodné pre široký rozsah aplikácií. Dostupné v prevedení s valcovou a Weldon stopkou, modulárne a nástrčné (s nerovnomernou zubovou roztečou), s priemerom Ø 25 až Ø 125 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

### ECON LN



KAPR	90°
APMX	9.0 mm



Produkt	DC	OAL	DCON MS	DCCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.	kg	ISO 6462 DIN 8030
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
25A2R034A25-SLN12-C	25	170	25	-	34	-	-	-	-	-23	-8	2	19500	GI205 SQ340 -
25A2R080A25-SLN12-C	25	170	25	-	80	-	-	-	-	-23	-8	2	19500	GI205 SQ340 -
32A2R034A32-SLN12-C	32	195	32	-	34	-	-	-	-	-15	-6	2	17300	GI205 SQ340 -
32A2R090A32-SLN12-C	32	195	32	-	90	-	-	-	-	-15	-6	2	17300	GI205 SQ340 -
25A2R042B25-SLN12-C	25	99	25	-	42	-	-	-	-	-23	-8	2	19500	GI205 SQ340 -
32A3R042B32-SLN12-C	32	103	32	-	42	-	-	-	-	-15	-6	3	17300	GI205 SQ340 -
40A4R050B32-SLN12-C	40	111	32	-	50	-	-	-	-	-15	-6	4	15500	GI205 SQ340 -
25A2R033M12-SLN12-C	25	55	12.5	-	-	33	-	-	-	-22	-6	2	-	GI205 SQ340 -
32A2R043M16-SLN12-C	32	66	17	-	-	43	-	-	-	-15	-6	2	-	GI205 SQ340 -
32A3R043M16-SLN12-C	32	66	17	-	-	43	-	-	-	-15	-6	3	-	GI205 SQ340 -
40A3R043M16-SLN12-C	40	66	17	-	-	43	-	-	-	-15	-6	3	-	GI205 SQ340 -
40A04R-S90LN12-C	40	-	16	14	-	40	-	8.4	5.6	-15	-6	4	15500	GI205 SQ342 -
50A04R-S90LN12-C	50	-	22	18	-	40	-	10.4	6.3	-14.5	-6	4	13800	GI205 SQ343 -
50A05R-S90LN12-C	50	-	22	18	-	40	-	10.4	6.3	-14.5	-6	5	13800	GI205 SQ343 -
63A04R-S90LN12-C	63	-	22	18	-	40	-	10.4	6.3	-14	-6	4	12300	GI205 SQ343 -
63A06R-S90LN12-C	63	-	22	18	-	40	-	10.4	6.3	-14	-6	6	12300	GI205 SQ343 -
80A05R-S90LN12-C	80	-	27	38	-	50	-	12.4	7	-14	-6	5	10900	GI205 SQ341 AC001
80A07R-S90LN12-C	80	-	27	38	-	50	-	12.4	7	-14	-6	7	10900	GI205 SQ341 AC001
100A06R-S90LN12-C	100	-	32	45	-	50	-	14.4	8	-14	-6	6	9800	GI205 SQ341 AC002
100A08R-S90LN12-C	100	-	32	45	-	50	-	14.4	8	-14	-6	8	9800	GI205 SQ341 AC002
110A06R-S90LN12-C	110	-	32	45	-	50	-	14.4	8	-14	-6	6	9300	GI205 SQ341 AC002
125A07R-S90LN12-C	125	-	40	56	-	63	-	16.4	9	-14	-6	7	8700	GI205 SQ341 AC003
125A09R-S90LN12-C	125	-	40	56	-	63	-	16.4	9	-14	-6	9	8700	GI205 SQ341 AC003



GI205

LNGX 1205..

LNGU 1205..



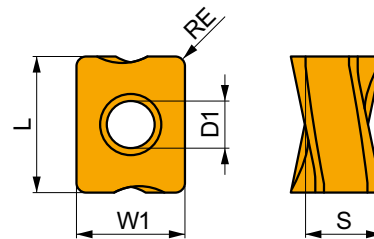
SQ340	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–
SQ342	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 0830C
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

## LNGX 12

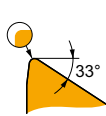
PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



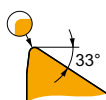
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometria s veľmi pozitívnym prevedením pre ľahké obrábanie.

LNGX 120504ER-F	<b>8215</b>	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
	<b>M8340</b>	0.4	180	0.15	1.5	–	–	–	170	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F	<b>8215</b>	0.8	240	0.15	1.5	–	–	–	225	0.15	1.5	–	–	–	–	–	–	–	–	–
	<b>M8310</b>	0.8	260	0.15	1.5	–	–	–	245	0.15	1.5	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	0.8	235	0.15	1.5	–	–	–	220	0.15	1.5	–	–	–	–	–	–	–	–	–
	<b>M8340</b>	0.8	215	0.15	1.5	–	–	–	200	0.15	1.5	–	–	–	–	–	–	–	–	–



M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

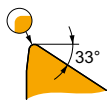
LNGX 120504ER-M	<b>M8330</b>	0.4	185	0.15	3.0	–	–	–	175	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M8340</b>	0.4	170	0.15	3.0	–	–	–	160	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M	<b>8215</b>	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M8310</b>	0.8	240	0.15	3.0	–	–	–	225	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M8330</b>	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M8340</b>	0.8	200	0.15	3.0	–	–	–	190	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M9315</b>	0.8	300	0.15	3.0	–	–	–	285	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M9325</b>	0.8	280	0.15	3.0	–	–	–	265	0.15	3.0	–	–	–	–	–	–	–	–	–
<b>M9340</b>	0.8	250	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120510ER-M	<b>M8330</b>	1.0	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–
	<b>M8340</b>	1.0	210	0.15	3.0	–	–	–	195	0.15	3.0	–	–	–	–	–	–	–	–	–





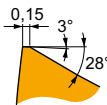
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



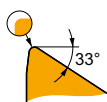
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

LNGX 120512ER-M	M8330	1.2	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–
	M8340	1.2	210	0.15	3.0	–	–	–	195	0.15	3.0	–	–	–	–	–	–	–
LNGX 120516ER-M	M8330	1.6	240	0.15	3.0	–	–	–	225	0.15	3.0	–	–	–	–	–	–	–
	M8340	1.6	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–
LNGX 120520ER-M	M8310	2.0	280	0.15	3.0	–	–	–	265	0.15	3.0	–	–	–	–	–	–	–
	M8330	2.0	255	0.15	3.0	–	–	–	240	0.15	3.0	–	–	–	–	–	–	–
	M8340	2.0	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–



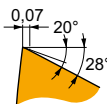
R geometria s pozitívnym prevedením pre nestabilné podmienky obrábania.

LNGX 120508SR-R	8215	0.8	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	
	M5315	0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	–	
	M8310	0.8	220	0.20	3.5	–	–	–	205	0.20	3.5	–	–	–	–	–	–	–	
	M8330	0.8	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	
	M8340	0.8	185	0.20	3.5	–	–	–	175	0.20	3.5	–	–	–	–	–	–	–	
	M9315	0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	–	–
	M9325	0.8	250	0.20	3.5	–	–	–	235	0.20	3.5	–	–	–	–	–	–	–	–
	M9340	0.8	225	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R	8215	1.6	225	0.20	3.5	–	–	–	210	0.20	3.5	–	–	–	–	–	–	–	
	M8330	1.6	225	0.20	3.5	–	–	–	210	0.20	3.5	–	–	–	–	–	–	–	
	M8340	1.6	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	
	M9325	1.6	275	0.20	3.5	–	–	–	260	0.20	3.5	–	–	–	–	–	–	–	



MF geometria s veľmi pozitívnym prevedením pre ľahké obrábanie.

LNGX 120504ER-MF	M6330	0.4	175	0.15	1.0	125	0.14	1.0	–	–	–	–	–	–	–	–	–	–
	M8340	0.4	190	0.15	1.0	110	0.14	1.0	–	–	–	–	–	–	–	–	–	–
	M9340	0.4	240	0.15	1.0	140	0.14	1.0	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF	M6330	0.8	210	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	225	0.15	1.0	135	0.14	1.0	–	–	–	–	–	–	–	–	–	–
	M9340	0.8	285	0.15	1.0	170	0.14	1.0	–	–	–	–	–	–	–	–	–	–



MM geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

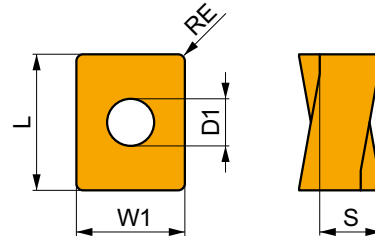
LNGX 120508SR-MM	M6330	0.8	190	0.15	2.8	135	0.14	2.8	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	200	0.15	2.8	120	0.14	2.8	–	–	–	–	–	–	–	–	–	–
	M8345	0.8	160	0.15	2.8	95	0.14	2.8	–	–	–	–	–	–	–	–	–	–
	M9340	0.8	255	0.15	2.8	150	0.14	2.8	–	–	–	–	–	–	–	–	–	–



## LNGU 12

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



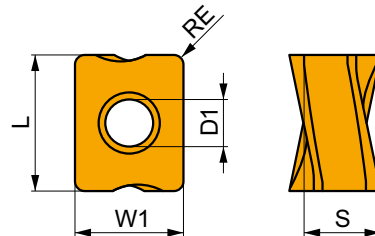
M geometria s pozitívnym prevedením pre stredné obrábanie.

LNGU 120525ER-M	M8330	2.5	255	0.15	3.0	—	—	—	240	0.15	3.0	—	—	—	—	—	—	—	—	—
	M8340	2.5	230	0.15	3.0	—	—	—	215	0.15	3.0	—	—	—	—	—	—	—	—	—
LNGU 120530ER-M	M8330	3.0	255	0.15	3.0	—	—	—	240	0.15	3.0	—	—	—	—	—	—	—	—	—
	M8340	3.0	230	0.15	3.0	—	—	—	215	0.15	3.0	—	—	—	—	—	—	—	—	—

## LNGX 12-FA

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



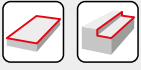
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

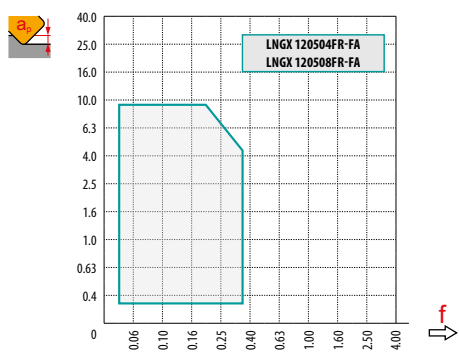
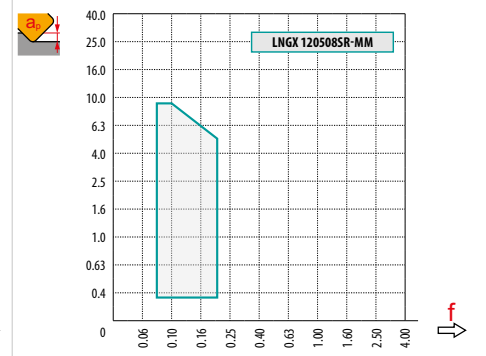
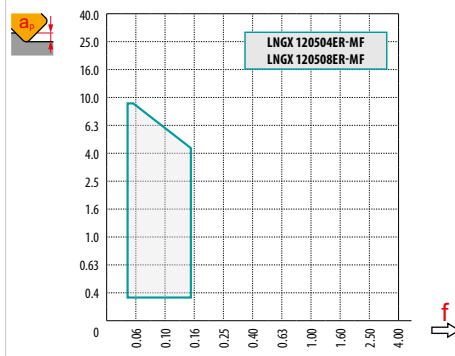
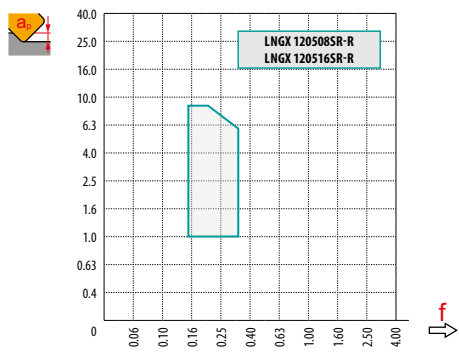
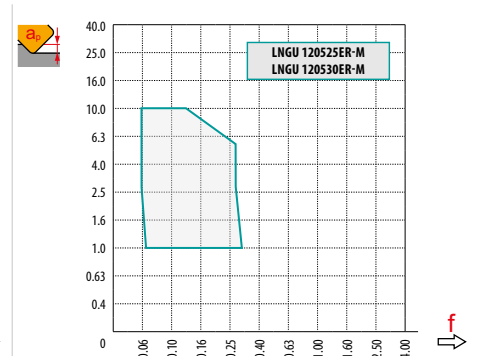
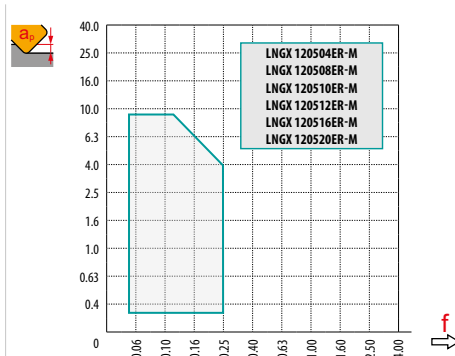
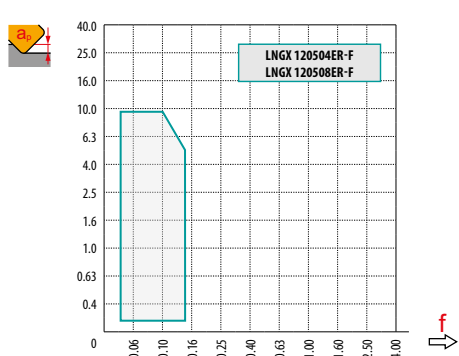
LNGX 120504FR-FA	HF7	0.4	—	—	—	—	—	—	270	0.30	2.0	—	—	—	—	—	—	—	—	—
LNGX 120508FR-FA	HF7	0.8	—	—	—	—	—	—	315	0.30	2.0	—	—	—	—	—	—	—	—	—
	M0315	0.8	—	—	—	—	—	—	720	0.30	2.0	—	—	—	—	—	—	—	—	—

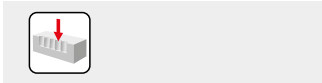


$a_s$ DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

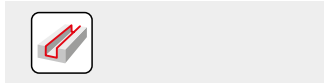
	LNGX 12-F		LNGX 12-M						LNGU 12-M	
	0.4	0.8	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0
	2.29	1.89	2.29	1.89	1.69	1.49	1.09	0.68	0.87	0.36

	LNGX 12-R		LNGX 12-MF		LNGX 12-MM	LNGX 12-FA	
	0.8	1.6	0.4	0.8	0.8	0.4	0.8
	1.88	1.08	2.28	1.88	1.88	2.30	1.89

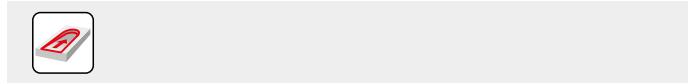




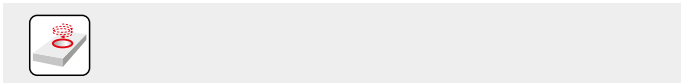
3.5



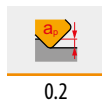
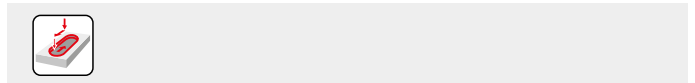
	<b>1.0</b>	<b>5.0</b>	<b>9.0</b>
	0.19	0.13	0.08



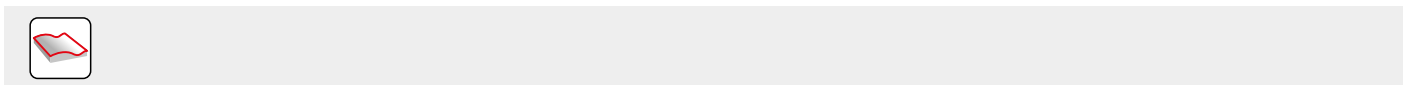
LNGX 12		
	RPMX	APMX/I
<b>25</b>	1.3	2.1/100
<b>32</b>	0.7	1.1/100
<b>40</b>	0.5	0.7/100
<b>50</b>	0.4	0.5/100
<b>63</b>	0.2	0.3/100
<b>80</b>	0.2	0.2/100



LNGX 12				
	DMIN	DMAX		
<b>25</b>	35.0	50.0	0.7	1.7
<b>32</b>	49.0	64.0	0.6	1.2
<b>40</b>	65.0	80.0	0.6	1.0
<b>50</b>	85.0	100.0	0.7	1.0
<b>63</b>	111.0	126.0	0.6	0.8
<b>80</b>	145.0	160.0	0.7	0.8



0.2

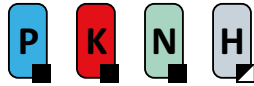


		3	5	10	15	20	30	40	50	60	80	100
<b>25</b>		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
<b>32</b>		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
<b>40</b>		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
<b>50</b>		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
<b>63</b>		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
<b>80</b>	0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657	

		3	5	10	15	20	30	40	50	60	80	100
<b>1.6</b>		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
<b>2.0</b>		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
<b>2.5</b>		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
<b>3.0</b>		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549



# SLN16



PRAMET

S

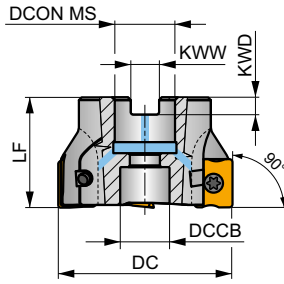
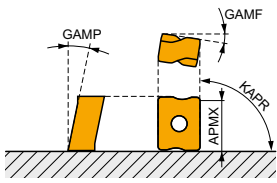


## ECON LN16 rohová fréza s vnútorným chladením

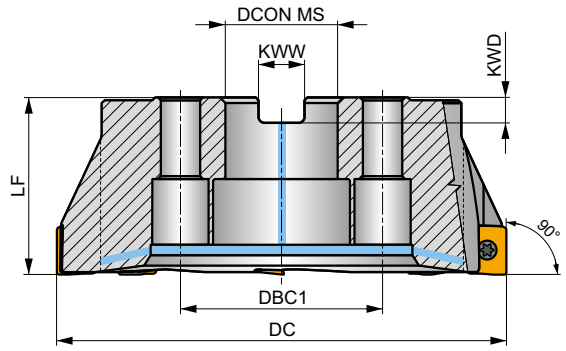
90° nástrčná fréza na obojstranné dosťičky LN.. 16 s APMX 13 mm. Vhodná pre široký rozsah aplikácií. Dostupná v nástrčnom prevedení s nerovnomernou zubovou roztečou, s priermi Ø 63 až Ø 175 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

## ECON LN

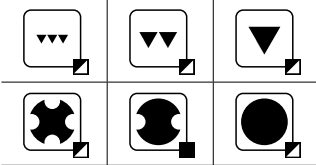
KAPR	90°
APMX	13.0 mm



DC 63 – 140 mm



DC 160 – 175 mm



0.08 – 0.2



Produkt	DC	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMF	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)									
63A04R-S90LN16-C	63	40	22	18	-	10.4	6.3	-10.5	-6	4	✓	7600	✓	0.46	G1207	SQ353	-	-
63A05R-S90LN16-C	63	40	22	18	-	10.4	6.3	-10.5	-6	5	✓	7600	✓	0.46	G1207	SQ353	-	-
80A04R-S90LN16-C	80	50	27	38	-	12.4	7	-10.5	-6	4	✓	6800	✓	0.98	G1207	SQ351	AC001	-
80A06R-S90LN16-C	80	50	27	38	-	12.4	7	-10.5	-6	6	✓	6800	✓	0.89	G1207	SQ351	AC001	-
100A05R-S90LN16-C	100	50	32	45	-	14.4	8	-10.5	-6	5	✓	6100	✓	0.98	G1207	SQ351	AC002	-
100A07R-S90LN16-C	100	50	32	45	-	14.4	8	-10.5	-6	7	✓	6100	✓	1.84	G1207	SQ351	AC002	-
125A06R-S90LN16-C	125	63	40	56	-	16.4	9	-10.5	-6	6	✓	5400	✓	3.44	G1207	SQ351	AC003	-
125A08R-S90LN16-C	125	63	40	56	-	16.4	9	-10.5	-6	8	✓	5400	✓	3.33	G1207	SQ351	AC003	-
140A06R-S90LN16-C	140	63	40	56	-	16.4	9	-10.5	-6	6	✓	5100	✓	3.91	G1207	SQ351	AC003	-
160C08R-S90LN16-C	160	63	40	-	66.7	16.4	9	-10.5	-6	8	✓	4700	✓	6.19	G1207	SQ356	-	-
175C08R-S90LN16-C	175	63	40	-	66.7	16.4	9	-10.5	-6	8	✓	4500	✓	7.11	G1207	SQ356	-	-



G1207



LNMU 1607..



LNGU 1607..

SQ351	US 45012-T20P	5.0	M 5	12	SDR T20P-T	-	-	-	-	-	-	-
SQ353	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1030C	-	-	-	-	-	-
SQ356	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5	-	-	-

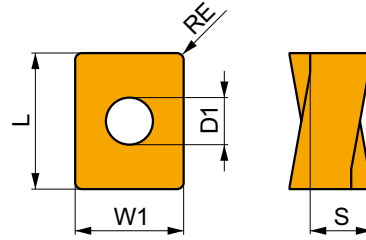


AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

# LNMU 16



	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1607	13.200	5.70	16.60	7.50



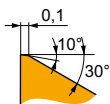
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



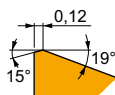
F geometria s veľmi pozitívnym prevedením pre ľahké obrábanie.

LNMU 160708ER-F	8215	0.8	■	235	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.8	■	230	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	■	210	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–



M geometria s pozitívnym prevedením pre stredné obrábanie.

LNMU 160708SR-M	8215	0.8	■	200	0.18	5.0	–	–	–	■	190	0.18	5.0	–	–	–	–	–	–
	M6330	0.8	■	170	0.18	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.8	■	200	0.18	5.0	–	–	–	■	190	0.18	5.0	–	–	–	–	–	–
	M8340	0.8	■	180	0.18	5.0	–	–	–	▣	170	0.18	5.0	–	–	–	–	–	–
	M9325	0.8	■	250	0.18	5.0	–	–	–	■	235	0.18	5.0	–	–	–	–	–	–
LNMU 160720SR-M	M8330	2.0	■	230	0.18	5.0	–	–	–	■	215	0.18	5.0	–	–	–	–	–	–
	M8340	2.0	■	210	0.18	5.0	–	–	–	▣	195	0.18	5.0	–	–	–	–	–	–
LNMU 160730SR-M	M8330	3.0	■	230	0.18	5.0	–	–	–	■	215	0.18	5.0	–	–	–	–	–	–
	M8340	3.0	■	210	0.18	5.0	–	–	–	▣	195	0.18	5.0	–	–	–	–	–	–
LNMU 160740SR-M	M8330	4.0	■	230	0.18	5.0	–	–	–	■	215	0.18	5.0	–	–	–	–	–	–
	M8340	4.0	■	210	0.18	5.0	–	–	–	▣	195	0.18	5.0	–	–	–	–	–	–



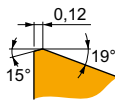
R geometria s pozitívnym stabilným prevedením pre stredné obrábanie.

LNMU 160708SR-R	M5315	0.8	▣	265	0.18	6.3	–	–	–	■	250	0.18	6.3	–	–	–	–	▣	50	0.15	1.0	
	M8310	0.8	■	215	0.18	6.3	–	–	–	■	200	0.18	6.3	–	–	–	–	▣	40	0.15	1.0	
	M8330	0.8	■	195	0.18	6.3	–	–	–	■	185	0.18	6.3	–	–	–	–	▣	35	0.15	1.0	
	M8340	0.8	■	175	0.18	6.3	–	–	–	▣	165	0.18	6.3	–	–	–	–	–	–	–	–	
	M9315	0.8	■	260	0.18	6.3	–	–	–	■	245	0.18	6.3	–	–	–	–	–	▣	50	0.15	1.0
	M9325	0.8	■	240	0.18	6.3	–	–	–	■	225	0.18	6.3	–	–	–	–	–	▣	45	0.15	1.0



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



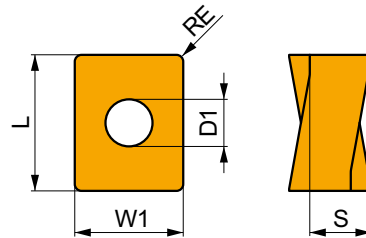
R geometria s pozitívnym stabilným prevedením pre stredné obrábanie.

LNMU 160716SR-R	M8330	1.6	215	0.18	6.3	–	–	–	200	0.18	6.3	–	–	–	–	–	–	–	40	0.15	1.0
	M8340	1.6	195	0.18	6.3	–	–	–	185	0.18	6.3	–	–	–	–	–	–	–	–	–	–
	M9315	1.6	285	0.18	6.3	–	–	–	270	0.18	6.3	–	–	–	–	–	–	–	55	0.15	1.0
	M9325	1.6	265	0.18	6.3	–	–	–	250	0.18	6.3	–	–	–	–	–	–	–	50	0.15	1.0

## LNGU 16

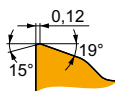
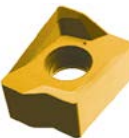


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometria s veľmi pozitívnym prevedením pre stredné obrábanie.

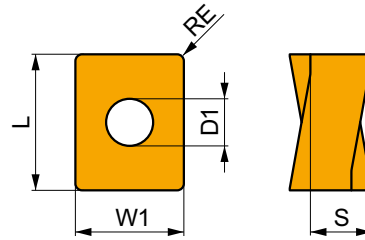
LNGU 160708SR-M	8215	0.8	200	0.18	5.0	–	–	–	190	0.18	5.0	–	–	–	–	–	–	–	40	0.15	1.0
	M8340	0.8	180	0.18	5.0	–	–	–	170	0.18	5.0	–	–	–	–	–	–	–	–	–	–
	M9315	0.8	265	0.18	5.0	–	–	–	250	0.18	5.0	–	–	–	–	–	–	–	50	0.15	1.0
	M9325	0.8	250	0.18	5.0	–	–	–	235	0.18	5.0	–	–	–	–	–	–	–	50	0.15	1.0



# LNGU 16-FA



	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1607	13.200	5.70	16.60	7.50



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometria s veľmi pozitívnym prevedením pre jemné dokončovacie až stredné obrábanie.

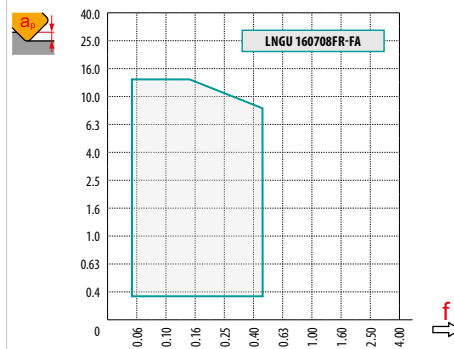
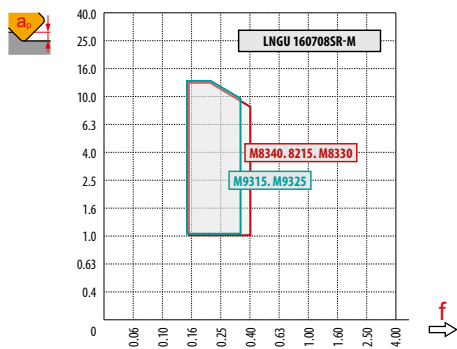
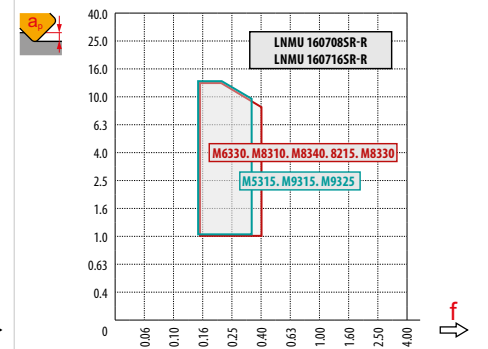
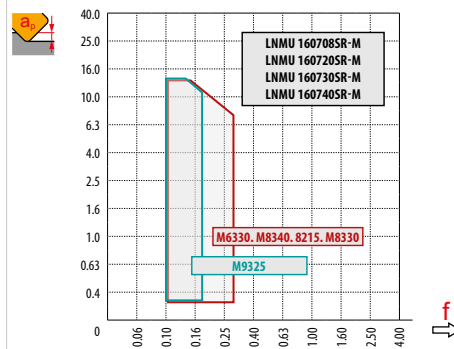
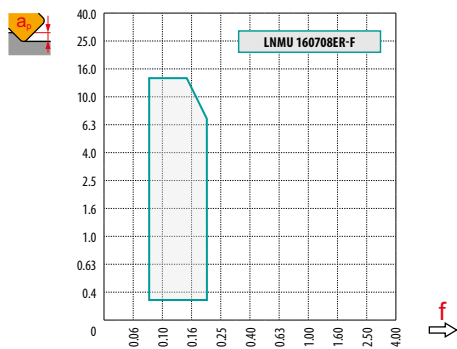
LNGU 160708FR-FA	HF7	0.8	-	-	-	-	-	-	-	300	0.30	3.0	-	-	-	-	-	-	-
------------------	-----	-----	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---





$a_s$ / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LNMU 16-F	LNMU 16-M					LNMU 16-R		LNGU 16-M	LNGU 16-FA
	0.8	0.8	2.0	3.0	4.0	0.8	1.6	0.8	0.8	
	3.30	3.30	2.11	1.12	0.10	3.30	2.50	3.24	3.30	



max.  
7.0



	1.0	6.0	13.0
	0.31	0.24	0.13



# SS0050



PRAMET

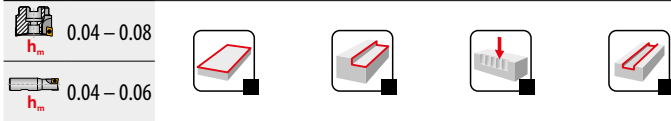
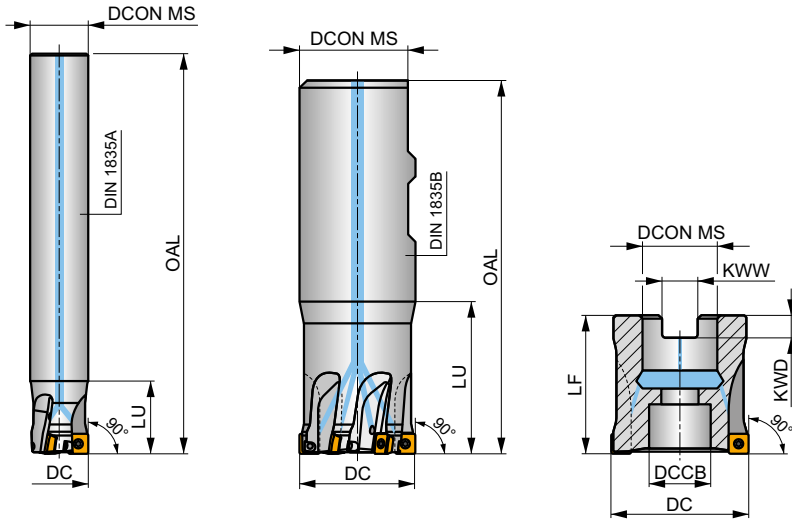
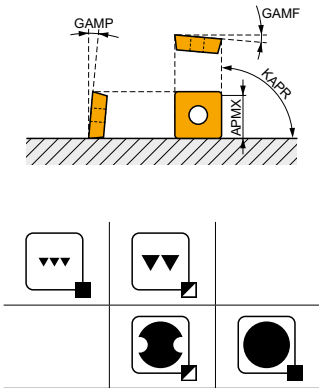
S



## 90° rohová fréza pre doštičky SOMT 05 s vnútorným chladením

90° stopkové a nástrčné frézy na pozitívne doštičky SOMT 05 s APMX 4.5 mm. Vhodné pre čelné, rohové, drážkovacie a odvrtavacie frézovanie. Dostupné v prevedení s valcovou alebo Weldon stopkou a nástrčné (s nerovnomernou zubovou roztečou), s priemerom Ø 12 až Ø 40 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	90°
APMX	4.5 mm



Produkt	DC	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMF	GAMP	max.	kg	ISO 6462	ISO 9030	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)					
12A2R018A10-SS0050-C	12	90	10	-	18	-	-	-	-8	8	2	58000	✓	0.05	GI327 SQ330
12A2R018A12-SS0050-C	12	90	12	-	18	-	-	-	-8	8	2	58000	✓	0.07	GI327 SQ330
16A3R020A14-SS0050-C	16	110	14	-	20	-	-	-	-5	8	3	50300	✓	0.12	GI327 SQ330
16A3R020A16-SS0050-C	16	110	16	-	20	-	-	-	-5	8	3	50300	✓	0.15	GI327 SQ330
20A4R020A18-SS0050-C	20	125	18	-	20	-	-	-	-5	8	4	45000	✓	0.21	GI327 SQ330
20A4R020A20-SS0050-C	20	125	20	-	20	-	-	-	-5	8	4	45000	✓	0.26	GI327 SQ330
25A5R024A25-SS0050-C	25	140	25	-	24	-	-	-	-5	8	5	40200	✓	0.48	GI327 SQ330
20A4R032B20-SS0050-C	20	83	20	-	32	-	-	-	-5	8	4	45000	✓	0.16	GI327 SQ330
25A5R042B25-SS0050-C	25	99	25	-	42	-	-	-	-5	8	5	40200	✓	0.31	GI327 SQ330
32A6R042B32-SS0050-C	32	103	32	-	42	-	-	-	-4.5	8	6	35500	✓	0.54	GI327 SQ330
32A06R-S90S0050-C	32	-	16	12.4	-	32	8.4	5.6	-4.5	8	6	35500	✓	0.10	GI327 SQ332
40A08R-S90S0050-C	40	-	22	18.1	-	40	10.4	6.3	-4	8	8	31800	✓	0.19	GI327 SQ333

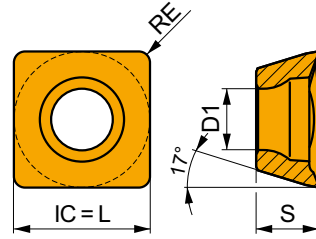


US	Nm	M	Flag	D-T	FG	HS
SQ330	US 62204-T07P	0.8	M 2.2	4.1	Flag T07P	-
SQ332	US 62204-T07P	0.8	M 2.2	4.1	-	D-T07P/T09P
SQ333	US 62204-T07P	0.8	M 2.2	4.1	-	D-T07P/T09P



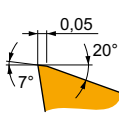
# SOMT 05

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0502	5.570	2.50	5.57	2.63



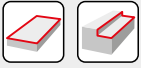
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



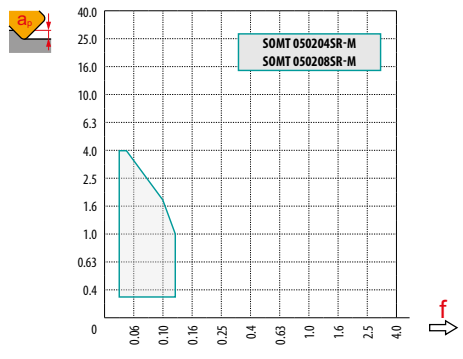
M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

SOMT 050204SR-M	M6330	0.4	■	255	0.05	2.5	■	180	0.05	2.5	■	–	–	–	■	75	0.04	2.0	■	–	–	–
	M8330	0.4	■	290	0.05	2.5	■	170	0.05	2.5	■	275	0.05	2.5	■	70	0.04	2.0	■	–	–	–
	M8340	0.4	■	260	0.05	2.5	■	155	0.05	2.5	■	245	0.05	2.5	■	65	0.04	2.0	■	–	–	–
SOMT 050208SR-M	M6330	0.8	■	300	0.05	2.5	■	210	0.05	2.5	■	–	–	–	■	85	0.04	2.0	■	–	–	–
	M8330	0.8	■	350	0.05	2.5	■	210	0.05	2.5	■	330	0.05	2.5	■	85	0.04	2.0	■	–	–	–
	M8340	0.8	■	310	0.05	2.5	■	185	0.05	2.5	■	290	0.05	2.5	■	75	0.04	2.0	■	–	–	–



$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

RE	SOMT 05-M	
BS	0.4	0.8
BS	-	-



max
1.5

$a_e$	1.0	2.0	4.0
f	0.12	0.08	0.03



SS009



PRAMET

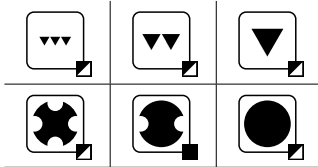
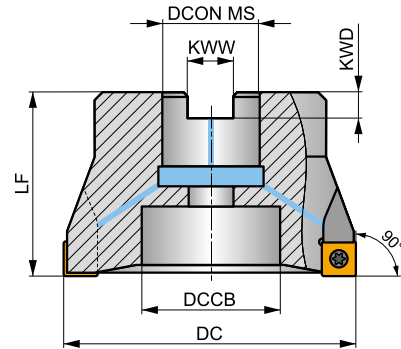
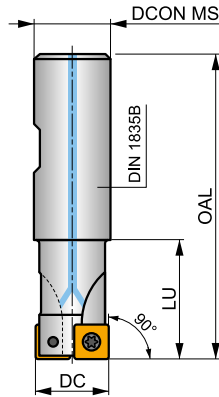
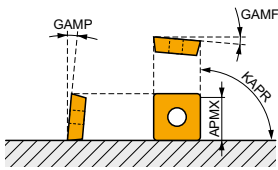
S



**90° rohová fréza pre doštičky SOMT 09 s vnútorným chladením**

90° stopkové a nástrčné frézy na pozitívne doštičky SOMT 09 s APMX 8 mm. Vhodné pre čelné, rohové, drážkovacie a odvrtávacie frézovanie. Dostupné v prevedení s Weldon stopkou a nástrčné (s nerovnomernou zubovou roztečou), s priemerom Ø 20 až Ø 125 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	90°
APMX	8.0 mm



$h_m$  0.07 – 0.22

$h_m$  0.07 – 0.18



Produkt	DC	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMF	GAMP										
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)										
20A2R032B20-SS009-C	20	82	20	-	32	-	-	-	-12	6	2	-	23800	✓	0.21	GI146	SQ400	-		
25A3R042B25-SS009-C	25	98	25	-	42	-	-	-	-12	6	3	-	21300	✓	0.31	GI146	SQ400	-		
32A4R042B32-SS009-C	32	102	32	-	42	-	-	-	-10	10	4	✓	18800	✓	0.55	GI146	SQ400	-		
40A05R-S90S009-C	40	-	16	14	-	40	8.4	5.6	-9.1	10	5	-	16800	✓	0.29	GI146	SQ402	-		
50A06R-S90S009-C	50	-	22	18	-	40	10.4	6.4	-8.8	10	6	-	15100	✓	0.33	GI146	SQ403	-		
63A07R-S90S009-C	63	-	22	18	-	40	10.4	6.4	-8.6	10	7	-	13400	✓	0.86	GI146	SQ403	-		
80A09R-S90S009-C	80	-	27	38	-	50	12.4	7	-8.1	10	9	-	11900	✓	1.03	GI146	SQ401	AC001		
100A10R-S90S009-C	100	-	32	45	-	50	14.4	8	-8.1	10	10	-	10700	✓	1.79	GI146	SQ401	AC002		
125A12R-S90S009-C	125	-	40	56	-	63	16.4	9	-8.1	10	12	-	9500	✓	3.62	GI146	SQ401	AC003		



GI146



SOMT 09T3..

SQ400	US 3006-T09P	2.0	M 3	6	-	-	Flag T09P	-
SQ401	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	-
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 1030C



AC001



KS 1230



K.FMH27

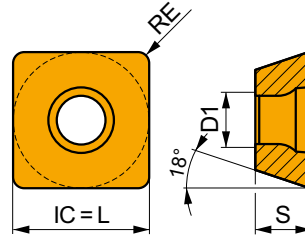


AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

## SOMT 09

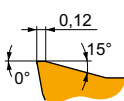
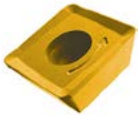


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.550	3.50	9.55	3.97



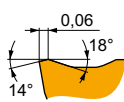
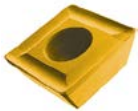
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Podmienky platia pre uhol nastavenia 90°. Ďalšie možnosti výpočtov sú v našej app Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



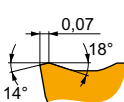
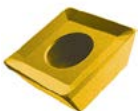
M geometria s pozitívnym prevedením pre stredné obrábanie.

SOMT 09T308-M	8215	0.8	275	0.14	2.5	165	0.13	2.5	260	0.14	2.5	—	—	—	65	0.13	2.0	—	—	—
	M5315	0.8	390	0.14	2.5	—	—	—	370	0.14	2.5	—	—	—	—	—	—	—	—	—
	M8330	0.8	270	0.14	2.5	160	0.13	2.5	255	0.14	2.5	—	—	—	65	0.13	2.0	—	—	—
	M8340	0.8	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	—	—	—	60	0.13	2.0	—	—	—
	M9315	0.8	380	0.14	2.5	—	—	—	360	0.14	2.5	—	—	—	—	—	—	—	—	—



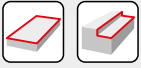
MI geometria so stabilným pozitívnym prevedením pre stredné obrábanie.

SOMT 09T304-MI	8215	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	—	—	—	55	0.10	2.0	—	—	—
	M8310	0.4	255	0.14	2.5	130	0.13	2.5	240	0.14	2.5	—	—	—	—	—	—	—	—	—
	M8330	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	—	—	—	55	0.10	2.0	—	—	—
	M8340	0.4	210	0.14	2.5	125	0.13	2.5	195	0.14	2.5	—	—	—	50	0.10	2.0	—	—	—
	M9315	0.4	320	0.14	2.5	—	—	—	300	0.14	2.5	—	—	—	—	—	—	—	—	—
M9340	0.4	265	0.14	2.5	155	0.13	2.5	—	—	—	—	—	—	65	0.10	2.0	—	—	—	



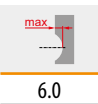
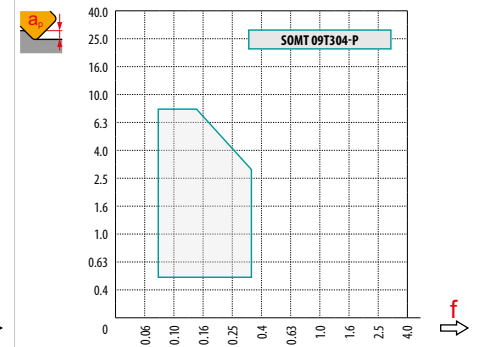
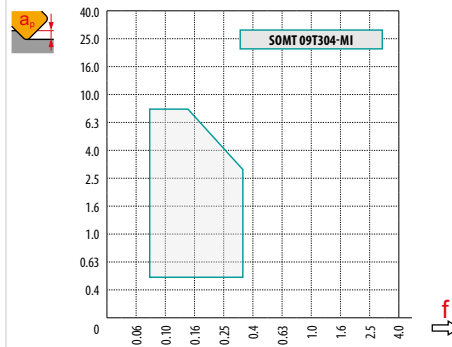
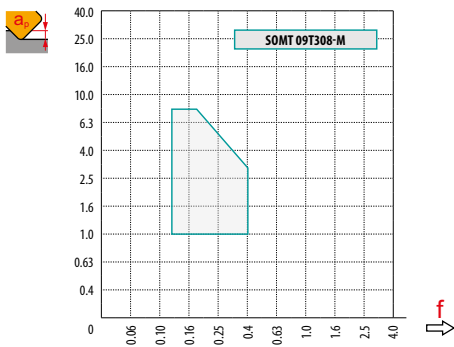
P geometria s veľmi pozitívnym prevedením pre stredné obrábanie.

SOMT 09T304-P	M8330	0.4	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	—	—	—	60	0.10	2.0	—	—	—
	M8340	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	—	—	—	55	0.10	2.0	—	—	—
	M9325	0.4	320	0.14	2.5	—	—	—	300	0.14	2.5	—	—	—	—	—	—	—	—	—



$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

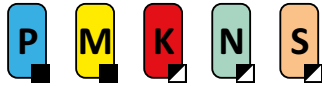
	SOMT 09-M	SOMT 09-MI	SOMT 09-P
	0.8	0.4	0.4
	0.90	1.30	1.30



	1.0	4.0	8.0
	0.28	0.19	0.09



# SSD12



PRAMET

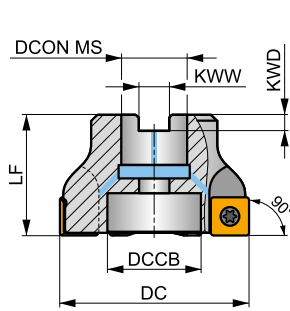
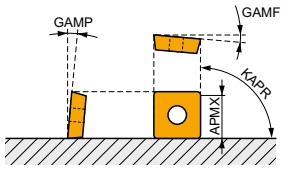
S



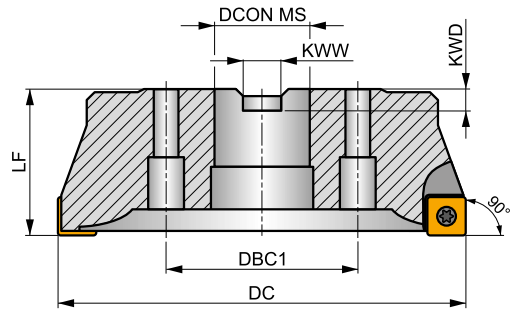
## 90° rohová fréza pre doštičky SDMT 12 s vnútorným chladením

90° nástrčná fréza na pozitívne doštičky SDMT 12 s APMX 10 mm. Vhodná pre čelné, rohové, drážkovacie a odvrtavacie frézovanie. Dostupná iba v nástrčnom prevedení s priermerní Ø 50 až 160 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

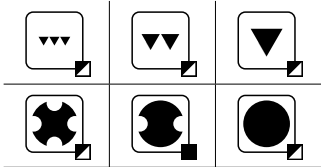
KAPR	90°
APMX	10.0 mm



DC 50 - 125 mm



DC 160 mm



0.09 - 0.25



Produkt	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)									
50A05R-S90SD12-C	50	40	22	18	-	10.4	6.3	-5	8	5	-	13000	✓	0.34	GI057	SQ413	-	
63A06R-S90SD12-C	63	40	22	18	-	10.4	6.3	-5	8	6	-	11600	✓	0.53	GI057	SQ413	-	
80A06R-S90SD12-C	80	50	27	38	-	12.4	7	-5	8	6	-	10300	✓	0.92	GI057	SQ411	AC001	
100A08R-S90SD12-C	100	50	32	45	-	14.4	8	-5	8	8	-	9200	✓	1.69	GI057	SQ411	AC002	
125A09R-S90SD12-C	125	63	40	56	-	16.4	9	-5	8	9	-	8300	✓	3.29	GI057	SQ411	AC003	
160C12R-S90SD12	160	63	40	-	66.7	16.4	9	-5	8	12	-	7300	-	5.74	GI057	SQ411	-	

GI057																			SDMT 1205..

SQ411	SSN 100312	MS 3510	HXK 3,5	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	-								
SQ413	-	-	-	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	HS 1030C								

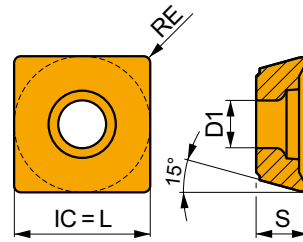
AC001		KS 1230								K.FMH27
AC002		KS 1635								K.FMH32
AC003		KS 2040								K.FMH40





# SDMT 12

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	12.700	4.40	12.70	5.00



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

F geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

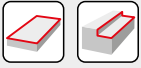
<b>SDMT 120508SR-F</b>	<b>M8330</b>	0.8	■	275	0.10	3.0	☑	165	0.09	3.0	☑	260	0.10	3.0	☑	825	0.12	3.0	☑	65	0.08	2.4	–	–	–
	<b>M8340</b>	0.8	■	250	0.10	3.0	☑	150	0.09	3.0	☑	235	0.10	3.0	☑	–	–	–	☑	60	0.08	2.4	–	–	–

M geometria s pozitívnym prevedením pre ľahké až stredné obrábanie.

<b>SDMT 120508SR-M</b>	<b>8215</b>	0.8	■	245	0.16	3.5	☑	145	0.14	3.5	☑	230	0.16	3.5	–	–	–	☑	60	0.11	2.8	–	–	–
	<b>M8330</b>	0.8	■	240	0.16	3.5	■	140	0.14	3.5	☑	225	0.16	3.5	–	–	–	☑	60	0.11	2.8	–	–	–
	<b>M8340</b>	0.8	■	220	0.16	3.5	■	130	0.14	3.5	☑	205	0.16	3.5	–	–	–	☑	55	0.11	2.8	–	–	–
	<b>M9325</b>	0.8	■	305	0.16	3.5	–	–	–	–	–	☑	285	0.16	3.5	–	–	–	–	–	–	–	–	–

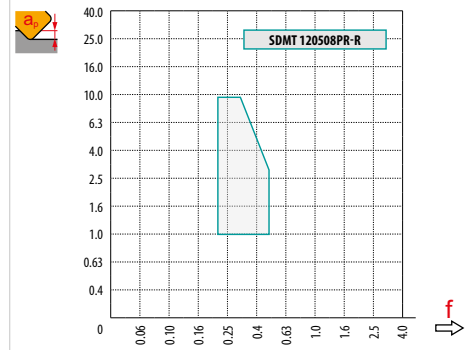
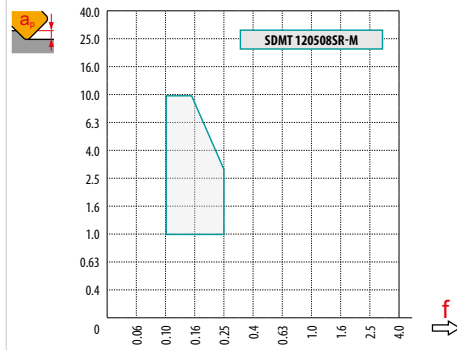
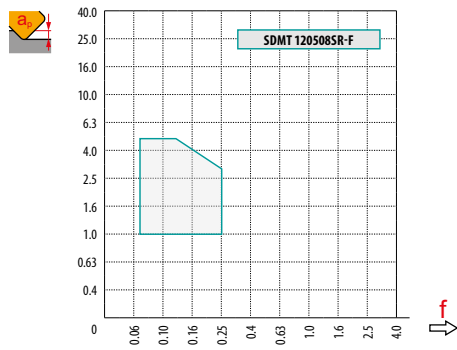
R geometria so stabilným pozitívnym prevedením pre stredné obrábanie.

<b>SDMT 120508PR-R</b>	<b>M8330</b>	0.8	■	220	0.25	3.5	☑	130	0.23	3.5	■	205	0.25	3.5	–	–	–	☑	55	0.23	2.8	–	–	–
	<b>M8340</b>	0.8	■	195	0.25	3.5	☑	115	0.23	3.5	☑	185	0.25	3.5	–	–	–	☑	45	0.23	2.8	–	–	–
	<b>M9315</b>	0.8	■	280	0.25	3.5	–	–	–	–	–	☑	265	0.25	3.5	–	–	–	–	–	–	–	–	–
	<b>M9325</b>	0.8	■	265	0.25	3.5	–	–	–	–	–	☑	250	0.25	3.5	–	–	–	–	–	–	–	–	–



$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SDMT 12-F	SDMT 12-M	SDMT 12-R
	0.8	0.8	0.8
	-	-	-

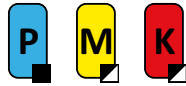


	8.0

	1.0	5.0	10.0
	0.39	0.25	0.14



# FTB27X



PRAMET

F

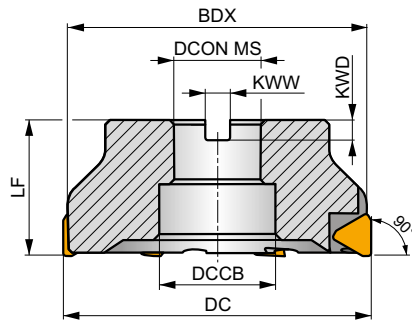
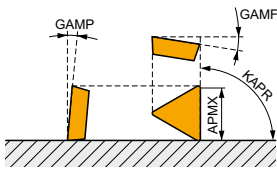


## ROUGH TB rohová fréza na doštičky TBMR 27 pre ťažké frézovanie

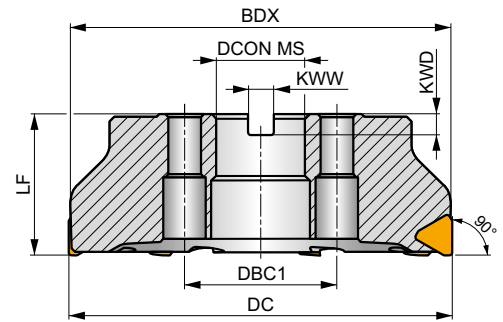
90° nástrčná fréza na pozitívne doštičky TBMR 27 s APMX 18 mm. Vhodná pre ťažké čelné, rohové a drážkovacie frézovanie. Dostupná iba v nástrčnom prevedení s priermi Ø 140 až Ø 260 mm, s nerovnomernou zubovou roztečou. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

## ROUGH TB

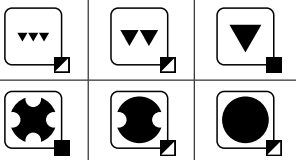
KAPR	90°
APMX	18.0 mm



DC 140 mm



DC 175 - 260 mm



$h_m$  0.15 - 0.38



Produkt	DC	BDX	LF	D CON MS	DCCB	DBC1	KWW	KWD	GAMF	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
140B07R-F90TB27X	140	135.7	63	40	56	-	16.4	9	-9	9	7	✓	-	-	4.75	GI163	SQ421	AC003
175C08R-F90TB27X	175	169.6	63	40	-	66.7	16.4	16.4	-9	9	8	✓	-	-	7.59	GI163	SQ424	-
210C10R-F90TB27X	210	204.1	63	60	-	101.6	25.7	25.7	-9	9	10	✓	-	-	10.80	GI163	SQ425	-
260C12R-F90TB27X	260	253.4	63	60	-	101.6	25.7	25.7	-9	9	12	✓	-	-	18.21	GI163	SQ425	-



GI163



TBMR 2707PZ..



SQ421



LNK 220616



US 6013-T20P



SDR T20P-T



KU TBMR 2707



DS 01Z



KL 04



HS 1240



AC003



KS 2040

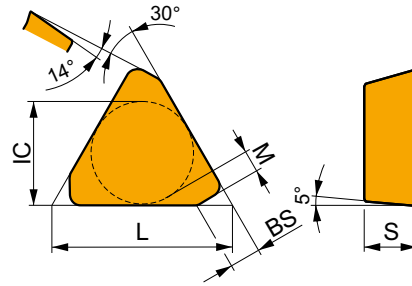


K.FMH40



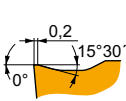
# TBMR 27

	BS	IC	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
2707	4.61	15.875	27.50	3	7.94



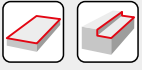
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



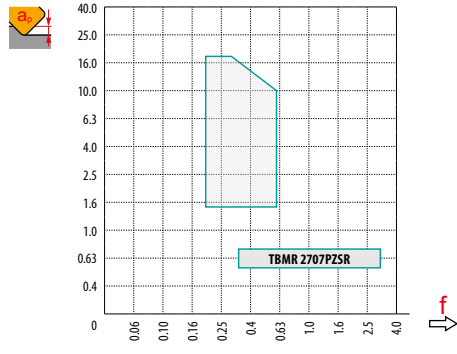
Zosilnená geometria pre ťažké obrábanie.

TBMR 2707PZSR	M8326	-	130	0.20	11.0	-	-	-	120	0.20	11.0	-	-	-	-	-	-	-
	M8346	-	110	0.20	11.0	65	0.20	11.0	-	-	-	-	-	-	-	-	-	-



$a_s$ DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	<b>TBMR 27</b>
	-
	2.70



	<b>1.5</b>	<b>8.0</b>	<b>18.0</b>
	0.60	0.39	0.24



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